



Technical Data Sheet

Date of issue	Revision Date	Version
19/07/16		1.0
Product Code	Product Name	
CU_-	Custom Clear™	

Custom Clear™ is a premium low viscosity 2K clear coat, specially developed for custom spray painting. Ideal for general clear coating, layering, sealing flakes, candies and flow coating. Used with different hardener speeds, gives excellent curing performance whilst easily delivering glass like finishes. Custom Clear™ can also be used with DNA® candy concentrates to create an easy to use 2K urethane candy finishes over suitable DNA® basecoats

Custom Clear™ Always check that you have the latest TDS



SURFACE PREP

Surface must be chemically clean & dry.



MIXING RATIO

4: Parts Custom Clear™
1: Part FX Hardener
No Reducer Required



URETHANE CANDY – MIXING RATIO

Up to 20% candy concentrate into Custom Clear™ then harden 4:1 (No reducer required)



CONVENTIONAL - GUN SET UP

1.2~1.4 Fluid tip
15~25 cm Spray distance
20~45 psi Air pressure
15~25 cm Fan size



HTE- GUN SET UP

1.2~1.3 Fluid tip
10~15 cm Spray distance
1.8~2.2bar Air pressure
15~20 cm Fan size



NUMBER OF COATS

2-3 medium wet coats



CURE TIMES @ 25°C

Dust Free: 30 min*
Baking: 30~40min* @ 60°C
*Medium Hardener



POT LIFE

2 Hour
*Medium Hardener



FLASH TIME @ 25°C

Fast Hardener: 5-10 min
Medium Hardener: 10-15 min
Slow Hardener: 15-20 min
(recommended for flow coating)



SPRAYING VISCOSITY

Ford 4 Cup: 13 sec



THEORETICAL COVERAGE

10~12 m² per litre



MSDS

Observe all safety precautions in relation to this products Material Safety Data Sheet



CLEAN UP

Clean equipment with Gun Wash, Reducer or Thinners



SAFETY

Always wear appropriate safety clothing, gloves, & breathing apparatus

STORAGE

1 Year in cool, dry conditions

QUICK APPLICATION GUIDE:

1. Prepare your surface.
2. 2-3 medium wet coats.
3. Allow to flash off properly between coats.
4. Bake 30~40min* @ 60°C.
5. Lightly polish if required.

DETAILED APPLICATION GUIDE:

CLEANING



Thoroughly clean the surface using a wax and grease remover such as DNA® Wax & Grease Remover or Prep Clean X™

SUBSTRATE



For use over DNA® BaZecoats™, Candy ColorZ™ & other DNA® Special FX products as well as previously painted substrates that are properly prepared, with the exception of thermoplastic acrylic lacquer and air dry enamel finishes. Surface must be chemically clean and dry.

PREPARATION



If applying over an existing 2K clear coat, sand using P1200 wet or dry. Clean with DNA® Prep Clean X™ & wipe dry.

MIXING



Mix Ratio: 4:1 no reducer required
 4: Parts Custom Clear™
 1: Part FX Hardener*

URETHANE CANDY – MIXING RATIO



Add up to 20% DNA® Candy Concentrate prior to hardening. Apply up to 3-4 coats with 70% overlap. Flash off between coats 15-20 minutes minimum. Once cured, lightly sand with a scotch brite pad, and overcoat with DNA® clear coat of your choice. (Strain using DNA® FIL01 microfine strainer.)

SPRAYING



Strain mixed Custom Clear™ into paint gun.
 Allowing for flash time between each coat apply 2-3 medium wet coats
 Spray with a 50% spray overlap.
Flash time varies with temperature, and choice of FX Hardener speed.

FLASH OFF@ 25°C



Time between coats
 5~10 min (Fast Hardener)
 10~15 min (Medium Hardener)
 15~20 min (Slow Hardener)

CURING TIMES



Dust Free @ 25°C
 25 min (Fast Hardener)
 30 min (Medium Hardener)
 60 min (Slow Hardener)

Baking @ 60°C
 20~30 min (Fast Hardener)
 40~50 min (Medium Hardener)
 60 min (Slow Hardener)

Air Dry Touch @ 25°C
 2 hr (Fast Hardener)

POT LIFE @ 25°C



1.5 hr (Fast Hardener)
 2 hr (Medium Hardener)
 2.5 hr (Slow Hardener)

FLOW COATING



Do not apply flow coat unless existing clear coat has been baked and left to out-gas for a minimum of 48 hours. Additional time will be required if cooler temperatures are experienced during the out-gassing period. Recommended hardener for flow coating is DNA® slow hardener HFXS.

For further information refer to the DNA® Training Manual, or contact your DNA® Distributor for Technical Support.

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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