

Kappa Clear [slow]

Endura Kappa Clear is a clear coat designed to give extra protection and gloss to solid, metallic, and pearl colours. Kappa is an easy to spray clear coat that provides a smooth automotive finish. Kappa provides exceptional UV protection along with excellent polishing characteristics.

Product Features

- ◆ High gloss
- ◆ Easy to spray
- ◆ Smooth automotive finish
- ◆ Excellent polishing clear
- ◆ Exceptional ultraviolet light protection

Theoretical Solids Content:

Volume: 33%

Shelf Life*

Component A: (3) years
Component B: (1) year

*For unopened product.

Pot Life of Mixed Product:

4 Hours* @ 77°F (25°C) and 50% RH

* The use of Endura Super Catalyst II is **NOT** recommended.



Suitability

Endura Kappa Clear is suitable for protecting most finished surfaces including solid colours, metallic and pearl colours. Kappa Clear [slow] is designed for higher temperature applications.



Surface Preparation

Ensure that surfaces to be clear coated are free of flaws, surface contaminants and other imperfections. If the surface has been allowed to cure longer than 24 hours, sanding will be required to achieve intercoat adhesion.

Between 24-48 hours: sand with 600 grit sandpaper

After 48 hours: sand with 320-400 grit sandpaper

Do not sand Metallic or Pearl colors.

Do not mix Kappa clear with colour for final coat.



Mixing Ratio

4 part by volume of component A [FUA0143]

1 part by volume of component B [FUB0132]

The recommended temperature when mixed is 20-25°C (68-77°F).

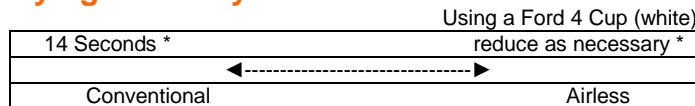
Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be between 20°C-25°C* (68°F-77°F). To prevent condensation during application the surface temperature must be 3°C (5°F) or more above the dew point at all times.

*for use outside this range please contact your Endura representative.



Spraying Viscosity*

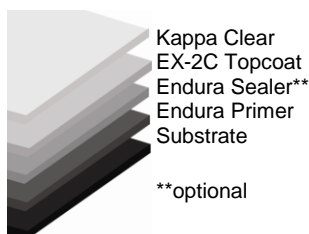


* Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and on the desired surface finish.



Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	< 1.4 mm	30-40 psi	
Pressure Feed	1.0-1.4 mm	55-65 psi	12-14 oz/min
Air Assist Airless	9-13 Thou	1,000-1,800 psi	
Airless	11-13 Thou	1,700-3,000 psi	



Kappa Clear [slow]

Endura Kappa Clear is a clear coat designed to give extra protection and gloss to solid, metallic, and pearl colours. Kappa is an easy to spray clear coat that provides a smooth automotive finish. Kappa provides exceptional UV protection along with excellent polishing characteristics.

Product Features

- ◆ High gloss
- ◆ Easy to spray
- ◆ Smooth automotive finish
- ◆ Excellent polishing clear
- ◆ Exceptional ultraviolet light protection

Theoretical Solids Content:

Volume: 33%

Shelf Life*

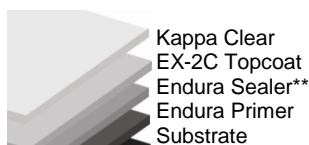
Component A: (3) years
Component B: (1) year

*For unopened product.

Pot Life of Mixed Product:

4 Hours* @ 77°F (25°C) and 50% RH

* The use of Endura Super Catalyst II is **NOT** recommended.



**optional



Application Method

Clear coats can be applied as soon as the surface has cured enough to wipe with a tack cloth. Apply 2-3 wet coats with a 15-20 minute flash off between coats. EX-2C Topcoats require a drying time of 8 - 10 hours before application Kappa Clear. Drying time of the Endura EX-2C topcoat can be reduced with accelerator*.

*Refer to the Super Catalyst II Data Sheet.

Recommended Film Build Thickness and Cover Rate

Endura Kappa Clear has a recommended film thickness of 1.0 - 2.0 mils dry (25 - 50 microns).

Wet (unreduced): 3.0 – 6.0 mils wet (75 – 150 microns)

Dry: 1.0 – 2.0 mils dry (25 – 50 microns)

Theoretical coverage at 1.0 mil (25 microns) DFT: 576 ft² per gallon @ 100% transfer efficiency.



Drying Time*

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Dust Free	2 Hours	1 Hour	30 Minutes
Full Cure	7-14 Days		

* Subject to ambient conditions (temperature and humidity) film build and good airflow. For improved scheduling please contact your Endura representative.

Specifications

Hardness	ASTM D3363	4H
Solvent resistance	ASTM D4752	100 MEK rubs; NO failure
Impact resistance	ASTM D2794	80 in. lbs; NO failure
Flexibility	ASTM D522	1/8" mandrel bend; NO failure
VOC	For VOC amounts please refer to the product MSDS	



Clean Up

Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.