



# KRONOX 3100

## E42

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### 3:1 UHS CLEAR COAT

#### DEFINITION

**KRONOX 3100** is an extremely new and differentiated 2K clear coat due to its formulation and 3:1 design ratio. It is very easy to apply and is particularly suitable for complete resprays as well as for spot repair works. To use, apply a mist coat followed by a full coat or it is also possible to apply two full coats, this ensures a fast and easy application. This ensures an excellent finish with a high level of gloss achieved with good drying times.

In addition KRONOX 3100 complies with European legislation regarding VOC limits with COV < 420 g/l (application) - 390 g/l (Kronox 3100 : K35).

#### PHYSICAL CHARACTERISTICS

<b>Nature:</b>	Acrylic 2K
<b>Colour:</b>	Colourless
<b>Specific weight:</b>	1,0 kg/l at 20°C
<b>Viscosity CF/4:</b>	20" at 20°C
<b>Dry film thickness:</b>	50-60 microns (½ + 1 coat)
<b>Yield:</b>	9-10 m <sup>2</sup> /l
<b>VOC:</b>	390 g/l                      Application
<b>Solids content:</b>	53 %                              Application

#### AUXILIARY PRODUCTS

K34	Slow Hardener	VOC PLUS Low Voc Standard Additive
K35	Standard Hardener	VOC PLUS Low Voc Slow Additive
K36	Fast Hardener	
K38	Extra-fast Hardener	

			
T° (°C)	Hardener	Hardener	Voc Plus Low Voc Additive
< 18	K36-K38	K36	Standard
18 - 25	K35 - K36	K35	Standard -Slow
> 25	K35	K34	Slow

#### SURFACE PREPARATION

Apply **KRONOX 3100** on the basecoat after the flash off time recommended by the manufacturer. On a solvent-based basecoat system, apply the clear coat after the coat is completely cured.

## MIXING RATIO

Kronox 3100					20°C	
K34	100:33:5-10 Volume	3 :1+5- 10%	20" F/4			2 h
K35						2 h
K36						1 h
K38						45'

## APPLICATION METHOD

	mm	bar	cm		
	1,2-1,4	2-3	15 - 20		½ + 1 coat or 2 coats  5'-10'
	1,3-1,5	4	15 - 20		
	1,2-1,3	2	10		

## DRYING TIMES

20° C						60° C		Short wave - IR		
									FLASH OFF	FULL BAKE
K34	45'	4h	6h	8h	24h	K34	40'	LIGHT	5'	10'
K35	40'	4h	5h	7h	24h	K35	35'	DARK	4'	8'
K36	30'	3h	4h	6h	24h	K36	25'	METALLIC	5'	10'
K38	15'	1h	2h	5h	12h					

## REMARKS

Humidity affects clear coat components so the application equipment should be absolutely dry.  
Close the hardener container immediately after use.  
Do not use when relative humidity is higher than 70%.  
Do not use at temperatures lower than +10°C. In this case dry in spraybooth.

## EQUIPMENT CLEANING

Use a cleaning thinner before the pot life has expired.

## SAFETY

Follow instructions of product label. For more information check the Safety Data Sheet. Compliant with the National Statutory Regulation for Health and Safety at Work and Waste Disposal.

## STORAGE

Store the product in a ventilated place far from direct exposure to sunlight. Keep between +5°C and +30°C.

## GUARANTEE

In unopened original packaging, one year from manufacturing date.

For any technical information contact with our Customer Attention Service or our Technical Department.  
ROBERLO SA declines any responsibility due to an incorrect use of the product.