

# 2K Xpress Clear 261

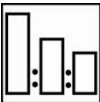





Clearcoat

10/01/2020

L5.02.10 AUS

## DESCRIPTION

2K Xpress Clear 261 is a two component clearcoat system, suitable for use on all types of repairs and in most application conditions. Quick flash-off and fast drying time maximize bodyshop efficiency and profitability. Good flow enhances superior gloss level at competitive price.

Mixing ratio		2 1 +10%	2K MS Xpress Clear 261 Lesonal 2K Hardener 720 / 728 B / 728 C Lesonal Multi Thinner 810-C /HT 810-CC ( <u>only</u> with 728 hardeners)	
Equipment		Spray gun set-up: 1.3-1.5 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.7 bar at the air cap	
Application		2 x 1 coat Spray 2 coats, allowing the first coat to become touch dry prior to the application of the second coat. Generally flash-off time is 3-5 minutes between coats.		
Flash-off		Between coats 3-5 minutes at 20°C	Before curing 10-15 minutes at 20°C	
Drying time		Drying: 2K Hardener 720 2K Hardener 728 B 2K Hardener 728 C	20°C 7 hours 5 hours 7 hours	60°C 25 minutes 20 minutes 25 minutes
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator		

Read complete TDS for detailed product information

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## PRODUCT AND ADDITIVES

Product	2K Xpress Clear 261
Hardener	Lesonal 2K Hardener 728 B; spot and small panel repairs at 15°C- 25°C Lesonal 2K Hardener 720 / 728 C; spot and small panel repairs at 20°C- 30°C
Thinner	Lesonal Multi Thinner 810-C / HT 810-CC; when using 728 hardeners ( <u>not</u> required with 720 hardeners)

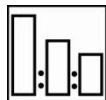
Note: the above suggestions are a guide, always take into consideration, temperature and size of job when using Lesonal 2K 728 Hardeners and Multi Thinner 810 combinations.

Basic raw materials	2K Xpress Clear 261; Acrylic resins 720 / 728 Hardeners; Polyisocyanate resins Multi Thinner 810; A blend of organic solvents
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## METHOD OF USE

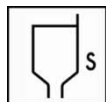
Suitable substrates	Existing finishes, Lesonal Basecoat SB 120 MM or 2K Topcoat MM 320
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Mixing	2	2K Xpress Clear 261
	1	2K Hardener 720 / 728 B / 728 C
	+10%	Lesonal Multi Thinner 810-C / HT 810-CC ( <u>only</u> when 728 hardeners are used)



Note: Only add 10% Lesonal Multi Thinner 810 in combination with 728 B / 728 C hardeners. When using 720 hardeners, Multi Thinner 810 is not required.

Viscosity	13-16 sec DIN cup 4 at 20°C.
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Spray gun set-up / application pressure	Spray gun Gravity feed	Fluid tip-set-up 1.3-1.5 mm	Application pressure 1.7-2.2 bar at the spray gun air inlet HVLP max 0.7 bar at the air cap
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## APPLICATION TECHNIQUE

Application process & blending

Spray 2 coats, allowing the first coat to become touch dry prior to the application of the second coat. Generally flash-off time is 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.



Pot-life

2K Hardener 720	3.5 hours	at 20°C
2K Hardener 728 B	1.5 hours	at 20°C
2K Hardener 728 C	3.0 hours	at 20°C

Film thickness

By using the recommended application: 30-40 µm per coat

Theoretical coverage

By using the recommended application, the theoretical material usage is ± 8 m<sup>2</sup>/liter RTS mixture.  
 The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Drying times



720	728 B	728 C
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20°C	Dust dry	15 mins	11 mins	15 mins
	Dry to handle	7 hrs	5 hrs	7hrs
30°C	Dust dry	13 mins	7 mins	13 mins
	Dry to handle	4 hrs	2 hrs	4 hrs
60°C	Dust dry	6 mins	5 mins	6 mins
	Dry to handle	25 mins	20 mins	25 mins

Cleaning of equipment

Use Lesonal Multi Thinner 810 (any)

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.  
 Avoid extreme temperature fluctuation.  
 Product shelf life data see TDS L9.01.02

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**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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