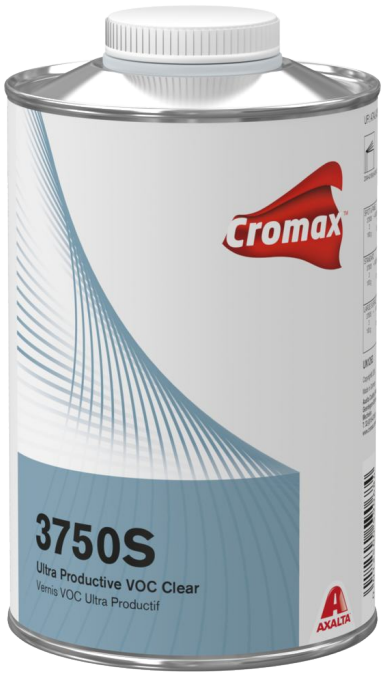
3750S
ULTRA PRODUCTIVE VOC CLEAR



PRODUCT DESCRIPTION

Ultra Productive VOC Clear 3750S is a clearcoat that dries very quickly at any temperature, from winter cold to summer heat. It provides the right mix for nearly all operating conditions and can be applied over waterborne and solventborne basecoats. It is part of the Ultra Productive 2K VOC clearcoat system.

Most productive clear

FEATURES

01 Application in 1.5 coats helps to save time and product.

02 Delivers consistently good, durable high-build finish under almost any ambient temperature.

03 Offers short flash-off times between coats and bake cycles.

04 Dries very quickly at ambient air temperatures.

05 Can be applied over Cromax solventbased and waterbased basecoats.

06 Helps increase productivity whether air drying, baked at low temperatures or using IR drying.

07 Has excellent polishing qualities.

TECHNICAL DATA SHEET

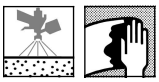
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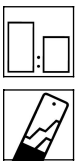
Product preparation - application STANDARD



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



Cromax Pro Basecoat / Cromax EZ+: Surfaces must be dried / flashed-off in accordance with TDS before application
Existing finishes: Surfaces must be sanded and degreased before application



M-6152

	Spot & panel repair (18-30°c)		Standard (18-28°c)		Large surface (18-22°c)		Large surface (21-25°c)	
	Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
3750S	3	100	3	100	3	100	3	100
XK203 / XK205	1	36	-	-	-	-	-	-
XK205 / XK206	-	-	1	37	-	-	-	-
XK206	-	-	-	-	1	37	1	37
3989S	-	-	-	-	-	-	0.4	13
430R */ 431R **/ XB387 ***	0.4	12	-	-	-	-	-	-
XB387	-	-	0.4	12	0.4	12	-	-

* XB387 for use on horizontal parts
** 431R is recommended for spot and panel repair only.
*** 430R can replace 431R, slight negative impact on drying time



Potlife at 20°C: 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.8 - 2.2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure

see manufacturer's instructions



0.5 + 1
1 operation
1st: thin and closed
2nd: normal

with intermediate flash-off: 0 min - 2 min
final flash-off: 5 min - 10 min



	XK203 / 431R	XK203 / XB387	XK205 / 431R	XK205 / XB387	XK206 / XB387	XK206 / 3989S
20 °C	2 hr	3 hr	2 hr 30 min	5 hr 30 min	-	-
50 °C	20 min	20 min	20 min	-	-	-
60 °C	15 min	15 min	15 min	25 min	30 min	35 min

For drying options, see details page.



Guideline for short wave IR equipment
Half power: 5 min
Full power: 10 - 15 min

VOC compliant

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.

TECHNICAL DATA SHEET

3750S

ULTRA PRODUCTIVE VOC CLEAR

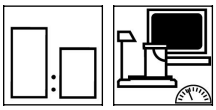
Products

3750S Ultra Productive VOC Clear

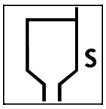
XK203 Low Emission Activator Fast
XK205 Low Emission Activator
XK206 Low Emission Activator Slow

3989S Retarder
430R Varispeed Thinner
431R Varispeed Ultra
XB387 HI-Temp Thinner

Product mix



Mixing ratios with special agents are available in the productmix table on ChromaWeb and in the specific TDS.



ISO 4: 49 - 61 s at 20°C
DIN 4: 19 - 22 s at 20°C



50 - 60 µm

Theoretical coverage

475 - 480 m²/l at 1 micron dry film thickness
Due to different activator characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.
Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



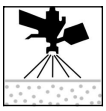
3750S	XK203 431R		XK205 431R		XK203 XB387		XK205 XB387	XK206 XB387	XK206 3989S
	Dark	Light	Dark	Light	Dark	Light	All colours	All colours	All colours
Flash time	4 min	4 min	4 min	4 min	4 min	4 min	5 min	5 min	5 min
Distance	50 cm	50 cm	50 cm	50 cm	50 cm	50 cm	80 cm	80 cm	80 cm
Half power	6 min	6 min	6 min	6 min	6 min	7 min	5 min	5 min	10 min
Full power	3 min	6 min	4 min	7 min	5 min	7 min	15 min	20 min	20 min

Guideline for short wave IR equipment

TECHNICAL DATA SHEET

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3750S Ultra Productive VOC Clear can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Close can of Activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Can also be applied in 2 coats, respecting 10 min intermediate flash off and 10 min flash off before bake.
- Dry spray spots in the clear can be worked off with AK350/AK350A at very low spray pressure. This should be done at the latest 5 min after clear application and should be avoided on horizontal parts.
- Can also be used over activated Centari Basecoat.
- For Semi-Flexible systems 10% 805R Flexible Additive can be added to the base material. Activator and Thinner ratios remain equal.
- For Full-Flexible systems the mixing ratios are available in the productmix table on Chromaweb.

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

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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