

2K Xpress Clear 261



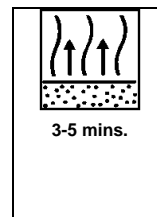
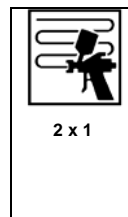
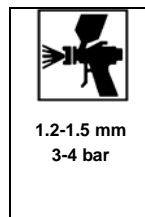
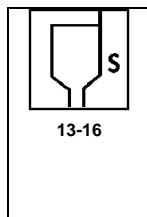
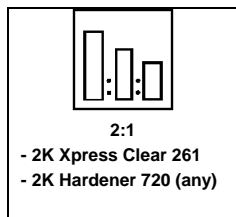
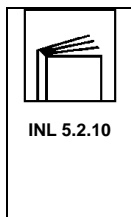
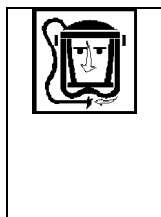
Technical Data Sheet



August 2006

INL 5.2.10

Description Two component clear system, suitable for use on all types of repairs and in most application conditions. Quick flash-off, fast drying, with good flow and superior gloss level at a competitive price. Two coats application maximizes bodyshop efficiency.



Product & ancillary items

Product Lesonal 2K Xpress Clear 261
Lesonal 2K Hardener 720 (any)

Basic Raw Materials 2K Xpress Clear 261 – Acrylic resins
720 Hardeners (any) – Polyisocyanate resins

Method of use

Suitable Substrates: Lesonal Basecoat SB MM 120
Lesonal 2K Topcoat MM 320

Mixing Ratio by Volume: 2 parts of 2K Xpress Clear 261
1 part of 2K Hardener 720 (any)

Use Mixing Stick D

Spraying Viscosity: 13-16 s DIN Cup 4 at 20°C when mixed with 2K Hardener 720

Potlife: 1.5 hrs. at 20°C with 2K Hardener 720-B
3.5 hrs. at 20°C with 2K Hardener 720
4.0 hrs. at 20°C with 2K Hardener 720-CC

Spray Gun Fluid Tip and Working Pressure:	Spray Gun:	Fluid Tip:	Working Pressure:
	Gravity Feed	1.2-1.5 mm	3-4 bar
	Syphon Feed	1.4-1.6 mm	3-4 bar
	Pressure Feed	1.1-1.2 mm	5-6 bar
	HVLP Gravity Feed	1.3-1.5 mm	max 0.7 bar at the air-cap
	HVLP Suction Feed	1.5-1.7 mm	max 0.7 bar at the air-cap

Application Technique: Spray 2 coats, allowing for a flash-off time of 3-5 minutes between coats. Allow 10-15 minutes flash off after the final coat before baking at 60°C.
Note: The specified flash-off times depend on temperature and air velocity.



Film Thickness: 30-40 µm per coat with 2K Hardener 720

Material Usage: Taking into account a transfer efficiency of 70%, the theoretical material usage for one layer is 8 m²/lt ready to spray mixture which calculates to 13 m²/lt unthinned paint at 40µm.

Note: The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

Equipment Cleaning: Use Lesonal Multi Thinner 810 (any) or Lesonal NC Thinner 820

Drying Times at 20°C:	<u>720-B</u>	<u>720</u>	<u>720-CC</u>
Dust Dry	18 mins.	20 mins.	30 mins.
Tack-Free	1.0 hr.	1.0 hr.	1.5 hrs.
Dry to Handle	8 hrs.	10 hrs.	12 hrs.
Hard Dry	10 hrs.	12 hrs.	16 hrs.

Drying Times at 60°C:			
Dust Dry	5 mins.	6 mins.	8 mins.
Tack-Free	10 mins.	14 mins.	20 mins.
Dry to Handle	20 mins.	25 mins.	25 mins.
Hard Dry	30 mins..	30 mins.	30 mins.

Dust ingress and minor damage in the 2K Xpress Clear 261 finishing can be polished out after allowing for the following drying times:

At 60°C:

With 2K Hardener 720-C 30 mins.

First flat out dust particles carefully with SF sandpaper, then polish the area manually or mechanically.

Shelflife: 2K Xpress Clearcoat 261 – 24 months
2K Hardener 720 (any) – 12 months

Health & Safety Data: These products are intended for professional use only. Please refer to can labels and Safety Data Sheets concerned for more specific information. The user of these products is required to comply with the national laws pertaining to Health & Safety disposal. *The above information is given in good faith, but without warranty, as the final results are also dependent upon factors of use which are outside our control.*