

# 2K Xpress Clear 261

Clearcoat

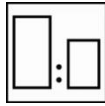
01/08/2019

L5.02.10

## 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      2K MS Xpress Clear 261  
1      Lesonal 2K Hardener 720

### Equipment



Spray gun set-up:  
1.3-1.5 mm

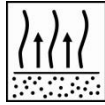
Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.7 bar at the air cap

### 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 60°C

### Drying time



Drying:	20°C	60°C
2K Xpress Clear 261	4 hours	15 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

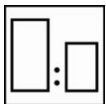
<b>Product</b>	2K Xpress Clear 261 Hardener	Lesonal 2K Hardener 720; a general purpose hardener for all repair sizes.
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<b>Basic raw materials</b>	2K Xpress Clear 261 ; Acrylic resins 720 Hardeners (any) ; Polyisocyanate resins
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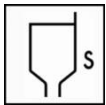
## METHOD OF USE

<b>Suitable substrates</b>	Existing finishes, Lesonal Basecoat SB 120 MM or 2K Topcoat MM 320
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<b>Mixing</b>	2      2K Xpress Clear 261 1      2K Hardener 720	Mix the components in a plastic can, mix thoroughly after adding each of the components.
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<b>Viscosity</b>	17-20 sec DIN cup 4 at 20°C.
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<b>Spray gun set-up / application pressure</b>	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.

<b>Pot-life</b>	2K Hardener 720-B	2 hours	at 20°C
	2K Hardener 720	3.5 hours	at 20°C
	2K Hardener 720-CC	4.0 hours	at 20°C

**Film thickness** By using the recommended application: 30-40 µm per coat with 2K Hardener 720

**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-B	720	720-CC
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20°C	Dust dry	15 mins	15 mins	30 mins
	Dry to handle	4 hrs	6 hrs	8 hrs
30°C	Dust dry	10 mins	13 mins	20 mins
	Dry to handle	2 hrs	4 hrs	6 hrs
60°C	Dust dry	5 mins	6 mins	8 mins
	Dry to handle	15 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 S9.02.01

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