

120SX

STANDARD MS 2K CLEAR

Description

2-component clear to be used in clear over base system.
Composition based on acrylic copolymer.

Products

120SX	Standard MS 2K Clear
AK210	2K Activator
256S	Activator Fast
AK260	High Solids Activator

Properties

- Has very good flow.
- Has excellent mar, chemical and weather resistance.
- Gives a long lasting high gloss finish.
- Can be used for spot, panel and overall repair.

Substrates

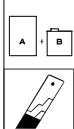








- Centari® 600, Centari® 6000 basecoats
- all OEM finishes cleaned and sanded (not recommended on thermoplastic acrylic finishes)



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PRODUCT PREPARATION

	Mixing ratio	120SX AK210 256S AK260	Standard		Fast		Large surface	
			Volume	Weight	Volume	Weight	Volume	Weight
			2	100	3	100	4	100
			1	50	/	/	/	/
			/	/	1	35	/	/
			/	/	/	/	1	27
	VOC		602 g/li		598 g/li		589 g/li	
	Pot life at 20°C	AK210	6 h					
		256S	4 h					
		AK260	4 h					
	Spray viscosity at 20°C	DIN 4	15 s					
		FORD 4	15-16 s					
		AFNOR 4	16-18 s					
	Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip			Spray distance		
			1.4-1.6 mm	15-20 cm				
			1.6-1.8 mm	15-20 cm				
			1.3-1.5 mm	10-15 cm				
			1.0-1.2 mm	15-20 cm				
	Spray pressure	Gravity feed	3.5-4 bar					
		Suction feed	3.5-4 bar					
		HVLP	0.7 bar at nozzle					
		Pressure feed	4-6 bar					
	Number of coats	2-3						
	Flash time	10 min. between coats. 5 min. before bake.						
	DFT	40-50 μ (2 coats)						
	Drying	Dust-free Dry to handle Tape-free	AK210/AK260			256S		
			20°C	30 min. x 60°C	20°C	20 min. x 60°C		
			40 min.	imm.	30 min.	imm.		
			6 h	30 min.	4 h	30 min.		
			O.N.	1 h 30 min.	5 h	1 h 30 min.		
	IR drying*	Flash time	5 min.					* guideline for short/medium wave IR equipment
		Distance	80 cm					
		Half power	5 min.					
		Full power	15-20 min.					
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.								

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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 120SX in 2 to 3 coats with 10 min. flash between coats.

Chemical resistance

When fully cured, 120SX 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: 70-80 cp
Theoretical coverage: 5.7 m²/li at recommended DFT - ready-to-spray

Products	Packages (li)	Storability at 20°C (year)
120SX	1 - 5	2
AK210	0.5 - 1 - 5	2
256S	1 - 5	2
AK260	1 - 5	2

Remarks

- 256S is recommended for spot/panel repair only.
- If necessary for minor viscosity adjustments, use Centari[®] basecoat thinners (maximum 5 %).
- Close can of AK210, 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.
- 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

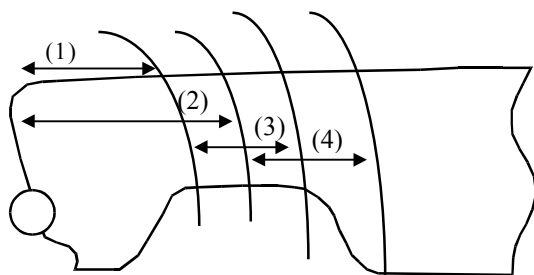
Overall repair

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 120SX over the basecoat, extending into the area surrounding the spot.
 - ② Apply a 2nd coat of 120SX, extending further into the area surrounding the spot.
 - ③ OPTIONAL: reduce 1 part of 120SX with 1 part AK350 and apply 1 coat of reduced 120SX 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.