



Effective July 15, 2010

# 3801SR

CHROMACLEAR® VOC ROUGE BABYLONE

## Description

2-component clear based on Low Emission resin technology, to be used in clear over base system, specially designed to obtain Peugeot Rouge Babytone (LKR) colour in a DuPont Refinish basecoat quality.  
Composition based on acrylic copolymer and a unique, patented “star” polymer technology.

## Products

3801SR	ChromaClear® VOC Rouge Babytone
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow

## Properties

- Can be used over solventborne and waterborne basecoats.
- Combines very easy application with little sagging risks.
- Gives a smooth, high build finish and has very fast drying properties.
- Has excellent mar, chemical and weather resistance.
- Can be used for spot, panel and overall repair.
- VOC compliant, conform with directive 2004/42/EC.

## Substrates

- Basecoat Rouge Babytone (Peugeot LKR) in a DuPont Refinish basecoat quality.


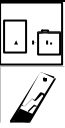









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## PRODUCT PREPARATION

	Stir 3801SR well before adding activator.							
	<b>Mixing ratio</b>	<b>Spot and panel</b>		<b>Standard</b>		<b>High temperature</b>		
		Volume	Weight	Volume	Weight	Volume	Weight	
		3801SR	3	100	3	100	3	100
		XK203	1	37	-	-	-	-
		XK205	-	-	1	37	-	-
XK206	-	-	-	-	1	37		
<b>VOC</b>	420 g/l							
	<b>Pot life at 20°C</b>	XK203 1 hr 15 min XK205 1 hr 30 min XK206 2 hr						
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b>		<b>FORD 4</b>		<b>AFNOR 4</b>		
		16-18 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	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 (HVLV/HTE)</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>	0-3 min between coats when applying 1.5 coats. 5-10 min between coats when applying 2 coats. 0-5 min before bake.						
<b>DFT</b>	45-60 μ							
	<b>Drying</b>	<b>XK203</b>		<b>XK205</b>		<b>XK206</b>		
		20°C	20 min x 60°C	20°C	30 min x 60°C	40 min x 60°C		
		Dust-free	40 min	imm.	1 hr	imm.	imm.	
		Dry to handle	3 hr 30 min	imm.	6 hr	imm.	1 hr	
Tape-free	12 hr	30 min	O.N.	30 min	2 hr			
	<b>IR drying*</b>	Flash time	5 min					
		Distance	80 cm					
		Half power	5 min					
		Full power	15-20 min					
* Guideline for short/medium wave IR equipment.								
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 Basecoat Rouge Babytone (Peugeot LKR) in a DuPont Refinish basecoat quality.

### Clearcoat application

Stir 3801SR well prior to use.

When the DuPont Refinish basecoat is completely flat, apply 3801SR in 1 light coat immediately followed by a full coat with 0-3 min flash between coats or apply 2 full coats with 5-10 min flash between coats.

Stay within the recommended film thickness for optimum colour match.

### Chemical resistance

When fully cured, 3801SR 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

- XK203 is recommended for spot repair only.
- 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 XK203 is recommended.
- 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.
- Material has to be at room temperature (18-25°C) before use.

### Product data

Package viscosity: 37 cp  
 Theoretical coverage: 8.5 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(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)
3801SR	1	2	0.973
XK203	0.5 - 1 - 5	2	1.060
XK205	1 - 5	2	1.059
XK206	1 - 5	2	1.078

### Safety

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



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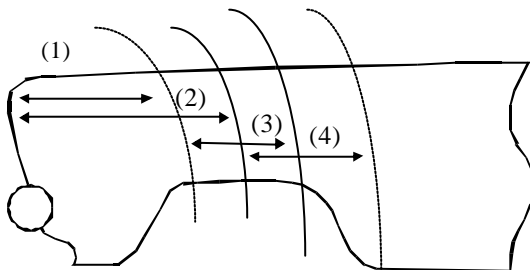
## REPAIR SYSTEMS

### 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: AK350 Fade-out Thinner method

- (1) Apply 1 coat of 3801SR over the basecoat, extending into the area surrounding the spot.
  - (2) Apply a 2<sup>nd</sup> coat of 3801SR, 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.