

# 2K Clears

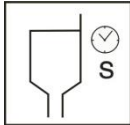
## 1060S Premium Crystal Clear

### Product Description

Premium crystal clears for application ranging from spot repair, panel repair to overall refinish.

### Pre-treatment

1060S Premium Crystal Clear is suitable to be applied on top of a clean and dust-free basecoat. See TDS of basecoat for other preparation of substrate.

|                                                                                     |                                          |                                                                                                                                                                                                                                                                                                                                                                                                      |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
|-------------------------------------------------------------------------------------|------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|--|--|----------------------------|-------------------------|-------------|-----------------|------------------------------------|---------------------------|--------------------------|----------|-----------------|------------------------|----------|---------|
|    | <b>Mixing Ratio</b>                      | <b>1060S Clear</b> 100 (vol)<br><b>AK260 Hardener</b> 50 (vol)<br><b>AK321 Thinner</b> 5-15 (vol)<br>Mix well and strain before application.<br>Note: AK2601/AK3211 is for temperatures between 5°C–15°C<br>AK2602/AK3212 is for temperatures between 15°C–25°C<br>AK2603/AK3213 is for temperatures above 25°C<br>AK3214 Thinner is for temperatures above 35°C or when refinishing large surfaces. |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
|   | <b>Spray Viscosity</b><br><b>Potlife</b> | 18 to 26 seconds DIN 4 cup at 25°C<br>4 hours at 25°C; 3 hours at 35°C                                                                                                                                                                                                                                                                                                                               |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
|  | <b>Spray Guns</b>                        | <table><tr><td>HVLP gravity-feed spraygun</td><td>1.2–1.3mm</td><td>1.8–2.0 bar</td><td>10–15 cm</td></tr><tr><td>Conventional gravity-feed spraygun</td><td>1.3–1.6mm</td><td>3.0–4.0 bar</td><td>15–20 cm</td></tr></table>                                                                                                                                                                        |          |  |  | HVLP gravity-feed spraygun | 1.2–1.3mm               | 1.8–2.0 bar | 10–15 cm        | Conventional gravity-feed spraygun | 1.3–1.6mm                 | 3.0–4.0 bar              | 15–20 cm |                 |                        |          |         |
| HVLP gravity-feed spraygun                                                          | 1.2–1.3mm                                | 1.8–2.0 bar                                                                                                                                                                                                                                                                                                                                                                                          | 10–15 cm |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
| Conventional gravity-feed spraygun                                                  | 1.3–1.6mm                                | 3.0–4.0 bar                                                                                                                                                                                                                                                                                                                                                                                          | 15–20 cm |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
|  | <b>Application</b>                       | <table><tr><td>Number of spraycoats:</td><td colspan="3">1 half wet + 1 wet coat</td></tr><tr><td>Flash-off:</td><td colspan="3">10-20mins (Before Baking)</td></tr><tr><td>Film thickness:</td><td colspan="3">40–60 µm</td></tr></table>                                                                                                                                                           |          |  |  | Number of spraycoats:      | 1 half wet + 1 wet coat |             |                 | Flash-off:                         | 10-20mins (Before Baking) |                          |          | Film thickness: | 40–60 µm               |          |         |
| Number of spraycoats:                                                               | 1 half wet + 1 wet coat                  |                                                                                                                                                                                                                                                                                                                                                                                                      |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
| Flash-off:                                                                          | 10-20mins (Before Baking)                |                                                                                                                                                                                                                                                                                                                                                                                                      |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
| Film thickness:                                                                     | 40–60 µm                                 |                                                                                                                                                                                                                                                                                                                                                                                                      |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
|  | <b>Drying</b>                            | <table><tr><td>Drying</td><td>25°C</td><td>60°C</td></tr><tr><td>Dust free after</td><td>45 mins</td><td>5 mins</td></tr><tr><td>Ready for assembly after</td><td>6 hours</td><td>30 mins</td></tr><tr><td>Ready for polish after</td><td>24 hours</td><td>60 mins</td></tr></table>                                                                                                                 |          |  |  | Drying                     | 25°C                    | 60°C        | Dust free after | 45 mins                            | 5 mins                    | Ready for assembly after | 6 hours  | 30 mins         | Ready for polish after | 24 hours | 60 mins |
| Drying                                                                              | 25°C                                     | 60°C                                                                                                                                                                                                                                                                                                                                                                                                 |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
| Dust free after                                                                     | 45 mins                                  | 5 mins                                                                                                                                                                                                                                                                                                                                                                                               |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
| Ready for assembly after                                                            | 6 hours                                  | 30 mins                                                                                                                                                                                                                                                                                                                                                                                              |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
| Ready for polish after                                                              | 24 hours                                 | 60 mins                                                                                                                                                                                                                                                                                                                                                                                              |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
|  | <b>IR Drying</b>                         | IR drying after flash-off time:<br>Step 1–short wave: 5 mins at a 80 cm distance<br>Step 2–medium wave: 20 mins at a 80 cm distance                                                                                                                                                                                                                                                                  |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
| <b>Further Treatment</b>                                                            |                                          | Polish after specified drying times and cooling.                                                                                                                                                                                                                                                                                                                                                     |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |
|  | <b>Note</b>                              | <ol style="list-style-type: none"><li>1. Mix with Dobte series products to assure spray effect and paint performance.</li><li>2. Use different type of hardener &amp; thinners as per different temperature.</li><li>3. Wear protective mask, glove and overall etc.</li></ol>                                                                                                                       |          |  |  |                            |                         |             |                 |                                    |                           |                          |          |                 |                        |          |         |