



VIPER Technical Data Sheet TDS

Information contained herein is based on careful investigation and is intended for information only. User is obliged to test the suitability of the products for their particular use. Supplier may change any specifications without notice.

SUNOX® Viper HS Compliant Scratch Resistant Clear – low solvent content - Used in conjunction with 498 10M / 499 5M

Product description –SUNOX® **VIPER** 2-pack Compliant Clear – high solids, high functionality at low viscosity. For application ranging from the repair of individual panels to overall re-sprays.
Solid content 45.5% by weight (RFU) – **Excellent flow, gloss and DOI**

The EU limit value for this product (product category IIB .e) in ready for use form is max.840 g/litre of VOC. The VOC content of this product in ready for use form is 600 g/l – 2004/42/IIB(e) (840) 600

Composition	Acrylic Resins,
Colour	Water white,
Shelf life	36 months in unopened container
Pack size	5 litre / 2.5 litre

Pre-treatment

SUNOX® VIPER 2K HS Compliant Clear can be applied to solvent and waterborne basecoats



Health and safety "For professional use only" **Important:** When using any **new** product, consult the "**Health and Safety**" data sheet. Always read the risks and precautions stated on the product label.

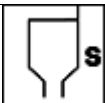


Mixing Ratio 2:1 *stir well & strain before use*
2 PARTS SUNOX® VIPER - HS Clear
1 PART SUNOX® VIPER 498 499

Volume	Weight
100g	100g
50g	55g

UP TO 5% UNI THINNER

5% optional




Spraying viscosity
18 to 20 seconds BS 4 cup at 20°C – 14 seconds DIN4 cup at 20°C
Pot life- 499 20 mins / 498 55 mins @ 20°C ambient temp.



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Metal temperature needs to be at ambient 20°C

	LVP Compliant Gravity-feed spray gun	fluid tip	1.3 to 1.4	2 – 2.5bar
	Devilbiss GTI Air cap 110	fluid tip	1.3	2 – 2.5
	bar			
	HVLP gravity-feed nozzle	fluid tip	1.3– 1.5	0.7bar at

	<p>Number of coats - 2 – 1st ¾ wet at 20°C 2/3/4 minutes flash off 2nd full wet</p> <p>A further 2/3/4 minutes before bake / infra-red</p> <p>Film thickness 40 – 50 micron</p> <p><u>Do NOT over apply- allow correct flash off</u></p>
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Through cure times operate from BAKE TIME

	<p>498 10M</p> <p>Bake at 80° C 60°metal for 10 minutes</p> <p>Air dry @ 20°C touch dry in 30 minutes – hard dry 1hr</p> <p>499 5M</p> <p>Bake at 80° C 60°metal for 5 minutes</p> <p>Air dry @ 20°C touch dry in 20 minute – hard dry 40 minute</p>
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