

696S

27.08.2014

MS II CLEAR

DESCRIPTION

2-component clear based on high build resin technology, to be used in clear over base system. Composition based on acrylic copolymer.

PRODUCTS

696S	MS II Clear®
256S	Activator Fast
AK260	High Solids Activator
125S	Standard Activator
255MS	Universal Fast Activator

PROPERTIES

- Combines very easy application with little sagging risks and short drying time.
- Provides excellent appearance and very fast drying properties.
- Has excellent mar, chemical and weather resistance and results in a high gloss, mirror like, lasting finish.
- Can be used for spot, panel and overall repair.

SUBSTRATES









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

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PRODUCT PREPARATION

 Mixing		Large surface		Spot and Panel		Small & Medium	
		Volume	Weight	Volume	Weight	Volume	Weight
	696S	3	100	3	100	2	100
	AK260	1	35	-	-	-	-
	256S	-	-	1	35	-	-
	125S / 255MS	-	-	-	-	1	50
VOC	AK260	529 g/l					
	256S	547 g/l					
	125S / 255MS	630 g/l					
 Pot life at 20°C	AK260	4 h					
	256S	3 h					
	125S	4 h					
	255MS	5 h					
 Spray Viscosity at 20°C	DIN 4	16 – 18 s					
	FORD 4	16 – 18 s					
 Spray equipment		Fluid tip		Distance		Pressure	
	Conv. 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 (HVLV / THE)						
	Gravity feed	1.3 – 1.5 mm		10 – 15 cm		According to supplier's specification	
	Suction feed	1.5 – 1.6 mm		10 – 15 cm			
	Pressure feed	1.0 – 1.2 mm		10 – 15 cm			
 Number of coats	2						
 Flash time at 20°C	5 min between coats 5 min before bake						
DFT	45 – 65 µm						
 Drying		AK260		256S		125S / 255MS	
		20°C	30'@60°C	20°C	20'@60°C	20°C	30'@60°C
	Dust free	20 min	imm.	15 min	imm.	30 min	imm.
	Dry to handle	6 h	imm.	2 h	imm.	6 h	30 min
	Tape free	O.N.	30 min	6 h	30 min	O.N.	45 min
 IR Drying *	Flash time	5 min					
	Distance	80 cm					
	Half power	5 min					
	Full power	15 – 20 min					
* Guideline for short / medium wave IR equipment							
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 Cromax solventborne basecoat.

CLEARCOAT APPLICATION

When the basecoat is completely flat, apply 696S in 2 coats with 5 min flash between coats.

CHEMICAL RESISTANCE

When fully cured, 696S 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

- If necessary for minor viscosity adjustments, use Centari® basecoat thinners (maximum 5 %).
- 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.
- Use of 256S can influence the appearance. Baking at 80°C is not recommended.
- To spray interiors, use of 431R or 256S 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 10 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.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Package viscosity: 40 - 50 cp

Theoretical coverage: 7.7 m²/l at recommended DFT - ready-to-spray.

SAFETY

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

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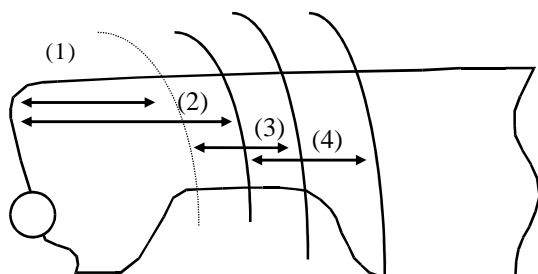
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OVERALL REPAIR

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 696S over the basecoat, extending into the area surrounding the spot.
 - (2) Apply a 2nd coat of 696S, extending further into the area surrounding the spot.
 - (3) OPTIONAL: Reduce 1 part of activated ready-for-use 696S with 1 part AK350 and apply 1 coat of reduced 696S over the fade-out area.
 - (4) Blend in 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 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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