

676S

ULTRA PRODUCTIVE CLEAR

Description

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

Products

676S	Ultra Productive Clear
256S	Activator Fast
AK260	High Solids Activator
AB380	Basecoat Thinner
AB385	Hi-Temp Thinner
XB383	Standard Thinner
XB387	High Temperature Thinner

Properties

- Gives very fast air drying and allows short flash times between coats and bake.
- The fast dustfree 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.

Substrates

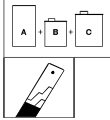








- Centari® 600, Centari® 6000 basecoats, Cromax® Waterborne Basecoat.
- all OEM finishes cleaned and sanded (not recommended on thermoplastic acrylic finishes)



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PRODUCT PREPARATION

	Mixing ratio 676S AK260 256S AB380/XB383 AB385/XB387	Fast (15-20°C)		Standard (20-25°C)		High temp. (> 30°C)			
		Volume	Weight	Volume	Weight	Volume	Weight		
		3	100	3	100	3	100		
		/	/	1	35	1	35		
		1	35	/	/	/	/		
		0.6	18	0.6	18	/	/		
		/	/	/	/	0.6	18		
VOC		514-531 g/li							
	Pot life at 20°C AK260 256S	4 h							
		3 h							
	Spray viscosity at 20°C DIN 4 FORD 4 AFNOR 4	14-16 s							
		14-16 s							
		15-18 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 Suction feed HVLP Pressure feed Spot repair	3-4 bar							
		3-4 bar							
		0.7 bar at nozzle							
		3-4 bar							
		2.5-3 bar							
	Number of coats	2							
	Flash time	5 min. between coats.							
		5 min. before bake.							
DFT		45-65 µ							
	Drying With AK260 Dustfree Dry to handle Tapefree	15°C		20°C		30°C		20 min. x 60°C	
		15 min.		13 min.		10 min.		imm.	
		7 h		7 h		6 h		30 min.	
		16 h		14 h		12 h		50 min.	
	With 256S Dustfree Dry to handle Tapefree	15°C		20°C		30°C		15 min. x 60°C	
		13 min.		11 min.		8 min.		imm.	
		4 h		4 h		3 h		imm.	
		14 h		12 h		10 h		15 min.	
	IR drying* Flash time Distance Half power Full power	5 min.				* guideline for short/medium wave IR equipment			
		80 cm							
		5 min.							
		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, Centari® 6000 or Cromax®.

Clearcoat application

When Centari® 600, Centari® 6000 or Cromax® is completely flat, apply 676S in 2 coats with 5 min. flash between coats.

Chemical resistance

When fully cured, 676S 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 tapefree time.

Product data

Package viscosity : 130 cp
Theoretical coverage : 6.6-7.1 m²/li at recommended DFT - ready-to-spray

Products	Packages (li)	Storability at 20°C (year)
676S	1 - 5	2
256S	1 - 5	2
AK260	1 - 5	2
AB380	1 - 5 - 20	2
AB385	5	2
XB383	1 - 5 - 20	2
XB387	5	2

Remarks

- 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.
- 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 (to be avoided on horizontal parts).
- Over Cromax[®] basecoat we recommend the use of XB383 or XB387 to reduce 676S. This will provide a smoother application over the waterborne basecoat and make the clear even less sensitive for adverse spray conditions.
- 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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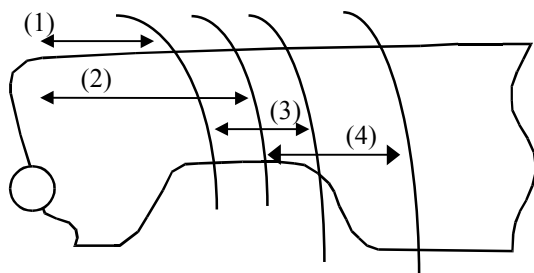
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REPAIR SYSTEMS

Spot and panel repair : AK350 Centari® Blending Thinner method

When spot repairing with Centari® 600, Centari® 6000 or Cromax®, 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 676S over the basecoat, extending into the area surrounding the spot.
 - ② Apply a 2nd coat of 676S, extending further into the area surrounding the spot.
 - ③ OPTIONAL : reduce 1 part of 676S with 1 part AK350 and apply 1 coat of reduced 676S 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 : 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.