

BODY 696 AIR DRY CLEAR HS SR 2:1



GENERAL TECHNICAL DESCRIPTION

2K HS clearcoat with fast air-drying properties resulting in a premium finish.

Applicable in a wide ambient temperature range, by using exclusive hardeners, BODY 627 FAST or BODY 626 NORMAL.

Innovative formula which provides high throughput, efficiency and energy savings.

Suitable for spot panel and partial automotive repairs (including horizontal surfaces).

Easy application and polishing right after drying.

Scratch resistant properties and chemical / mechanical endurance.

SURFACE

HB BODY solvent- and waterborne basecoat paints

PRETREATMENT/CLEANING OF SUBSTRATE



Let the basecoat dry sufficiently before the clearcoat. Clean the surface from the dust with a tack cloth.

PRODUCT APPLICATION: Apply 2 normal coats.



Mix 2 parts CLEAR COAT with 1 part BODY 627 FAST / BODY 626 NORMAL HARDENER
Pot life at 20°C (68°F):
- 627 FAST: 30 min
- 626 NORMAL: 60 min

TEMPERATURE RANGE	HARDENER SELECTION DEPENDING ON SIZE OF REPAIR	
	1 - 2 PARTS	3 - 5 PARTS
15 - 25°C (59 - 77°F)	627 FAST	627 FAST
25 - 30°C (77 - 86°F)	627 FAST	626 NORMAL
30 - 35°C (86 - 95°F)	626 NORMAL	626 NORMAL



Addition 5% 740 NORMAL ACRYL THINNER / REDUCER



Ready to spray: 13 - 15 s
DIN 4 / 20°C (68°F)



1.2 - 1.3 mm
1.7 - 2.2 bar (25 - 32 psi)
2x coats = 50 - 60 µm
(2 - 2.4 mil)



Flash off time between coats
3 - 5 min / 20°C (68°F)
Flash off time before bake
2 - 3 min* / 20°C (68°F)

*Do not exceed the guidelines given.



TEMPERATURE	DUST FREE		FREE TO HANDLE	
	627 FAST	626 NORMAL	627 FAST	626 NORMAL
23°C (73°F)	15 min	25 - 30 min	50 - 60 min	90 - 105 min
45°C (113°F)	2 - 5 min		20 - 25 min	30 - 35 min
50°C (122°F)			15 - 20 min	20 - 25 min
60°C (140°F)			5 - 10 min	10 - 15 min



Flash off time before IR curing: 5 min
1st step: half power 5 min
2nd step: full power 5 min
Panel distance: 60 - 70 cm



Ready to Polish
In case of air drying: at
FREE TO HANDLE time

In case of bake: 10 min
after cooldown at FREE TO
HANDLE time

SPECIFIC GRAVITY

0.96 ± 0.02 g/cm³

SOLID CONTENT

(NO THINNER / REDUCER)

47 ± 2% Weight

VOC (2004/42/EC)

This is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 840 g/L. The VOC content in the ready for use form of this product is 840 g/L.
2004/42/II(b)(840)840

CLEANING OF EQUIPMENT

Clean after final use with 740 ACRYL NORMAL or 767 NITRO thinner / reducer

REMARKS

- Application only with the recommended hardeners and thinners / reducers.
- Drying time and potlife depends on hardener, film thickness and ambient temperature (recommended film thickness 50-60 µm).

STORAGE SHELF LIFE

Guaranteed shelf life of 24 months in unused original containers stored in a cool place (5 - 25°C) (41 - 77°F).



Always wear protective equipment



Follow the application instructions mentioned in this TDS

2K paint systems tend to react with water, hence all the equipment used must be moisture free. Isocyanates may cause skin sensitization. More specifically, care should be taken when handling the material. Anyone with a history of histaminic conditions, or respiratory problems should consult the doctor first.

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