

Technical Data Sheet



Product Name:**Ultra Violet Cure Clear Hardcoats**

Product Number:**51003-R1; 51006**

Product Description:

Clear, water white, gloss hard coats for use on polycarbonate mouldings etc for a variety of uses, including aircraft canopies; vehicle headlights, desk top and mobile phone lens, automotive trim parts.

Product can be supplied at 100% convertible solids (51003-R1) for on-site thinning: this allows for a variety of application solids to be achieved to allow for varying application methods: flow coating on aerospace canopies; automatic spray for lens etc.

In addition, ready for use version available which allows easy control of film thickness whilst meeting specific industry requirements.

51006 is designed for highly controlled thin film application, typically used on new and re-furbished vehicle headlamps and teletronic lenses to allow dry film thicknesses down to 4-8 microns.

Approvals/Specifications:

Approved for use on SAAB Griffen fighter jet cockpit canopy. (GKN Aerospace Transparency Systems M1340-001 to include: Adhesion; Tensile Strength; Tear Strength; Hardness; Abrasion Resistance; Rain Erosion; Optical Performance).

Approved for use on polycarbonate lenses on BT desk top phones.

Performance:

Exhibits exceptional scratch resistance as a thin film coating. Excellent clarity.

Components:

51003-R1:	100% convertible Solids
51006:	25% solids by weight
40008:	Reducer for 51003-R1

Application:**Surface Preparation:**

Ensure all surfaces are clean and free from dust/dirt etc
Pre-sand and basecoat as required; Wipe as required with IPA;
de-stat to prevent attraction of dust particles

Paint Preparation:

51003-R1: thin to required solids content with 40008 or specific solvent blend: please refer to our technical department

51006: use as supplied

Application Method:

Automatic Spray, Fixed guns or robotics.

Flow Coating.

Manual Spray: it is recommended that latest generation “compliant” spray guns are used; refer to manufacturers’ instructions regarding atomising pressures etc. Ensure full PPE is worn to include lint free coveralls, gloves, goggles and spray masks, preferably air-fed.

Drying Curing:

Pre-Cure: Allow solvents to flash off; typically use medium wave IR heating for 30-60 Seconds.

Cure: UVC lamps (240-250 nanometres; 200-300w/linear cm Mercury); 2-4 seconds exposure
Smart Repair UV lamps(400W iron doped metal halide): 40-60 seconds exposure

Technical Properties:

Supply Viscosity:	51003-R1: 300"/Din 4 cup/25±2°C 51006: 11"/ISO 4 cup/23±2°C
Density:	51003-R1: 1.12gms/cc 51006: 0.942gms/cc
Flash Point:	51003-R1: ≥ 55°C: 51006: ≥0°C & ≤21°C
VOC Content:	51003-R1: 0gms/litre 51006: 680gms/litre
Colour:	51003-R1/51006: Clear water white
Gloss:	Full Gloss
Thinner:	40008
Solvent/Clean Up:	40008 or Gunwash 40006
Theoretical Coverage:	21m ² /litre at 10 micron dry film thickness
Pack Size:	51003-R1/51006: 5 litre containers

Storage:

Highly flammable liquid: store and use in accordance with the flammable liquid regulations

Shelf Life: 12 months temperate; 6 months tropical

Before use, refer to Product Safety Data Sheet

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Safety Data Sheets:

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