

380S

27.08.2014

1K ACRYLIC LACQUER CLEAR®

DESCRIPTION

1-component acrylic lacquer clear for use over Lucite® 400 Acrylic Lacquer metallic colours to repair OEM base/clear finishes.
Composition based on acrylic resin.

PRODUCTS

380S	1K Acrylic Lacquer Clear
3608S	Thinner

PROPERTIES

- Can be applied over Lucite® 400 Acrylic Lacquer metallic colours to repair OEM base/clear finishes or to be used as an acrylic clear. 380S makes base/clear repairs easy with a lacquer system that dries fast.

SUBSTRATES










- Lucite 400®, Centari® 600, Centari® 6000 basecoats.
- All cleaned and sanded OEM finishes.

380S

27.08.2014

1K ACRYLIC LACQUER CLEAR®

PRODUCT PREPARATION

 	Mixing ratio		Fast (15 – 20°C)		Standard (20 – 25°C)		High temperature (>30°C)	
		380S 3608S	Volume 1 1.5 - 2	Weight 100 150 - 200	Volume 1 1.5 - 2	Weight 100 150 - 200	Volume 1 -	Weight 100 -
	VOC	561 – 583 g/l						
	Pot life at 20°C	Not applicable						
	Spray viscosity at 20°C	DIN 4 FORD 4	14 – 15 s 14 – 15 s					
	Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip			Distance		
			1.2 – 1.5 mm	1.6 – 1.8 mm	1.3 – 1.5 mm	1.0 – 1.2 mm	15 – 20 cm	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 - 4						
	Flash time	10 – 15 min between coats						
	DFT	45 – 50 µm						
	Drying at 20°C	Dust free Tack free Dry to handle Tape free	15 – 20 min 50 min 2 h 30 min 4 h					
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.								

380S

27.08.2014

1K ACRYLIC LACQUER CLEAR®

SURFACE PREPARATION

The entire panel has to be carefully prepared before basecoat application:

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. Wet sand with P1200 or treat with 600S the remaining surface of the panel.
5. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
6. Tack rag.
7. Apply basecoat Lucite® 400, Centari® 600 or Centari® 6000

CLEARCOAT APPLICATION

When Lucite® 400, Centari® 600 or Centari® 6000 is completely flat, apply 380S in 2 to 4 coats with 10-15 min flash between coats.

POLISHING

After overnight dry, polish with a non silicone containing polishing compound or a non silicone containing final glaze.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

RECOATABILITY

At any time after tape-free time. After 24 hr, scuff sanding is required.

PRODUCT DATA

Package viscosity: 95s Ford 4
Theoretical coverage: 2 - 3 m²/l at recommended DFT - ready-to-spray.

SAFETY

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

380S

27.08.2014

1K ACRYLIC LACQUER CLEAR®

REMARKS

- Avoid excessive film build as cracking could result as well as soft films.
- Flash time before clearcoating is 30 min for metallics. For solid colours allow more time.
- Gloss can be lowered using 4531S Universal Flattening Base. Add 20 % maximum by volume to already thinned clear (see specific TDS).
- Material has to be at room temperature (18-25°C) before use.

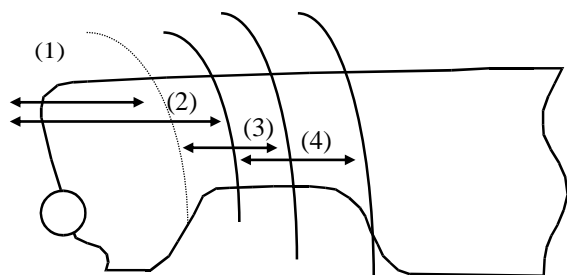
OVERALL REPAIR

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:

When spot repairing with Lucite® 400, 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+2) Apply 2 to 4 coats of 380S over the basecoat, extending into the area surrounding the spot.
 - (3) OPTIONAL: Reduce 1 part of 380S with with 1 part 3608 and apply 1 coat of reduced 380S over the blend-out area.
 - (4) Blend in the fade-out area immediately with pure 3608S.
- ! Surface should be carefully and correctly prepared before the basecoat application.
See recommended use, paragraph surface preparation.
- !



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.

380S

27.08.2014

1K ACRYLIC LACQUER CLEAR®

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.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.