TECHNICAL DATA SHEET

CC6400

07.02.2016

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
AZ9101	Performance Agent Slow

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

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

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PRODUCT PREPARATION

		Spot and panel		Standard		High temperature	
Mixing ratio		Volume	Weight	Volume	Weight	Volume	Weight
	CC6400	3	100	3	100	3	100
	XK203	1	36	-	-	-	-
	XK205	-	-	1	36	-	-
	XK206	-	-	-	-	1	36
	AZ9100/AZ9101	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**	
	Compliant guns						
	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			
	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		2-2.5bar	
	Pressure feed	1.0-1.2 mm		15-20 cm		2-2.5bar	
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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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 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 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 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:	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 Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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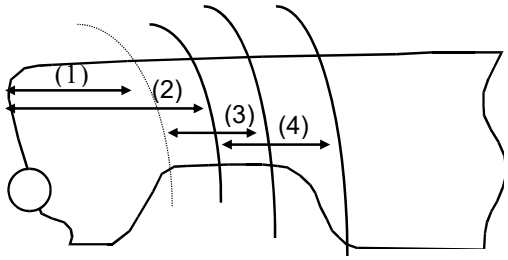
OVERALL REPAIR

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 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) 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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