

2K Clears

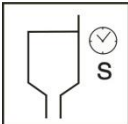
430S Medium Solid Clear

Product Description

Medium Solid clears for application ranging from spot repair, panel repair to overall refinish.

Pre-treatment

430S Medium Solid Clear is suitable to be applied on top of a clean and dust-free basecoat. See TDS of basecoat for other preparation of substrate.

	Mixing Ratio	430S Clear 100 (vol) AK125 Hardener 50 (vol) AK321 Thinner 10-20 (vol) Mix well and strain before application. Note: AK1251/AK3211 is for temperatures between 5°C–15°C AK1252/AK3212 is for temperatures between 15°C–25°C AK1253/AK3213 is for temperatures above 25°C AK3214 Thinner is for temperatures above 35°C or when refinishing large surfaces.												
	Spray Viscosity Potlife	18 to 26 seconds DIN 4 cup at 25°C 4 hours at 25°C; 3 hours at 35°C												
	Spray Guns	<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											
	Application	<table><tr><td>Number of spraycoats:</td><td>1 half wet + 1 wet coat</td></tr><tr><td>Flash-off:</td><td>10-20mins (Before Baking)</td></tr><tr><td>Film thickness:</td><td>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													
	Drying	<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>6hours</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	6hours	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	6hours	30 mins												
Ready for polish after	24 hours	60 mins												
	IR Drying	IR drying after flash-off time: Step 1–short wave: 5 mins at a 80 cm distance Step 2–medium wave: 20 mins at a 80 cm distance												
Further Treatment		Polish after specified drying times and cooling.												
	Note	1. Mix with Dobte series products to assure spray effect and paint performance. 2. Use different type of hardener & thinners as per different temperature. 3. Wear protective mask, glove and overall etc.												