DuPont Refinish
More than just paint ...

Technical Data Sheet

Effective July 1, 2011

CC6400

STANDARD VOC CLEAR

Description

2-component clear based on Low Emission resin technology, to be used in clear over base system.
Composition based on acrylic copolymer and a unique, patented "star" polymer technology.

Products

CC6400	Standard VOC Clear
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
AZ9100	Performance Agent

Properties

- Combines very easy application with little sagging risks.
- Gives a smooth, high build finish.
- Has an efficient drying performance.
- Has excellent mar, chemical and weather resistance.
- Can be used for spot, panel and overall 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).

This Technical Data Sheet supersedes all previous issues.

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PRODUCT PREPARATION

	Mixing ratio		**Spot and panel**		**Standard**		**High temperature**	
			Volume	Weight	Volume	Weight	Volume	Weight
		CC6400	3	100	3	100	3	100
		XK203	1	36	-	-	-	-
		XK205	-	-	1	36	-	-
		XK206	-	-	-	-	1	36
		AZ9100	0.2	6	0.2	6	0.2	6
	VOC	420 g/L						
	Pot life at 20°C	XK203	1 hr					
		XK205	1 hr 15 min					
		XK206	1 hr 15 min					
	Spray viscosity at 20°C	**DIN 4**	19-22 s					
		FORD 4	20-23 s					
	Spray equipment		**Fluid tip**		**Distance**		**Pressure**	
		Conventional guns						
		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 (HVLP/HTE)						
		Gravity feed	1.2-1.4 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	2 (1.5)						
	Flash time	5-10 min between coats when applying 2 coats 0-3 min between coats when applying 1.5 coats 0-5 min before bake						
	DFT	50-80 µm						
	Drying		**XK203**		**XK205**		**XK206**	
			25 min x 60°C		**30 min x 60°C**		**35 min x 60°C**	
		Dust-free	imm.		imm.		imm.	
		Dry to handle	10 min		10 min		25 min	
		Tape-free	1 hr		1 hr		2 hr	
	IR drying*	Flash time	5 min		* Guideline for short/medium wave IR equipment.			
		Distance	80 cm					
		Half power	5 min					
		Full power	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

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

Clearcoat application

When the DuPont Refinish basecoat is completely flat, apply CC6400 in 2 coats with 5-10 min flash between coats or apply 1 light coat immediately followed by a full coat with 0-3 min flash between coats.

Chemical resistance

When fully cured, CC6400 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

- XK203 is recommended for spot repair only and not for use on horizontal parts.
- 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 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 5 min after clear application and should be avoided on horizontal parts.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

Product data

Package viscosity:	95-115 cp
Theoretical coverage:	6-10 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)	Density (kg/L)
CC6400	5	4	0.984
XK203	1	3	1.060
XK205	1 - 5	3	1.059
XK206	1	3	1.078
AZ9100	1	2	0.829

Safety

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

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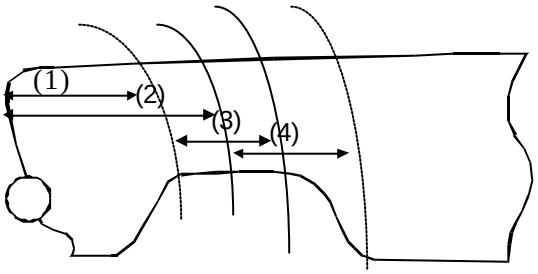
REPAIR SYSTEMS

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 CC6400 over the basecoat, extending into the area surrounding the spot.
(2) Apply a 2nd coat of CC6400, extending further into the area surrounding the spot.
(3) OPTIONAL: reduce 1 part of activated ready-for-use CC6400 with 1 part AK350 and apply 1 coat of reduced CC6400 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 after complete hardening of the repair.