

## 3750S - 3760S

27.08.2014

### ULTRA PRODUCTIVE VOC CLEAR SYSTEM

#### DESCRIPTION

A Productive Clear System that can be used for a wide range of repairs under various conditions. 2-component fast dry clear, to be used in clear over base system. Composition based on acrylic polyurethane copolymer. System derived from Hyper Cure™ technology.

#### PRODUCTS

3750S	Ultra Productive VOC Clear
3760S	Ultra Productive VOC Hi-Temp Clear
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
431R	Varispeed Ultra
XB387	HI-Temp Thinner
3989S	Retarder

#### PROPERTIES

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

#### SUBSTRATES







- Basecoats.
- All cleaned and sanded OEM and cured repair finishes (not recommended on thermoplastic acrylic finishes).

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#### PRODUCT PREPARATION (Fast)

	Mixing ratio	Spot and panel															
		18°C - 30°C						25°C - 38°C									
		V.	W.	V.	W.	V.	W.	V.	W.	V.	W.	V.	W.				
	3750S	3	100	3	100	3	100	-	-	-	-	-	-				
	3760S	-	-	-	-	-	-	3	100	3	100	3	100				
	XK203	1	36	-	-	1	36	1	36	-	-	1	36				
	XK205	-	-	1	36	-	-	-	-	1	36	-	-				
	431R	0.4	12	0.4	12	-	-	0.4	12	0.4	12	-	-				
	XB387	-	-	-	-	0.4	12	-	-	-	-	0.4	12				
<b>VOC</b>		420 g/l															
	<b>Pot life at 20°C</b>	3750S						3760S									
		With 431R 45 min						With XB387 60 min									
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b>		19-22 s		<b>FORD 4</b>		20-23 s									
	<b>Spray equipment</b>	<b>Compliant guns</b>		<b>Fluid tip</b>		<b>Distance</b>		<b>Pressure</b>									
		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											
		<b>Conventional guns</b>															
		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											
<b>Number of coats</b>		1,5 (2)															
<b>Flash time</b>		0-5 min between coats. 0-5 min before bake (depends on spray booth).															
<b>DFT</b>		40-60 µm															
	<b>Drying</b>	<b>With 3750S</b>		<b>XK203 / 431R</b>		<b>XK205 / 431R</b>		<b>XK203 / XB387</b>									
				20°C		15 min x 60°C		20°C		15 min x 60°C		20 min x 50°C		20°C		15 min x 60°C	
				20 min		imm.		20 min		imm.		30 min		imm.			
		<b>Dust-free</b>		15 min		imm.		20 min		imm.		30 min		imm.			
		<b>DTH</b>		2 hr		imm.		2 hr 30'		imm.		3 hr		imm.			
		<b>Tape-free</b>		6 hr		15 min		6 hr 30'		20 min		8 hr		30 min			
		<b>With 3760S</b>		<b>XK203 / 431R</b>		<b>XK205 / 431R</b>		<b>XK203 / XB387</b>									
				28°C		15 min x 60°C		28°C		15 min x 60°C		28°C		15 min x 60°C			
				15 min		imm.		20 min		imm.		30 min		imm.			
		<b>Dust-free</b>		15 min		imm.		20 min		imm.		30 min		imm.			
<b>DTH</b>		2 hr		imm.		2 hr 30'		imm.		3 hr		imm.					
<b>Tape-free</b>		6 hr		20 min		6 hr 30'		30 min		8 hr		40 min					
	<b>IR drying*</b>	<b>Dark</b>		<b>Light</b>		<b>Dark</b>		<b>Light</b>		<b>Dark</b>		<b>Light</b>					
		<b>Flash time</b>		4 min		4 min		4 min		4 min		4 min		4 min			
		<b>Distance</b>		50 cm		50 cm		50 cm		50 cm		50 cm		50 cm			
		<b>Half power</b>		6 min		6 min		6 min		6 min		6 min		7 min			
		<b>Full power</b>		3 min		6 min		4 min		7 min		5 min		7 min			

\* Guideline for short/medium wave IR equipment.

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# TECHNICAL DATA SHEET



## 3750S - 3760S

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### ULTRA PRODUCTIVE VOC CLEAR SYSTEM

#### PRODUCT PREPARATION (STANDARD)

	<b>Mixing ratio</b>	3750S 3760S XK205 / XK206 XB387	<b>Large surface</b>			
			<b>18°C - 28°C</b>		<b>25°C - 38°C</b>	
			Volume	Weight	Volume	Weight
			3	100	-	-
		-	-	3	100	
		1	36	1	36	
		0.4	12	0.4	12	
	<b>VOC</b>	420 g/l				
	<b>Pot life at 20°C</b>	With XK205 With XK206	3750S		3760S	
			60 min		90 min	
			70 min		90 min	
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b>	19-22 s 20-23 s			
	<b>Spray equipment</b>	<b>Compliant guns</b> Gravity feed Suction feed Pressure feed  <b>Conventional guns</b> Gravity feed Suction feed Pressure feed	<b>Fluid tip</b>		<b>Distance</b>	<b>Pressure</b>
			1.3-1.5 mm		10-15 cm	According to supplier's specifications
			1.5-1.6 mm		10-15 cm	
			1.0-1.2 mm		10-15 cm	
			1.4-1.6 mm		15-20 cm	2-2.5 bar
			1.6-1.8 mm		15-20 cm	2-2.5 bar
1.0-1.2 mm		15-20 cm	2-2.5 bar			
	<b>Number of coats</b>	1,5 (2)				
	<b>Flash time</b>	0-5 min between coats. 0-5 min before bake (depends on spray booth).				
	<b>DFT</b>	40-60 µm				
	<b>Drying</b>	<b>With 3750S</b>	<b>XK205</b>		<b>XK206</b>	
			<b>20°C</b>		<b>25 min x 60°C</b>	<b>30 min x 60°C</b>
			Dust-free	50 min	imm	imm
			Dry to handle	5 hr 30 min	imm	30 min
		Tape-free	O.N.	1 hr 30 min	2 hr	
		<b>With 3760S</b>	<b>XK205</b>		<b>XK206</b>	
			<b>28°C</b>		<b>25 min x 60°C</b>	<b>30 min x 60°C</b>
			Dust-free	50 min	imm	imm
Dry to handle	6 hr		15 min	30 min		
Tape-free	O.N.	2 hr	2 hr 30 min			
	<b>IR drying*</b>	<b>Flash time</b> <b>Distance</b> <b>Half power</b> <b>Full power</b>	<b>All colours</b>		<b>All colours</b>	
			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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




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### ULTRA PRODUCTIVE VOC CLEAR SYSTEM

#### PRODUCT PREPARATION (SLOW)

	Mixing ratio	<b>Overall</b>								
		<b>18°C - 22°C</b>		<b>21°C - 25°C</b>		<b>21°C - 30°C</b>		<b>28°C - 38°C</b>		
		V	W	V	W	V	W	V	W	
		3750S	100	3	100	-	-	-	-	
		3760S	-	-	-	-	3	100	3	100
		XK206	36	1	36	1	36	1	36	
		XB387	12	-	-	0.4	12	-	-	
		3989S	-	-	0.4	12	-	-	12	
<b>VOC</b>		420 g/l								
	<b>Pot life at 20°C</b>	3750S				3760S				
		With XB387 70 min				90 min				
		With 3989S 60 min				90 min				
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	19-22 s							
		<b>FORD 4</b>	20-23 s							
		<b>AFNOR 4</b>	22-25 s							
	<b>Spray equipment</b>	<b>Compliant guns</b>		<b>Fluid tip</b>	<b>Distance</b>		<b>Pressure</b>			
		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					
		<b>Conventional guns</b>		1.4-1.6 mm		15-20 cm		2-2.5 bar		
		Gravity feed								
		Suction feed								
		Pressure feed		1.0-1.2 mm		15-20 cm		2-2.5 bar		

\* Guideline for short/medium wave IR equipment.  
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### ULTRA PRODUCTIVE VOC CLEAR SYSTEM

#### 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 waterborne basecoat is completely flat, apply 3750S/3760S in 1 light coat immediately followed by a full coat with 0-3 min flash between coats or 2 coats with 5-10 min flash between coats.

#### CHEMICAL RESISTANCE

When fully cured, 3750S / 3760S 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

- 431R is recommended for spot and panel repair only.
- For horizontal parts, preferably use XB387.
- 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:	3750S : 150 cp 3760S : 145 cp
Theoretical coverage:	9.4 m <sup>2</sup> /l at recommended DFT - ready-to-spray
Directive 2004/42/EC:	2004/42/IIB(d) (420)420: 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.

#### SAFETY

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

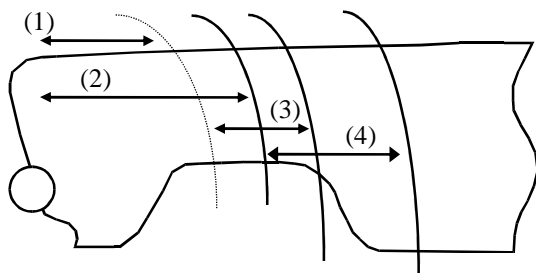
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### ULTRA PRODUCTIVE VOC CLEAR SYSTEM

#### SPOT AND PANEL REPAIR: AK350 FADE-OUT THINNER METHOD

- (1) Apply 1 coat of 3750S / 3760S over the basecoat, extending into the area surrounding the spot.
  - (2) Apply a 2<sup>nd</sup> coat of 3750S / 3760S, extending further into the area surrounding the spot.
  - (3) Smoothen out the fade-out area with AK350 within 5 min maximum.
  - (4) 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.

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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