

## G3-7800SX

09.02.2015

### 2K SUPER FAST DRY CLEAR

#### DESCRIPTION

2K super fast dry clear, to be used in clear over base system.  
Composition based on acrylic polyurethane copolymer and on Hyper Cure™ technology.

#### PRODUCTS

G3-7800SX	2K Super Fast Dry Clear®
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
256S	Activator Fast
255MS	Universal Fast Activator
AK260	High Solids Activator
AK261	High Solids Activator Slow
AB380	Low Temperature Thinner
AB385	Standard Thinner
XB387	High Temperature Thinner

#### PROPERTIES

- Gives super fast air drying and no flash time required between coats.
- The fast dust-free time prevents the surface from air-borne contamination.
- Has excellent polishability
- Increases productivity in air dry without sacrificing appearance.
- Can be used for spot and panel repair.

#### SUBSTRATES

- Suitable Cromax basecoats.
- All cleaned and sanded OEM finishes (not recommended on thermoplastic acrylic finishes).

#### ACTIVATOR AND THINNER SELECTION GUIDE

Temperature	18-24°C	24-30°C	>30°C low humidity	>30°C high humidity	>30°C high humidity
<b>Drying</b>	Air dry	Air dry	Air dry	Air dry	10min @ 50°C
<b>Activator</b>	XK203/256S/255MS	XK203/256S/255MS	XK203/256S XK205/AK260/255MS	XK206/AK261	XK206/AK261
<b>Thinner</b>	AB380 (No Thinner with 255MS)	AB385(No Thinner with 255MS)	XB387 (No Thinner with 255MS)	XB387	XB387



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### PRODUCT PREPARATION

	<b>Mixing ratio</b>		<b>Volume</b>		<b>Weight</b>	
		<b>G3-7800SX</b> <b>XK203/XK205/XK206</b> <b>AB380/AB385/XB387</b>		4	100	
				1	28.5	
				1	23.7	
		or				
<b>G3-7800SX</b> <b>256S/AK260/AK261</b> <b>AB380/AB385/XB387</b>		3	100			
		1	36.6			
	0.5	15.8				
or						
<b>G3-7800SX</b> <b>255MS</b>		2	100			
		1	48.8			
<b>VOC</b>		<b>582.06 g/L</b>				
	<b>Pot life at 20°C</b>	1.5 hours				
	<b>Spray viscosity at 25°C</b>	<b>DIN 4</b>	12-13 s			
		<b>FORD 4</b>	13-14 s			
	<b>Spray equipment</b>	<b>Conventional Guns</b>		<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>
			Gravity feed	1.3-1.4 mm	15-20 cm	1.8-2 bar
			Suction feed	1.5-1.6 mm	15-20 cm	1.8-2 bar
		Pressure Feed	0.9-1.0 mm	15-20 cm	1.8-2 bar	
		<b>Compliant Guns (HVLP/THE)</b>				
			Gravity feed	1.2-1.3 mm	10-15 cm	According to supplier's specification
Suction feed	1.4-1.5 mm		10-15 cm			
Pressure Feed	0.9-1.0 mm	10-15 cm				
	<b>Number of coats</b>	1.5-2				
	<b>Flash time</b>	No flash time required between coats				
	<b>DFT</b>	40-50 µm				
	<b>Drying</b>	<b>Dust-free</b> <b>Dry to polish</b> <b>Tape-free</b>	<b>@ 25°C</b>		<b>10 min @ 50°C</b>	
			8-12 min		imm.	
			25-35 min		5-15 min	
			3 h		2 h	

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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.

#### SURFACE PREPARATION

- Clean surface with water and soap. Rinse and dry.
- Degrease with a correct Axalta preparatory cleaner/degreaser. Wipe dry with a clean cloth.
- Repair according to damage.
- Clean with a correct Axalta final cleaner. Wipe dry with a clean cloth.
- Tack rag.
- If needed, apply an Axalta basecoat.

#### CLEARCOAT APPLICATION

When the basecoat is completely flat, apply 1.5-2 coats of G3-7800SX without any flash time between coats.

#### CHEMICAL RESISTANCE

When fully cured, G3-7800SX is resistant to short exposure to 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       |

#### RECOATABILITY

At any time, it's easy to be coated after tape-free time. Scuff sanding is required.

#### REMARKS

- Close can of activator tightly after use, as this product will react with humid air and water and lose its hardening effect.
- Material must be at room temperature (18-25C) before use.
- Unused activated material must be discarded.

#### SAFETY

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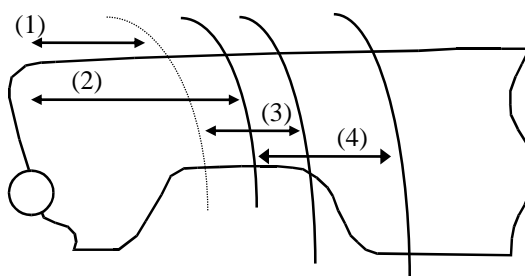
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### 2K SUPER FAST DRY CLEAR

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

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

- (1) Apply 1<sup>st</sup> coat of G3-7800SX over the basecoat extending into surrounding area.
- (2) Extend 2<sup>nd</sup> coat of G3-7800SX beyond the previous one.
- (3) Smoothen out the fade-out area with AK350 within 3 min max.
- (4) Optionally, extend the fade-out area with AK350 within 3 min max.



- Surface should be carefully and correctly prepared before application of the basecoat.
- 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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