



Effective 28 January, 2007

# 3300S

## PROTECT PLUS CLEAR

### Description

2-component clear based on high build resin technology, providing excellent scratch resistance, to be used in clear over base system.  
Composition based on acrylic polymer.

### Products

3300S	Protect Plus Clear
AK260	High Solids Activator

### Properties

- Has excellent scratch, chemical and weather resistance.
- Gives a long lasting high gloss finish.
- Easy application.
- Provides excellent appearance.
- Can be used for panel and overall repair.
- VOC compliant, conform with directive 2004/42/EC.

### Substrates

- DuPont Refinish basecoats.



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## PRODUCT PREPARATION

	<b>Mixing ratio</b>	3300S AK260	<b>Volume</b>		<b>Weight</b>
			2	1	100 52
	<b>VOC</b>	495 g/l			
	<b>Pot life at 20°C</b>	2 hr 30 min			
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b> <b>AFNOR 4</b>	17-18 s 17-19 s 19-21 s		
	<b>Spray equipment</b>	<b>Conventional guns</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>
			Gravity feed	1.4-1.6 mm	15-20 cm
		Suction feed	1.6-1.8 mm	15-20 cm	3-4 bar
		Pressure feed	1.0-1.2 mm	15-20 cm	3-4 bar
		<b>Compliant guns (HVLP/HTE)</b>			
		Gravity feed	1.3-1.5 mm	10-15 cm	According to supplier's specifications
Suction feed	1.5-1.6 mm	10-15 cm			
Pressure feed	1.0-1.2 mm	10-15 cm			
	<b>Number of coats</b>	2			
	<b>Flash time</b>	10-15 min between coats. 10 min before bake.			
	<b>DFT</b>	40-60 μ			
	<b>Drying</b>	<b>Dust-free</b> <b>Dry to handle</b> <b>Tape-free</b>	<b>40 min x 65°C</b>		
			imm. after cool down 2 hr		
	<b>IR drying*</b>	Flash time	5 min	* Guideline for short/medium wave IR equipment.	
		Distance	80 cm		
		Half power	5 min		
		Full power	15-20 min		
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.					



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## RECOMMENDED USE

### Surface preparation

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with a clean cloth.
3. Repair according to damage.
4. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.
5. Tack rag.
6. If needed, apply a DuPont Refinish basecoat.

### Clearcoat application

When the DuPont Refinish basecoat is completely flat, apply 3300S in 2 coats with 10-15 min flash between coats.

### Chemical resistance

When fully cured, 3300S is resistant to short exposures of the chemicals as listed:

sodium hydroxide	10 %	xylene
sulphuric acid	20 %	lead-free fuel
hydrochloric acid	5 %	methyl ethyl ketone
nitric acid	10 %	

### Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



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## RECOMMENDED USE (con'd)

### Recoatability

At any time after tape-free time. After 24 hr, scuff sanding is required.

### Remarks

- If necessary for minor viscosity adjustments, use XB thinners (maximum 5 %).
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Activated material should not be returned to original can of non-activated material.
- To spray interiors, use of 5 % 421R is recommended.
- Material has to be at room temperature (18-25°C) before use.

### Product data

Package viscosity: 70 cp  
Theoretical coverage: 9 m<sup>2</sup>/l at recommended DFT - ready-to-spray  
Directive 2004/42/EC: The EU limit value for this product (product category: IIB(e)) in ready to use form is maximum 840 g/l of VOC. The VOC content of this product in ready to use form is maximum 495 g/l.

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
3300S	1	2	0.975
AK260	1 - 5	2	1.023

### Safety

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



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## REPAIR SYSTEMS

### **Panel and overall repair**

Pay attention to the application method. Spray procedure has to ensure proper overspray melt-in which is achieved within 2 min of the clear application. Plan the process to avoid dry overspray.

### **Spot repair**

Not recommended.