



Effective 24 May, 2008

3050S

CHROMACLEAR®

Description

2-component clear based on Low Emission resin technology, to be used in clear over base system.

Composition based on acrylic copolymer.

Products

3050S	ChromaClear®
256S	Activator Fast
AK260	High Solids Activator
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow

Properties

- Combines very easy application with little sagging risks.
- Gives a smooth, high build finish and has very fast drying properties.
- Has excellent mar, chemical and weather resistance.
- Can be used for spot, panel and overall repair.

Substrates

- DuPont Refinish basecoats.
- All cleaned and sanded OEM finishes (not recommended on thermoplastic acrylic finishes).

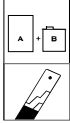









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PRODUCT PREPARATION

	Mixing ratio	Spot repair		Standard	
		Volume	Weight	Volume	Weight
	3050S 256S AK260	3 1 -	100 37 -	3 - 1	100 - 37
VOC	256S AK260	562 g/l 548 g/l			
 Pot life at 20°C	256S AK260	3 hr 4 hr			
 Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	16-18 s 16-18 s 18-20 s			
 Spray equipment	Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip	Distance	Pressure	
		1.4-1.6 mm	15-20 cm	3-4 bar	
		1.6-1.8 mm	15-20 cm	3-4 bar	
	Compliant guns (HVLPHTE) Gravity feed Suction feed Pressure feed	1.0-1.2 mm	15-20 cm	3-4 bar	
		1.3-1.5 mm	10-15 cm	According to supplier's specifications	
		1.5-1.6 mm	10-15 cm	According to supplier's specifications	
 Number of coats	2				
 Flash time	5 min between coats. 5 min before bake.				
DFT	45-65 µ				
 Drying	Dust-free Dry to handle Tape-free	256S		AK260	
		20°C	20 min x 60°C	20°C	30 min x 60°C
		15 min	imm.	20 min	imm.
		2 hr	imm.	6 hr	imm.
6 hr	30 min	O.N.	30 min		
 IR drying*	Flash time	5 min			
	Distance	80 cm			
	Half power	5 min			
	Full power	15-20 min			

* Guideline for short/medium wave IR equipment.

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PRODUCT PREPARATION (con'd)

	Mixing ratio	3050S XK203 XK205 XK206	Spot and panel		Standard		High temperature	
			Volume	Weight	Volume	Weight	Volume	Weight
			4	100	4	100	4	100
			1	27	-	-	-	-
			-	-	1	27	-	-
			-	-	-	-	1	27
	VOC	526 g/l						
	Pot life at 20°C	XK203 XK205 XK206	2 hr 2 hr 45 min 3 hr 15 min					
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	16-18 s 17-19 s 19-21 s					
	Spray equipment	Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip		Distance		Pressure	
			1.4-1.6 mm		15-20 cm		3-4 bar	
			1.6-1.8 mm		15-20 cm		3-4 bar	
			1.0-1.2 mm		15-20 cm		3-4 bar	
		Compliant guns (HVLP/HTE) Gravity feed Suction feed Pressure feed	1.3-1.5 mm		10-15 cm		According to supplier's specifications	
			1.5-1.6 mm		10-15 cm			
			1.0-1.2 mm		10-15 cm			
	Number of coats	2						
	Flash time	5 min between coats. 5 min before bake.						
	DFT	45-65 µ						
	Drying	Dust-free Dry to handle Tape-free	XK203		XK205		XK206	
			20°C	20 min x 60°C	20°C	30 min x 60°C	40 min x 60°C	
			50 min	imm.	1 hr	imm.	imm.	
			3 hr 30 min	imm.	6 hr	imm.	1 hr	
			12 hr	30 min	O.N.	30 min	2 hr	
	IR drying*	Flash time Distance Half power Full power	5 min 80 cm 5 min 15-20 min		* Guideline for short/medium wave IR equipment.			
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RECOMMENDED USE

Surface preparation

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with a clean cloth.
3. Repair according to damage.
4. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.
5. Tack rag.
6. If needed, apply a DuPont Refinish basecoat.

Clearcoat application

When the DuPont Refinish basecoat is completely flat, apply 3050S in 2 coats with 5 min flash between coats.

Chemical resistance

When fully cured, 3050S is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20 %	battery acid
sulphuric acid	25 %	toluene
hydrochloric acid	20 %	xylene
phosphoric acid	20 %	glycol
ammonia	10 %	brake fluid, petrol

Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



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RECOMMENDED USE (con'd)

Recoatability

At any time after tape-free time. After 24 hr, scuff sanding is required.

Remarks

- XK203 is recommended for spot repair only.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Activated material should not be returned to original can of non-activated material.
- To spray interiors, use of 421R or XK203 is recommended.
- Dry spray spots in the clear can be worked off with AK350 at very low spray pressure. This should be done at the latest 10 min after clear application and should be avoided on horizontal parts.
- For structured and/or flat clears, see specific TDS.
- For flexible systems, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

Product data

Package viscosity: 30 cp
 Theoretical coverage: 7.5 m²/l at recommended DFT - ready-to-spray with AK260/256S
 8.2 m²/l at recommended DFT - ready-to-spray with XK203/XK205/XK206

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
3050S	5	2	0.966
256S	1 - 5	2	0.986
AK260	1 - 5	2	1.023
XK203	1 - 5	2	1.060
XK205	1 - 5	2	1.059
XK206	1 - 5	2	1.078

Safety

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



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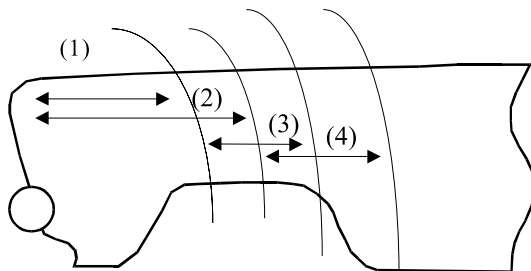
REPAIR SYSTEMS

Overall repair

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

Spot repair: AK350 Fade-out Thinner method

- ① Apply 1 coat of 3050S over the basecoat, extending into the area surrounding the spot.
 - ② Apply a 2nd coat of 3050S, extending further into the area surrounding the spot.
 - ③ OPTIONAL: reduce 1 part of activated ready-for-use 3050S with 1 part AK350 and apply 1 coat of reduced 3050S over the fade-out area.
 - ④ Smoothen out the fade-out area immediately with pure AK350.
- ! Surface should be carefully and correctly prepared before the basecoat application.
See recommended use, paragraph surface preparation.
- ! Stay with the application of AK350 within the prepared area.



If necessary, balance out the gloss level by polishing with a non silicone containing polishing compound or a non silicone containing final glaze, after complete hardening of the repair.