



381S

ACRYLIC 1K CLEAR LACQUER®



PRODUCT DESCRIPTION

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

FEATURES

- 01** Provides a high gloss finish with fast drying.
- 02** Excellent adhesion and durability.
- 03** Easy to polish.

TECHNICAL DATASHEET

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Product preparation



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Lucite 400®, Centari® 600 and Centari® 6000 basecoats.

All cleaned and sanded OEM finishes.

Can be applied over Lucite® 400 Acrylic Lacquer metallic colours to repair OEM base/clear finishes or to be used as an acrylic clear. 381S makes base/clear repairs easy with a lacquer system that dries fast.

Mixing ratio	381S 3608S/AB380 AB385	Fast (15 – 20°C)		Standard (20 – 25°C)		High temperature (>30°C)	
		Volume	Weight	Volume	Weight	Volume	Weight
		1	100	1	100	1	100
		1.5 - 2	150 - 200	1.5 - 2	150 - 200	-	-
						2	200
Pot life at 20°C	Not applicable						
Spray viscosity at 20°C	DIN 4 FORD 4	13 – 15 s 13 – 15 s					
Spray equipment	Gravity feed Suction feed HVL P Pressure feed	Fluid tip		Distance			
		1.2 – 1.5 mm		15 – 20 cm			
		1.6 – 1.8 mm		15 – 20 cm			
		1.3 – 1.5 mm		10 – 15 cm			
		1.0 – 1.2 mm		15 – 20 cm			
Spray pressure	Gravity feed Suction feed HVL P Pressure feed Spot repair	2 – 2.5 bar 2 – 2.5 bar 0.7 bar at nozzle 3 – 4 <u>bar</u> 1 – 1.5 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.							



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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. Wet sand the remaining surface of the panel with P1200.
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 381S in 2 to 4 coats with 10-15 minute 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 solvent borne gunwash.

Recoatability

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

Product Data

Package viscosity:	>180s DIN 4, @ 20°C
Theoretical coverage:	5 m ² /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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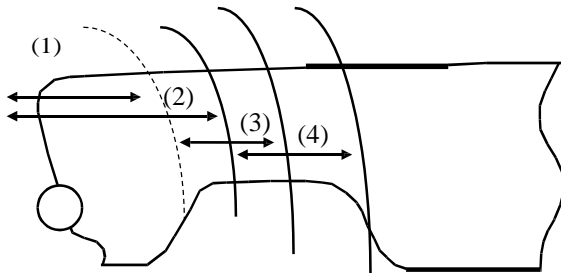
Overall Repair

Pay attention to the application method. Spray procedure has to ensure proper overspray melt-in which is achieved within 2 minutes 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 381S over the basecoat, extending into the area surrounding the spot.
- (3) OPTIONAL: Reduce 1 part of 381S with 1 part 3608S and apply 1 coat of reduced 381S 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.

Products

381S Acrylic 1K Clear Lacquer
3608S Lacquer Thinner
AB380 Standard Thinner
AB385 High Temp Thinner



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Remarks

- Avoid excessive film build, as cracking could result as well as soft films.
- Flash time before clearcoating is 30 minutes 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.

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All other products referred to in the refinish build up are from our Cromax product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Cromax product range, unless explicitly indicated otherwise.

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