



Effective 24 May, 2008

3750S

ULTRA PRODUCTIVE VOC CLEAR

Description

2-component fast dry clear, to be used in clear over base system.
Composition based on acrylic polyurethane copolymer and on Hyper Cure™ technology.

Products

3750S	Ultra Productive VOC Clear
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
431R	Accelerator
XB387	High Temperature Thinner

Properties

- Gives very fast air drying and allows short flash times between coats and bake.
- The fast dust-free times prevent surface defects by air contamination.
- Has excellent polishability.
- Increases productivity in air dry, low bake or IR drying.
- Can be used for spot and panel repair.
- VOC compliant, conform with directive 2004/42/EC.

Substrates

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



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PRODUCT PREPARATION (Accelerated)

	Mixing ratio	3750S XK203 431R/XB387	Spot and panel			
			Volume	Weight		
			3	100		
			1	36		
			0.4	12		
	VOC	420 g/l				
	Pot life at 20°C	With 431R	45 min			
		With XB387	55 min			
	Spray viscosity at 20°C	DIN 4	19-22 s			
		FORD 4	20-23 s			
		AFNOR 4	22-25 s			
	Spray equipment	Conventional guns	Fluid tip	Distance	Pressure	
		Gravity feed	1.4-1.6 mm	15-20 cm	3-4 bar	
		Suction feed	1.6-1.8 mm	15-20 cm	3-4 bar	
		Pressure feed	1.0-1.2 mm	15-20 cm	3-4 bar	
		Compliant guns (HVL P/HTE)				
		Gravity feed	1.3-1.5 mm	10-15 cm	According to supplier's specifications	
Suction feed	1.5-1.6 mm	10-15 cm				
Pressure feed	1.0-1.2 mm	10-15 cm				
	Number of coats	1.5				
	Flash time	0-5 min between coats. 0-5 min before bake (depends on spray booth).				
	DFT	40-60 µ				
	Drying	Dust-free Dry to handle Tape-free	With 431R		With XB387	
			20°C	15 min x 60°C	20°C	15 min x 60°C
			15 min	imm.	30 min	imm.
			2 hr	imm.	3 hr	imm.
		6 hr	15 min	8 hr	30 min	
	IR drying*	Flash time Distance Half power Full power	Dark colours	Light colours	Dark colours	Light colours
			4 min	4 min	4 min	4 min
			50 cm	50 cm	50 cm	50 cm
			6 min	6 min	6 min	7 min
			3 min	6 min	5 min	7 min

* Guideline for short/medium wave IR equipment.

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.

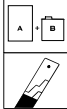









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PRODUCT PREPARATION (Not accelerated)

	Mixing ratio	3750S XK205/XK206 XB387	Large surface/High temperature		
			Volume	Weight	
			3	100	
			1	36	
			0.4	12	
	VOC	420 g/l			
	Pot life at 20°C	With XK205	65 min		
		With XK206	70 min		
	Spray viscosity at 20°C	DIN 4	19-22 s		
		FORD 4	20-23 s		
		AFNOR 4	22-25 s		
	Spray equipment	Conventional guns	Fluid tip	Distance	Pressure
		Gravity feed	1.4-1.6 mm	15-20 cm	3-4 bar
		Suction feed	1.6-1.8 mm	15-20 cm	3-4 bar
		Pressure feed	1.0-1.2 mm	15-20 cm	3-4 bar
		Compliant guns (HVL P/HTE)			
		Gravity feed	1.3-1.5 mm	10-15 cm	According to supplier's specifications
Suction feed	1.5-1.6 mm	10-15 cm			
Pressure feed	1.0-1.2 mm	10-15 cm			
	Number of coats	1.5			
	Flash time	0-5 min between coats. 0-5 min before bake (depends on spray booth).			
	DFT	40-60 µ			
	Drying	Dust-free Dry to handle Tape-free	With XK205		With XK206
			20°C	25 min x 60°C	30 min x 60°C
			50 min 5 h 30 min O.N.	imm. imm. 1 h 30 min.	imm. 30 min 2 h
	IR drying*	Flash time Distance Half power Full power	All colours		All colours
			5 min		5 min
			80 cm		80 cm
			5 min		5 min
			15 min		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 3750S in 1 light coat immediately followed by a full coat.

Chemical resistance

When fully cured, 3750S 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

- 431R is recommended for spot and panel repair only.
- For horizontal parts, preferably use XB387.
- For larger surfaces, preferably use XK205 or XK206.
- 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.
- Dry spray spots in the clear can be worked off with AK350 at very low spray pressure. This should be done at the latest 5 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: 150 cp
 Theoretical coverage: 9.4 m²/l at recommended DFT - ready-to-spray
 Directive 2004/42/EC: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Products	Packages (l)	Shelf life at 20°C (year)
3750S	1 - 5	2
XK203	1 - 5	2
XK205	1 - 5	2
XK206	1 - 5	2
431R	1	1
XB387	1 - 5	2

Safety

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



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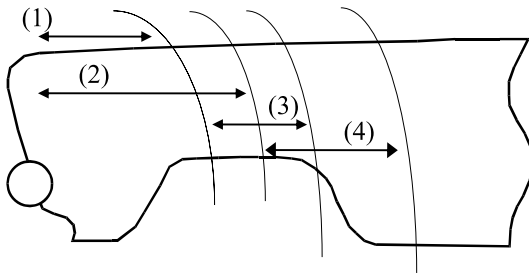
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REPAIR SYSTEMS

Spot and panel repair: AK350 Fade-out Thinner method

- ← Apply 1 coat of 3750S over the basecoat, extending into the area surrounding the spot.
- ↑ Apply a 2nd coat of 3750S, extending further into the area surrounding the spot.
- Smoothen out the fade-out area with AK350 within 5 min maximum.
- ↓ Optionally extend the fade-out area with AK350 within 5 min maximum.
- ! 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.