

Technical Data Sheet

Date of issue	Revision date	Version
30/01/06	21/11/08	5c
Product code	Product name	
DC-	Diamond Clear™	

Before you begin.

Read instructions thoroughly. These products are for professional use only and not recommended for use by the unskilled or novice painter.

This data sheet has been prepared to inform our customers about the products properties. Since we cannot control the application or preparation, the user should make tests to check the suitability of the product. This data sheet cancels and replaces earlier editions.

Surface preparation must be properly carried out prior to painting; DNA® cannot accept any responsibility for existing primer, old paint, or other variables. Always use a spray painting booth, a quality compressor, breathing apparatus, suitable spray painting equipment and wear the correct protective clothing. DNA® does not recommend painting in cold temperatures (below 21° C) or mixing and using incompatible products, possibly from other manufacturers, which may cause problems.

The Data on this sheet is given in good faith and intended to be a general guide only. DNA® offers no warranties of whatever nature express or implied as to merchantability or fitness for a particular use. DNA® shall not accept liability for any specific or consequential damage as a result of using these products unless otherwise agreed to in writing. DNA® shall only replace the defective product, or, at its sole discretion refund the purchase price. DNA® shall not accept liability as a result of any failure of the applicator, lack of preparation or use of other materials.

Always spray out a test panel, noting the exact product ratios, application method and techniques employed. Only proceed to the job when you are satisfied that the color and finish are correct and in the identical manner as previously tested.



1. Description:

Diamond Clear™ incorporates the latest developments in Modified Polyurethane Clear Coatings. This high solid (over 50%) clear is suitable with all OEM base coat systems. It has superb flow characteristics, excellent depth of image, is easy to apply and has an exceptionally high gloss level of 94-96% gloss meter at 60”.

Manufactured using the finest ingredients available Diamond Clear™ provides you with an ‘OEM’ quality product with high chemical and weather resistance and UV stability tested to meet the 5 years Allunga exposure rating.

Rigorously tested to the OEM automotive standards in relation to UV, adhesion, flex, mar, chip & chemical resistance with all tests carried out by an independent testing laboratory, you can use Diamond Clear™ with complete confidence. Produced under strict guidelines to ensure the highest production standards are maintained, to allow you to produce the perfect finish on every job.

Diamond Clear™ has excellent flow and blend-in promotion properties, is easy to apply and has great leveling to ensure a smooth finish which reduces your polishing and final finishing times. Diamond Clear™ is available with your choice of ‘FX’ Hardener™ in **HFXF** (Fast), **HFXM** (Medium), or **HFXS** (Slow) and ‘FX’ Reducers™ (thinners) **RFXF** (Fast) **RFXM** (Medium), **RFXS** (Slow) or **RFXHF** (High Flow) all of which are available separately.

Diamond Clear™ is packaged in convenient 0.875 litre, 1.75 litre or commercial 7 litre ready to spray kit form. Diamond Clear™ can be used for spot, panel or overall repairs just follow our simple and easy to follow step-by-step instructions.

DNA® 5-7 Keith Campbell Court Scoresby Vic 3179 Australia Tel: 1300 791 667 or 03 9764 2088

website: www.dna-paints.com

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Properties	0	1	2	3	4	5	6	7	8	9	10
Solids by weight											
Ease of application											
Flexibility											
Gloss @ 60" is 94-96%											
Chemical Resistance											

0 = no effect and 10 = maximum


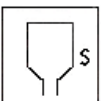
2. Product Data

Theoretical coverage :	10 – 12 sq m per 1 litre
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3. Substrates & Preparation:

 	Surface must be chemically clean and dry. Formulated for use over previously base coated substrates & properly prepared and cleaned OEM paintwork, with the exception of thermoplastic acrylic lacquer and air dry enamel finishes.
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4. Application:

<p>A. <u>Mixing Ratio/Reducing</u></p> 	<p>2:1 (2 parts clear and 1 part hardener) plus 10% to 20% Reducer.</p> <p>'FX' Hardener™ performs well with 'FX' Reducer™ and will air dry overnight at moderate temperatures. For further details refer to the 'FX' Reducer™ Technical Data Sheet.</p>
<p>B. <u>Spraying Viscosity:</u></p> 	<p>Ford 4 cup : 16-18 sec @ 20° C</p>

C. Application**QUICK APPLICATION GUIDE:**

1. Prepare your surface.
2. Spray one to two medium coats or until desired coverage has been achieved.
3. Allow 10 minutes to flash off between coats.
4. Bake for 45 - 60 mins @ 50° C.
5. Lightly polish if required.

DETAILED APPLICATION GUIDE:

- Thoroughly clean the surface with soap and water.
- Degrease fully with DNA® Wax & Grease Remover and wipe dry.
- Sand using P600-1200 wet or P500 dry.
- Degrease again with DNA® Wax & Grease Remover and wipe dry.
- Wipe with suitable Tack Cloth.
- Spray two medium wet coats of Diamond Clear™ at about 25° C.
- Allow 10 minutes to flash off between coats at and allow to 'breathe' for 15minutes before baking.
- Spraying under higher temperatures may allow the top (outer layer) to dry more quickly, this 'holds' the solvents and as they evaporate may cause 'solvent pop'.
- For full UV protection a coating of at least 30µ is required.
- Lightly polish if required.

NOTE: It is imperative that the correct mixing ratio is used to ensure that complete cross-linking is achieved. Too much hardener lowers durability and not enough hardener results in poor chemical resistance. The Reducers are also important in that these contain enhanced flow, anti crater and other specialty additives.

WARNING: Different plastics react differently at various temperatures; some withstand heat better than others. Unless previous tests prove otherwise, it is best not to bake any plastic at high temperatures.

D. Spray Equipment:




Gravity feed
Hi Transfer

Fluid tip

1.2-1.6 mm
1.2-1.5 mm

Spray distance

15-25 cm
10-15 cm

E. <u>Spray Pressure</u> Gravity feed Hi Transfer	20-45 psi 10-30 psi	
F. <u>Flash time</u> 	@ 25°C	10 -15 minutes between coats and 15 minutes before baking for Fast and Medium Hardeners, and longer for Slow Hardener.
G. <u>Cure times</u> 	Dust Free: Baking: Air Dry (Touch):	5 min @ 25° C (Fast Hardener) 10 min @ 25° C (Medium Hardener) 10 min @ 25° C (Slow Hardener) 20-30 min @ 50° C (Fast Hardener) 40-50 min @ 50° C (Medium Hardener) 60 min @ 50° C (Slow Hardener) 1½ -2 hrs @ 20° C (Fast Hardener & Fast Reducer)
H. <u>Pot-life</u> 	1 hour (Fast Hardener). 30 min (Fast Hardener & Fast Reducer) 2 hour (Medium Hardener). 2 hour (Slow Hardener)	

5. Cleaning Equipment: After use, clean equipment thoroughly with gun wash.

6. Storage Period and Conditions:

1 year when stored in cool, dry conditions

7. Safety: Always wear appropriate safety clothing, gloves, breathing apparatus and observe all normal safety precautions in relation to Material Safety Data Sheets prior to use of this product.

8. Hardeners: 'FX' Hardeners™ are available in **F**ast and **M**edium or **S**low for maximum versatility and ease of application.

9. Reducers: A full range of 'FX' Reducers™ have been produced, these are available in **F**ast (RFXF), **M**edium (RFXM), **S**low (RFXS) or **H**igh Flow (RFXHF).

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These all have special properties that allow the most versatility in the hands of the professional painter in order to achieve the best results under varying conditions. For further details, refer to the 'FX' Reducer™ Technical Data Sheet.

'FX' Reducer™ Fast, RFXF can be used where fast drying is required. Can be used with all base coat, clear coat OEM and refinish systems, has good flow and solvency properties, very highly compatible (minimized risk of hazing) , good re-coatability, formulated for plastic substrates, ideal for use over all DNA® primers and coatings and prevents surface defects-craters, orange peel, bubbles and pinholes. Suited to prevent mottle and hazing with difficult to apply pearls and metallic base colors.

'FX' Reducer™ Medium, RFXM has a slower rate of drying than our Fast Reducer, has very good flow and leveling properties and is designed to provide a smooth finish. The reducer is formulated to provide very good blend-in promotion properties and is suitable with all base coats, clear coat OEM and refinish systems. It develops a long-wave effect in spray application, is highly compatible (minimized risk of hazing), has good re-coatability, is ideal for plastic substrates and for use over all DNA® primers and coatings, and prevents surface defects-craters, orange peel, bubbles and pinholes.

'FX' Reducer™ Slow, RFXS, has a slow rate of drying with excellent flow and leveling properties. The reducer is formulated to provide excellent flow and blend-in promotion properties, is suitable for use with all base coats, clear coat OEM and refinish systems and develops a long-wave effect in spray application. It is highly compatible (minimized risk of hazing), has good re-coatability, is ideal for plastic substrates and for use over all DNA® primers and coatings. The finish is excellent with no or minimal surface defects-craters, orange peel, bubbles or pinholes.

'FX' Reducer™ High Flow, RFXHF, has the slowest rate of drying of our reducers and has extraordinary flow and leveling properties. It is suitable for use in hot temperatures and where premium leveling is required for a "mirror finish". It is designed to provide the perfect surface on which to apply **Virtual Chrome™**, **HolAchrome™**, **Black Chrome™**, **HolAspeX™**, **HolAgrafix™** or where the smoothest finish is required. This reducer also possesses excellent flow and blend-in promotion properties, is suitable for use with all base coats, clear coat OEM and refinish systems and develops a long-wave effect in spray application. It is highly compatible (minimized risk of hazing), has good re-coatability, is ideal for plastic substrates and for use over all DNA® primers and coatings. The finish is excellent with no or minimal surface defects-craters, orange peel, bubbles or pinholes.



Note: Custom painting can be difficult. All products should be fully tested prior to commencing any job to determine suitability, final finish and overall appearance. All information and data provided by DNA® is given in good faith and intended to be a general guide only. DNA® shall not accept liability as a result of any failure or lack of expertise on the part of the applicator, condition of substrates, lack of, or incorrect preparation, use of incompatible materials, equipment failure or use of incorrect equipment or any other reason beyond the control of DNA® and further offers no warranties of whatever nature express or implied as to merchantability or fitness for a particular use or purpose and shall not accept liability for any specific or consequential damage as a result of using these products unless otherwise agreed to in writing. Should a product be defective, DNA® shall replace the defective product, or, at its sole discretion refund the purchase price.

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