

380S

1K ACRYLIC LACQUER CLEAR

Description

1-component acrylic lacquer clear for use over Lucite[®] 400 Acrylic Lacquer metallic colours to repair OEM base/clear finishes.
Composition based on acrylic resin.

Products

380S	1K Acrylic Lacquer Clear
3608S	Thinner
3642S	1K Multi-purpose Thinner
AD345	1K Thinner

Properties

- Can be applied over Lucite[®] 400 Acrylic Lacquer metallic colours to repair OEM base/clear finishes or to be used as an acrylic clear. 380S makes base/clear repairs easy with a lacquer system that dries fast.

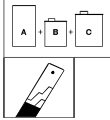







Substrates

- Lucite[®] 400
- also can be applied over Centari[®] 600, Centari[®] 6000 basecoats
- all OEM finishes cleaned and sanded

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PRODUCT PREPARATION

	Mixing ratio		Fast (15-20°C)		Standard (20-25°C)		High temp. (> 30°C)	
		380S	Volume	Weight	Volume	Weight	Volume	Weight
		3608S	1	100	1	100	1	100
		3642S	1.5-2	150-200	1.5-2	150-200	/	/
		AD345	/	/	1.5-2	150-200	/	/
		/	/	/	/	2	200	
	VOC	561-583 g/li						
	Pot life at 20°C	Not applicable						
	Spray viscosity at 20°C	DIN 4	14-15 s					
		FORD 4	14-15 s					
		AFNOR 4	15-16 s					
	Spray equipment		Fluid tip			Spray distance		
		Gravity feed	1.2-1.5 mm			15-20 cm		
		Suction feed	1.6-1.8 mm			15-20 cm		
		HVLP	1.3-1.5 mm			10-15 cm		
		Pressure feed	1.0-1.2 mm			15-20 cm		
	Spray pressure	Gravity feed	3-4 bar					
		Suction feed	3-4 bar					
		HVLP	0.7 bar at nozzle					
		Pressure feed	3-4 bar					
		Spot repair	2.5-3 bar					
	Number of coats	2-4						
	Flash time	10-15 min. between coats						
	DFT	45-50 μ						
	Drying		20°C					
		Dust-free	15-20 min.					
		Tack-free	50 min.					
		Dry to handle	2 h 30 min.					
		Tape-free	4 h					
<p>This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.</p>								

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RECOMMENDED USE

Surface preparation

The entire panel has to be carefully prepared (before basecoat application):

1. Clean surface with water and soap.
2. Degrease with 3919S and wipe dry with clean cloth.
3. Repair according to damage.
4. Wet sand with P1200 or treat with 600S the remaining surface of the panel.
5. Degrease with 3920S and wipe dry with clean cloth.
6. Tack rag.
7. Apply basecoat Lucite[®] 400, Centari[®] 600 or Centari[®] 6000.

Clearcoat application

When Lucite[®] 400, Centari[®] 600 or Centari[®] 6000 is completely flat, apply 380S in 2 to 4 coats with 10-15 min. flash between coats.

Polishing

After overnight dry, polish with 1500S.

Equipment cleaning

Use 3608S. Do not leave mixed material in equipment.

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RECOMMENDED USE (con'd)

Recoatability

At any time after tape-free time.

Product data

Package viscosity: 95 s CF4
Theoretical coverage: 2-3 m²/li at recommended DFT - ready-to-spray

Products	Packages (li)	Storability at 20°C (year)
380S	1 - 3.785 - 5	2
3608S	1 - 5 - 20 - 200	2
3642S	1 - 5 - 20 - 60	1
AD345	1 - 5	2

Remarks

- Avoid excessive film build as cracking could result as well as soft films.
- Flash time before clearcoating is 30 min. for metallics. For solid colours allow more time.
- Gloss can be lowered using 4531S Universal Flattening Base. Add 20 % maximum by volume to already thinned clear (see specific TDS).
- Material has to be at room temperature (18-20°C) before use.

Safety

Consult Material Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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REPAIR SYSTEMS

Overall repair

Pay attention to the application method. Spray procedure has to ensure proper overspray melt-in which is achieved within the 2 min. of the clear application. Plan the process to avoid dry overspray.

Spot repair

- When spot repairing with Lucite[®] 400, Centari[®] 600 or Centari[®] 6000, the clearcoat method as described below can be used. If blending out the clear in original areas is unavoidable, the melt-in of the clear can be achieved as described below:

①+② Apply 2 to 4 coats of 380S over the basecoat, extending into the area surrounding the spot.

③ OPTIONAL: reduce 1 part of 380S with 1 part AD347 and apply 1 coat of reduced 380S over the blend-out area.

④ Blend in the fade-out area immediately with pure AD347.

! Surface should be carefully and correctly prepared before the basecoat application.
See recommended use, paragraph surface preparation.

! Stay with the application of AD347 within the prepared area.

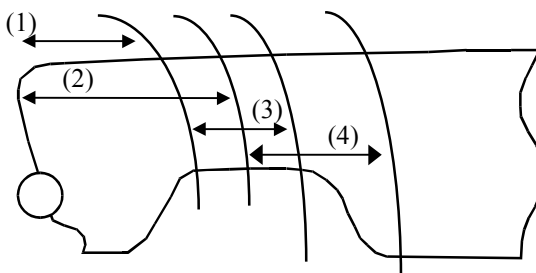
AD347 Centari[®] Blending Thinner method

① Apply 1st/2nd coat 380S.

② Extend a 3rd/4th coat 380S beyond the previous one.

③ OPTIONAL:
apply 1 coat reduced 380S beyond the previous application.

④ Blend in the fade-out area with AD347 within 5 min. maximum.



If necessary, balance out the gloss level by polishing with 1500S or 3000S after complete hardening of the repair.