

696S

MS II CLEAR

Description

2-component clear based on high build resin technology, to be used in clear over base system. Composition based on acrylic copolymer.

Products

696S	Ms II Clear
256S	Activator Fast
AK260	High Solids Activator

Properties

- Combines new application latitude with very little sagging risks and short drying time.
- Provides excellent appearance and very fast drying properties.
- Has excellent mar, chemical and weather resistance and results in a high gloss, mirror like, lasting finish.
- Can be used for spot, panel and overall repair.

Substrates

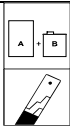








- Centari® 600, Centari® 6000 basecoats
- all OEM finishes cleaned and sanded (not recommended on thermoplastic acrylic finishes)



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PRODUCT PREPARATION

	Mixing ratio	696S AK260 256S	Large Surface		Spot and panel	
			Volume	Weight	Volume	Weight
			3	100	3	100
			1	35	/	/
			/	/	1	35
	VOC	AK260 256S	529 g/li 547 g/li			
	Pot life at 20°C	AK260 256S	4 h 3 h			
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	16-18 s 16-18 s 18-20 s			
	Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip		Spray distance	
			1.4-1.6 mm	1.6-1.8 mm	15-20 cm	
			1.3-1.5 mm		15-20 cm	
			1.0-1.2 mm		10-15 cm	
					15-20 cm	
	Spray pressure	Gravity feed Suction feed HVLP Pressure feed	3-4 bar 3-4 bar 0.7 bar at nozzle 4 bar			
	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	AK260		256S	
			20°C	30 min. x 60°C	20°C	20 min. x 60°C
			20 min.	imm.	15 min.	imm.
			6 h	imm.	2 h	imm.
			O.N.	30 min.	6 h	30 min.
	IR drying*	Flash time	5 min. * guideline for short/medium wave			
		Distance	80 cm IR equipment			
		Half power	5 min.			
		Full power	15-20 min.			
<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 Centari® 600 or Centari® 6000.

Clearcoat application

When Centari® 600 or Centari® 6000 is completely flat, apply 696S in 2 coats with 5 min. flash between coats.

Chemical resistance

When fully cured, 696S 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 3608S.

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RECOMMENDED USE (con'd)

Recoatability

At any time after tape-free time.

Product data

Package viscosity: 40-50 cp
Theoretical coverage: 7.7 m²/li at recommended DFT - ready-to-spray

Products	Packages (li)	Storability at 20°C (year)
696S	1 - 5	2
256S	1 - 5	2
AK260	1 - 5	2

Remarks

- If necessary for minor viscosity adjustments, use Centari[®] basecoat thinners (maximum 5 %).
- Close can of 256S and AK260 tightly immediately after use, as these products will react with humid air and water and lose their hardening effect.
- Activated material should not be returned to original can of non-activated material.
- Use of 256S can influence the appearance. Baking at 80°C is not recommended.
- To spray interiors, use of 421R (see specific TDS) or 256S 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. Hand should be avoided on horizontal parts.
- For structured and/or flat clears, 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

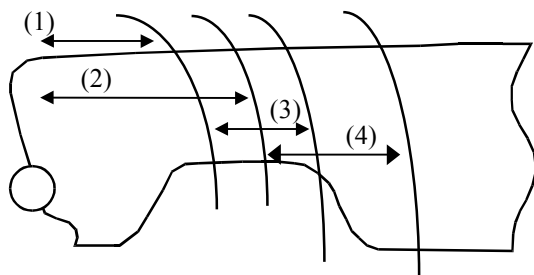
Overall repair

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

Spot repair: AK350 Centari® Blending Thinner method

When spot repairing with 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 Apply 1 coat of 696S over the basecoat, extending into the area surrounding the spot.
 - ② Apply a 2nd coat of 696S, extending further into the area surrounding the spot.
 - ③ OPTIONAL: reduce 1 part of 696S with 1 part AK350 and apply 1 coat of reduced 696S over the blend-out area.
 - ④ Blend in 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 1500S or 3000S after complete hardening of the repair.