

3050S

27.08.2014

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

- Cromax solventborne & waterborne Basecoats.
- All cleaned and sanded OEM finishes (not recommended on thermoplastic acrylic finishes).

TECHNICAL DATA SHEET











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PRODUCT PREPARATION









| | | | | | | |
|--|--------------------------------|--|--------------------|----------------------|-----------------|--|
|  | Mixing ratio | | Spot repair | | Standard | |
| | | | Volume | Weight | Volume | Weight |
| | | 3050S | 3 | 100 | 3 | 100 |
| | | 256S | 1 | 37 | - | - |
| | | AK260 | - | - | 1 | 37 |
| | VOC | 256S | 562 g/l | | | |
| | | AK260 | 548 g/l | | | |
|  | Pot life at 20°C | 256S | 3 hr | | | |
| | | AK260 | 4 hr | | | |
|  | Spray viscosity at 20°C | DIN 4 | 16-18 s | | | |
| | | FORD 4 | 16-18 s | | | |
|  | Spray equipment | Compliant guns | Fluid tip | Distance | Pressure | |
| | | | 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 | | | | |
| | | Conventional guns | | | | |
| | | Gravity feed | 1.4-1.6 mm | 15-20 cm | 2-2.5 bar | |
| | | Suction feed | 1.6-1.8 mm | 15-20 cm | 2-2.5 bar | |
| | | Pressure feed | 1.0-1.2 mm | 15-20 cm | 2-2.5 bar | |
|  | Number of coats | 2 | | | | |
|  | Flash time | 5 min between coats. 5 min before bake. | | | | |
| | DFT | 45-65 µm | | | | |
|  | Drying | | 256S | | AK260 | |
| | | | 20°C | 20 min x 60°C | 20°C | 30 min x 60°C |
| | | Dust-free | 15 min | imm. | 20 min | imm. |
| | | Dry to handle | 2 hr | imm. | 6 hr | imm. |
| | | Tape-free | 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. | | | | | | |
| 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 (CON'D)

|  | Mixing ratio | Spot and panel | | Standard | | High temperature | |
|--|--------------------------------|--|------------------|----------------------|--|----------------------|----------------------|
| | | Volume | Weight | Volume | Weight | Volume | Weight |
| | 3050S | 4 | 100 | 4 | 100 | 4 | 100 |
| | XK203 | 1 | 27 | - | - | - | - |
| | XK205 | - | - | 1 | 27 | - | - |
| | XK206 | - | - | - | - | 1 | 27 |
| | VOC | 526 g/l | | | | | |
|  | Pot life at 20°C | XK203 | 2 hr | | | | |
| | | XK205 | 2 hr 45 min | | | | |
| | | XK206 | 3 hr 15 min | | | | |
|  | Spray viscosity at 20°C | DIN 4 | 16-18 s | | | | |
| | | FORD 4 | 17-19 s | | | | |
|  | Spray equipment | Compliant guns | Fluid tip | Distance | Pressure | | |
| | | 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 | | | |
| | | Conventional guns | | | | | |
| | | Gravity feed | 1.4-1.6 mm | 15-20 cm | 2-2.5 bar | | |
| | | Suction feed | 1.6-1.8 mm | 15-20 cm | 2-2.5 bar | | |
| | | Pressure feed | 1.0-1.2 mm | 15-20 cm | 2-2.5 bar | | |
|  | Number of coats | 2 | | | | | |
|  | Flash time | 5 min between coats. 5 min before bake. | | | | | |
| | DFT | 45-65 µm | | | | | |
|  | Drying | | XK203 | | XK205 | | XK206 |
| | | | 20°C | 20 min x 60°C | 20°C | 30 min x 60°C | 40 min x 60°C |
| | Dust-free | | 50 min | imm. | 1 hr | imm. | imm. |
| | Dry to handle | | 3 hr 30 min | imm. | 6 hr | imm. | 1 hr |
| | Tape-free | | 12 hr | 30 min | O.N. | 30 min | 2 hr |
|  | IR drying* | Flash time | 5 min | | | | |
| | | Distance | 80 cm | | | | |
| | | Half power | 5 min | | | | |
| | | Full power | 15-20 min | | | | |

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SURFACE PREPARATION

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

CLEARCOAT APPLICATION

When the 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 solventborne gunwash.

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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

SAFETY

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

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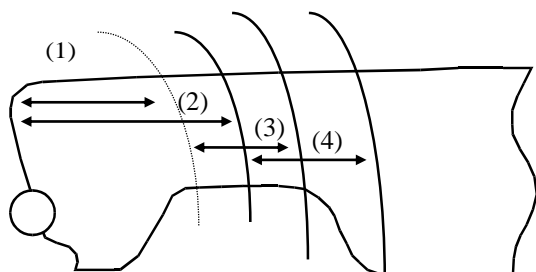
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OVERALL REPAIR

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.

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All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.

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