



Effective February 28, 2011

## 3750S - 3760S

### ULTRA PRODUCTIVE VOC CLEAR SYSTEM

#### Description

A Productive Clear System that can be used for a wide range of repairs under various conditions. 2-component fast dry clear, to be used in clear over base system. Composition based on acrylic polyurethane copolymer. System derived from Hyper Cure™ technology.

#### Products

3750S	Ultra Productive VOC Clear
3760S	Ultra Productive VOC Hi-Temp Clear
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
430R	Varispeed Thinner
431R	Varispeed Ultra
XB387	High Temperature Thinner
3989S	Retarder

#### Properties

- Gives very fast air drying and allows short flash times between coats and bake.
- Has excellent polishability.
- Increases productivity in air dry, low bake or IR drying.
- Can be used for spot, panel and overall repair.
- VOC compliant, conform with directive 2004/42/EC.
- Gives very fast air drying and allows short flash times between coats and bake.

#### Substrates

- DuPont Refinish basecoats.
- All cleaned and sanded OEM and cured repair finishes (not recommended on thermoplastic acrylic finishes).



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#### PRODUCT PREPARATION (Fast)

	<b>Mixing ratio</b>	<b>Spot and panel</b>											
		<b>18°C - 30°C</b>						<b>25°C - 38°C</b>					
		V.	W.	V.	W.	V.	W.	V.	W.	V.	W.	V.	W.
		3750S	3	100	3	100	3	100	-	-	3	100	3
3760S	-	-	-	-	-	-	3	100	3	100	3	100	
XK203	1	36	-	-	1	36	1	36	-	-	1	36	
XK205	-	-	1	36	-	-	-	-	1	36	-	-	
431R	0.4	12	0.4	12	-	-	0.4	12	0.4	12	-	-	
XB387	-	-	-	-	0.4	12	-	-	-	-	0.4	12	
<b>VOC</b>		420 g/l											
	<b>Pot life at 20°C</b>	3750S						3760S					
		With 431R 45 min						With 431R 45 min					
With XB387		55 min						60 min					
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b>											
		<b>FORD 4</b>											
AFNOR 4		19-22 s 20-23 s 22-25 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		3-4 bar					
		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 (HVLPH/TE)</b>						According to supplier's specifications					
		Gravity feed		1.3-1.5 mm		10-15 cm							
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>		1,5 (2)											
<b>Flash time</b>		0-5 min between coats. 0-5 min before bake (depends on spray booth)											
<b>DFT</b>		40-60 µ											
	<b>Drying</b>	<b>With 3750S</b>		<b>XK203 / 431R</b>		<b>XK205 / 431R</b>		<b>XK203 / XB387</b>					
				<b>20°C</b>		<b>20°C</b>		<b>20°C</b>		<b>20°C</b>		<b>20°C</b>	
				<b>15 min x 60°C</b>		<b>15 min x 60°C</b>		<b>15 min x 60°C</b>		<b>15 min x 60°C</b>		<b>15 min x 60°C</b>	
				<b>20 min x 50°C</b>		<b>20 min x 50°C</b>		<b>20 min x 50°C</b>		<b>20 min x 50°C</b>		<b>20 min x 50°C</b>	
		<b>Dust-free</b>		15 min		imm.		20 min		imm.		30 min	
		<b>DTH</b>		2 hr		imm.		2 hr 30'		imm.		3 hr	
		<b>Tape-free</b>		6 hr		15 min		6 hr 30'		20 min		8 hr	
		<b>With 3760S</b>		<b>XK203 / 431R</b>		<b>XK205 / 431R</b>		<b>XK203 / XB387</b>					
				<b>28°C</b>		<b>28°C</b>		<b>28°C</b>		<b>28°C</b>		<b>28°C</b>	
		<b>15 min x 60°C</b>		<b>15 min x 60°C</b>		<b>15 min x 60°C</b>		<b>15 min x 60°C</b>		<b>15 min x 60°C</b>			
		<b>20 min x 50°C</b>		<b>20 min x 50°C</b>		<b>20 min x 50°C</b>		<b>20 min x 50°C</b>		<b>20 min x 50°C</b>			
<b>Dust-free</b>		15 min		imm.		20 min		imm.		30 min			
<b>DTH</b>		2 hr		imm.		2 hr 30'		imm.		3 hr			
<b>Tape-free</b>		6 hr		20 min		6 hr 30'		30 min		8 hr			
	<b>IR drying*</b>	<b>Dark</b>		<b>Light</b>		<b>Dark</b>		<b>Light</b>		<b>Dark</b>		<b>Light</b>	
		<b>Flash time</b>		4 min		4 min		4 min		4 min		4 min	
		<b>Distance</b>		50 cm		50 cm		50 cm		50 cm		50 cm	
		<b>Half power</b>		6 min		6 min		6 min		6 min		7 min	
		<b>Full power</b>		3 min		6 min		4 min		7 min		5 min	

\* Guideline for short/medium wave IR equipment.

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#### PRODUCT PREPARATION (Standard)

	<b>Mixing ratio</b>	3750S 3760S XK205 / XK206 XB387	<b>Large surface</b>			
			<b>18°C - 28°C</b>		<b>25°C - 38°C</b>	
			Volume	Weight	Volume	Weight
			3	100	-	-
		-	-	3	100	
		1	36	1	36	
		0.4	12	0.4	12	
	<b>VOC</b>	420 g/l				
	<b>Pot life at 20°C</b>	With XK205 With XK206	3750S		3760S	
			60 min		90 min	
			70 min		90 min	
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b> <b>AFNOR 4</b>	19-22 s			
			20-23 s			
			22-25 s			
	<b>Spray equipment</b>	<b>Conventional guns</b> Gravity feed Suction feed Pressure feed	<b>Fluid tip</b>		<b>Distance</b>	<b>Pressure</b>
			1.4-1.6 mm		15-20 cm	3-4 bar
			1.6-1.8 mm		15-20 cm	3-4 bar
			1.0-1.2 mm		15-20 cm	3-4 bar
		<b>Compliant guns (HVLP/HTE)</b> Gravity feed Suction feed Pressure feed				According to supplier's specifications
			1.3-1.5 mm		10-15 cm	
			1.5-1.6 mm		10-15 cm	
			1.0-1.2 mm		10-15 cm	
	<b>Number of coats</b>	1,5 (2)				
	<b>Flash time</b>	0-5 min between coats. 0-5 min before bake (depends on spray booth).				
	<b>DFT</b>	40-60 µ				
	<b>Drying</b>	<b>With 3750S</b>	<b>XK205</b>		<b>XK206</b>	
			<b>20°C</b>		<b>25 min x 60°C</b>	<b>30 min x 60°C</b>
			Dust-free	50 min	imm	imm
		Dry to handle	5 hr 30 min	imm	30 min	
		Tape-free	O.N.	1 hr 30 min	2 hr	
		<b>With 3760S</b>	<b>XK205</b>		<b>XK206</b>	
			<b>28°C</b>		<b>25 min x 60°C</b>	<b>30 min x 60°C</b>
			Dust-free	50 min	imm	imm
Dry to handle	6 hr	15 min	30 min			
Tape-free	O.N.	2 hr	2 hr 30 min			
	<b>IR drying*</b>	Flash time Distance Half power Full power	<b>All colours</b>		<b>All colours</b>	
			5 min		5 min	
			80 cm		80 cm	
			5 min		5 min	
			15 min		20 min	

\* Guideline for short/medium wave IR equipment.

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









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## 3750S - 3760S

### ULTRA PRODUCTIVE VOC CLEAR SYSTEM

#### PRODUCT PREPARATION (Slow)

 <b>Mixing ratio</b>		Overall							
		18°C - 22°C		21°C - 25°C		21°C - 30°C		28°C - 38°C	
		V	W	V	W	V	W	V	W
	3750S	3	100	3	100	-	-	-	-
	3760S	-	-	-	-	3	100	3	100
	XK206	1	36	1	36	1	36	1	36
	XB387	0.4	12	-	-	0.4	12	-	-
	3989S	-	-	0.4	12	-	-	0.4	12
<b>VOC</b>	420 g/l								
 <b>Pot life at 20°C</b>		3750S				3760S			
	With XB387	70 min				90 min			
	With 3989S	60 min				90 min			
 <b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	19-22 s							
	<b>FORD 4</b>	20-23 s							
	<b>AFNOR 4</b>	22-25 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		3-4 bar			
	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 (HVLPH/TE)</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>	1,5 (2)								
 <b>Flash time</b>	0-5 min between coats. 0-5 min before bake (depends on spray booth).								
<b>DFT</b>	40-60 µ								
 <b>Drying</b>	<b>With 3750S</b>	<b>XB387</b>				<b>3989S</b>			
		<b>30 min x 60°C</b>				<b>35 min x 60°C</b>			
	<b>Dust-free</b>	imm.				imm.			
	<b>Dry to handle</b>	30 min				30 min			
	<b>Tape-free</b>	2 hr				2 hr			
	<b>With 3760S</b>	<b>XB387</b>				<b>3989S</b>			
	<b>30 min x 60°C</b>				<b>35 min x 60°C</b>				
<b>Dust-free</b>	imm.				imm.				
<b>Dry to handle</b>	30 min				30 min				
<b>Tape-free</b>	2 hr 30 min				2 hr 30 min				
 <b>IR drying*</b>		<b>All colours</b>				<b>All colours</b>			
	<b>Flash time</b>	5 min				5 min			
	<b>Distance</b>	80 cm				80 cm			
	<b>Half power</b>	5 min				10 min			
	<b>Full power</b>	20 min				20 min			

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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 waterborne basecoat is completely flat, apply 3750S/3760S in 1 light coat immediately followed by a full coat with 0-3 min flash between coats or 2 coats with 5-10 min flash between coats.

##### Chemical resistance

When fully cured, 3750S / 3760S is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20 %	battery acid
sulphuric acid	25 %	toluene
hydrochloric acid	20 %	xylene
phosphoric acid	20 %	glycol
ammonia	10 %	brake fluid, petrol

##### 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

- 431R is recommended for spot and panel repair only.
- 431R can be replaced by 430R but this will have a slight negative influence on the drying time.
- For horizontal parts, preferably use XB387.
- 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.
- Dry spray spots in the clear can be worked off with AK350 at very low spray pressure. This should be done at the latest 5 min after clear application and should be avoided on horizontal parts.
- For structured and/or flat clears, see specific TDS.
- For flexible systems, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

##### Product data

Package viscosity: 3750S : 150 cp  
3760S : 145 cp

Theoretical coverage: 9.4 m<sup>2</sup>/l at recommended DFT - ready-to-spray

Directive 2004/42/EC: 2004/42/IIB(d) (420)420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
3750S	1 - 5	4	0.979
3760S	5	4	0.987
XK203	1 - 5	3	1.060
XK205	1 - 5	3	1.059
XK206	1 - 5	3	1.078
430R	1	2	0.880
431R	1	2	0.882
XB387	1 - 5	4	0.867
3989S	1	4	0.942

##### Safety

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



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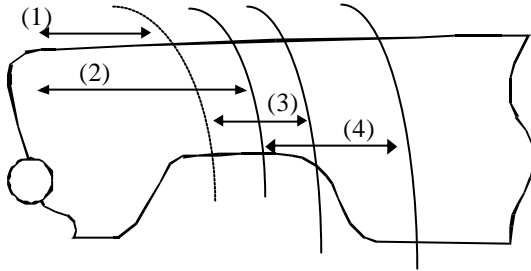
## 3750S - 3760S

### ULTRA PRODUCTIVE VOC CLEAR SYSTEM

#### REPAIR SYSTEMS

##### Spot and panel repair: AK350 Fade-out Thinner method

- (1) Apply 1 coat of 3750S / 3760S over the basecoat, extending into the area surrounding the spot.
  - (2) Apply a 2<sup>nd</sup> coat of 3750S / 3760S, extending further into the area surrounding the spot.
  - (3) Smoothen out the fade-out area with AK350 within 5 min maximum.
  - (4) Optionally extend the fade-out area with AK350 within 5 min maximum.
- ! Surface should be carefully and correctly prepared before the basecoat application.  
See recommended use, paragraph surface preparation.
- ! Stay with the application of AK350 within the prepared area.



If necessary, balance out the gloss level by polishing with a non silicone containing polishing compound or a non silicone containing final glaze, after complete hardening of the repair.