

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 Octabase Eco Plus System, the basecoat should be activated using 2% of the HW65 Octabase Eco Plus Optimum Hardener. (See Best Practice in TDS of W00 - W999 Octabase Eco Plus System).

GUN SETUP



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

APPLICATION



½ + 1 coat / 40 - 50 µm (1,6-2,0 mil)

1,5 coats: No flash off between coats.

FLASH-OFF AND DRY TIMES



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



Please refer to the next page for additional drying times.

SUBSTRATES



W00 - W999 Octabase Eco Plus System

Basecoat needs to be activated.

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	

COMPONENTS



H65 Optimum Hardener
TA875 Fade-Out Thinner

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

ADDITIVES



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

SURFACE PREPARATION



Base coat should be fully dry.

Mask entire vehicle to eliminate unwanted overspray.



NEXT LAYER



PHYSICAL DATA

EU REGULATIONS C650 Optimum Clear		
VOC Code		2004/42/IIIB(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		IIIB/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	
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 481 ft²/Gal/2 mil
	Gloss	High Gloss
	Colour	-

ADDITIONAL DRYING INFORMATION



Drying conditions										
		Air Dry 20-25°C	Low Bake 40°C	Forced Dry 60°C	Air Dry 20-25°C	Low Bake 40°C	Forced Dry 60°C	Air Dry 20-25°C	Low Bake 40°C	Forced Dry 60°C
Relative humidity (outside)	>70%			X			X			X
	50-70%						Y			X
	30-50%	Y								X
	<30%	X			Y			Y		X
Temperature (outside)		<15°C			15-25°C			>25°C		

X	Not advised
Y	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°C / 68°F unless specified otherwise.