

# **OPTIMUM CLEAR**

#### **GENERAL INFORMATION**

C650 Optimum Clear is a fast drying and energy-saving clear. It offers flexible drying options, from 5 minutes at 60°C to low temperature drying to reduce energy consumption. It's perfect for helping body shops increase throughput for spot repairs to medium-sized jobs - up to 3 panels, in one visit. It comes with a dedicated hardener, H65 Optimum Hardener, with an easy 1:1 mixing ratio. It's quick to apply and offers great blending to deliver a premium quality finish.

#### MIXING RATIO



1:1 Clear: H65 Optimum Hardener

In order to obtain optimal adhesion between the clear and the W00 - W999 Octobase Eco Plus System, the basecoat should be activated using 2% of the HW65 Octobase Eco Plus Optimum Hardener. (See Best Practice in TDS of W00 - W999 Octobase Eco Plus System).

#### **COMPONENTS**



H65 Optimum Hardener TA875 Fade-Out Thinner

Use TA875 Fade-Out Thinner for blending or fade-out areas.

#### **GUN SETUP**



|    | NOZZLE (MM) | AIR PRESSURE (BAR / PSI) |
|----|-------------|--------------------------|
| HE | 1,2 - 1,3   | 1,8-2,0 / 26-29          |

#### **ADDITIVES**



AC001 2K Structure Coat Fine AC002 2K Structure Coat Coarse

#### **APPLICATION**



½ + 1 coat / 40 - 50 µm (1,6-2,0 mil)

1,5 coats: No flash off between coats.

#### SURFACE PREPARATION



Base coat should be fully dry.

Mask entire vehicle to eliminate unwanted overspray.

## FLASH-OFF AND DRY TIMES



| Flash-off and<br>Dry Times | Flash-off<br>before bake | Dust free  | Dry to handle   | Dry to polish         |
|----------------------------|--------------------------|------------|-----------------|-----------------------|
| Air Dry<br>20°C (68°F)     | -                        | 20 minutes | 45 minutes      | 45 - 60 minutes       |
| Low Bake<br>40°C (104°F)   | 0 - 5 minutes            | -          | 15 - 20 minutes | After cooling<br>down |
| Forced Dry<br>60°C (140°F) | 0 - 5 minutes            | -          | 5 - 10 minutes  | After cooling<br>down |





**NEXT LAYER** 

Please refer to the next page for additional drying times.

## **SUBSTRATES**



W00 - W999 Octobase Eco Plus System

Basecoat needs to be activated.

## PHYSICAL DATA

|  |   | REGULATIONS COSO Optimum clear |  |  |  |  |  |
|--|---|--------------------------------|--|--|--|--|--|
|  | VOC (   | Code                           | 2004/42/IIB(d)(420)357   |  |  |  |  |
|  | Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product |                                | IIB/d. Topcoat - All types. EU limit values: 420 g/l (2007). This product contains a maximum of 357 g/l VOC. |  |  |  |  |
|  | Chemical Base Solventborne 2K Polyurea  |                                | ea   |  |  |  |  |
|  | Physical Properties   | Viscosity (RTS)                | 13-15 Dincup 4 / 20°C  |  |  |  |  |
|  |   | Density (kg/l)                 | 1,016  |  |  |  |  |
|  |   | Flash Point Closed Cup         | 9°C / 48.2°F   |  |  |  |  |
|  |   | Volume % Solids                | 59   |  |  |  |  |
|  |   | Economy                        | 11.8 m²/L/50 μm  |  |  |  |  |
|  |   | Economy                        | 481 ft²/Gal/2 mil  |  |  |  |  |
|  |   | Gloss                          | High Gloss   |  |  |  |  |
|  |   | Colour                         | -  |  |  |  |  |

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## POT LIFE AT 20°C (68°F)

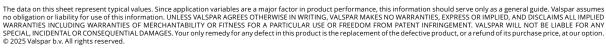


25 minutes

#### INFRARED DRYING



| AFTER FULL FLASH OFF AND AT PROPER DISTANCE |             |  |  |  |  |
|---|-------------|--|--|--|--|
| Half-bake                                   | 10 min 60°C |  |  |  |  |
| Full-bake                                   | -           |  |  |  |  |
| See IR Manufacturer information             |             |  |  |  |  |







## C650 OPTIMUM CLEAR

## ADDITIONAL DRYING INFORMATION



| Drying conditions     |        |                     |               |                    |                     |               |                    |                     |               |                    |
|-----------------------|--------|---------------------|---------------|--------------------|---------------------|---------------|--------------------|---------------------|---------------|--------------------|
|                       |        | Air Dry 20-<br>25°C | Low Bake 40°C | Forced Dry<br>60°C | Air Dry 20-<br>25°C | Low Bake 40°C | Forced Dry<br>60°C | Air Dry 20-<br>25°C | Low Bake 40°C | Forced Dry<br>60°C |
|                       | >70%   |                     |               | Χ                  |                     |               | Χ                  |                     |               | Χ                  |
| Relative humidity     | 50-70% |                     |               |                    |                     |               | Υ                  |                     |               | Χ                  |
| (outside)             | 30-50% | Υ                   |               |                    |                     |               |                    |                     |               | Χ                  |
|                       | <30%   | Х                   |               |                    | Υ                   |               |                    | Υ                   |               | Х                  |
| Temperature (outside) |        |                     | <15°C         |                    |                     | 15-25°C       |                    |                     | >25°C         |                    |

| Х | Not advised                                 |
|---|---|
| Υ | Possible but drying times may vary from TDS |
|   | Possible                                    |

## **PROTECTION**



Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).

For more detailed information please visit the following link for the Safety Data Sheet:

**SDS Octoral** 

#### **CLEANUP**



Gun Cleaner

Clean spray gun immediately after use.

## STORAGE / SHELF LIFE



The up-to-date shelf life overview can be found by clicking on the following link:

Shelf life overview Octoral

#### **NOTES**



All reported product properties on the TDS are determined at a temperature of  $20^{\circ}\text{C}$  /  $68^{\circ}\text{F}$  unless specified otherwise.

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