



Effective July 15, 2010

# 679S

## ULTRA PRODUCTIVE CLEAR

### Description

2-component fast dry clear to be used in clear over base system.  
Composition based on Hyper Cure™ technology.

### Products

679S	Ultra Productive Clear
256S	Activator Fast
AK260	High Solids Activator
421R	Varispeed
AB380	Basecoat Thinner
AB385	Hi-Temp Thinner
XB383	Standard Thinner
XB387	High Temperature Thinner

### Properties

- Gives very fast air drying and allows short flash times between coats and bake.
- The fast dust-free times prevent surface defects by air contamination.
- Has excellent polishability.
- Increases productivity in air dry, low bake or IR drying.
- Can be used for spot and panel repair.

### Substrates

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



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### PRODUCT PREPARATION

Mixing ratio		Extra Fast		Fast		Standard		High temperature	
		Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
	679S	3	100	3	100	3	100	3	100
	AK260	-	-	-	-	1	35	1	35
	256S	1	35	1	35	-	-	-	-
	421R	0.6	18	-	-	-	-	-	-
	AB380/XB383	-	-	0.6	18	0.6	18	-	-
	AB385/XB387	-	-	-	-	-	-	0.6	18
VOC	528 g/l								
Pot life at 20°C	AK260	4 h							
	256S / AB&XB thinners	4 h							
	256S / 421R	3 h							
Spray viscosity at 20°C	DIN 4	14-16 s							
	FORD 4	14-16 s							
	AFNOR 4	15-18 s							
Spray equipment	Conventional guns	Fluid tip		Distance		Pressure			
	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			
	Compliant guns (HVLP/HTE)								
	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					
Number of coats	2								
Flash time	5 min between coats. 5 min before bake.								
DFT	45-65 µ								
Drying	With AK260	AB380 / XB383		AB385 / XB387					
		20°C	20 min x 60°C	20°C	15 min x 60°C				
		30 min	imm.	40 min	imm.				
	With 256S	421R		AB380 / XB383					
		20°C	15 min x 60°C	20°C	15 min x 60°C				
		12 min	imm.	20 min	imm.				
	3 h 30 min	imm.	4 h	imm.					
	O.N.	15 min	O.N.	30 min					
IR drying*	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 679S in 2 coats with 5 min flash between coats.

#### Chemical resistance

When fully cured, 679S 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 h, scuff sanding is required.

#### Remarks

- 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 10 min after clear application and should be avoided on horizontal parts.
- Over Cromax<sup>®</sup> we recommend the use of XB383 or XB387 to reduce 679S. This will provide a smoother application over the DuPont Refinish waterborne basecoat and make the clear even less sensitive for adverse spray conditions.
- 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: 90 cp  
Theoretical coverage: 5.7-8.3 m<sup>2</sup>/l at recommended DFT - ready-to-spray

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
679S	1 - 5	4	0.955
256S	1 - 5	3	0.995
AK260	1 - 5	3	1.023
AB380	1 - 5 - 20	4	0.874
AB385	5	4	0.879
XB383	1 - 5 - 20	4	0.847
XB387	1 - 5	4	0.867
421R	1	4	0.888

#### Safety

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



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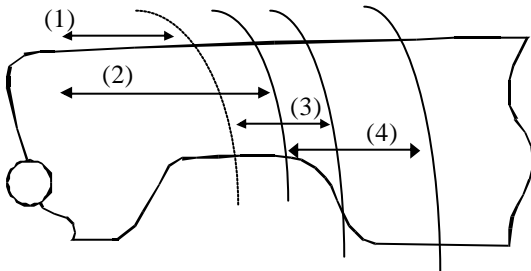
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### REPAIR SYSTEMS

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

- (1) Apply 1 coat of 679S over the basecoat, extending into the area surrounding the spot.
  - (2) Apply a 2<sup>nd</sup> coat of 679S, extending further into the area surrounding the spot.
  - (3) OPTIONAL:  
reduce 1 part of 679S with 1 part AK350 and apply 1 coat of reduced 679S over the fade-out area.
  - (4) Smoothen out the fade-out area immediately with pure AK350.
- ! 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.