

DULUX[®] AUTOSPEED[®] 488 S0016 2K MS CLEARCOAT



Dulux Australia
ABN 67 000 049 427

488 S0016 Dulux[®] AUTO SPEED[®] 2K MS Clearcoat

Product Name:

488-S0016 Dulux[®] AutoSpeed[®] 2K MS Clearcoat

Product Description:

Dulux[®] AutoSpeed[®] 2K MS Clearcoat is a high quality high gloss two pack clear top coat designed specifically for use in the Dulux[®] AutoSpeed[®] basecoat / clearcoat system.

Product & Additives:

- Dulux[®] AutoSpeed[®] 2K MS Clearcoat 488-S0016
- Dulux[®] AutoSpeed[®] 2K Hardener-Normal 980-89290
- Dulux[®] AutoSpeed[®] RP Hardener-Fast 980-89790 Cold Temperatures /Rapid Production
- Dulux[®] AutoSpeed[®] 2K Hardener Slow 980-S0028
- Dulux[®] AutoSpeed[®] 2K Thinner-Normal 920-89292
- Dulux[®] AutoSpeed[®] RP Thinner-Fast 920-89819 Cold Temperatures /Rapid Production
- Dulux[®] AutoSpeed[®] 2K Thinner-Slow 920-89847 High Temperatures



	Mixing Ratio	2 Parts 488-S0016
	Hardener	1 Part 980-89290 (Large Areas) or 1 Part 980-89790 (Small areas)
	Thinner	0-5% by Vol. 920-89292 or 920-89819 (Small areas) 920-89847 (High Temperatures Large areas)
	Spray Viscosity DIN Cup B4 @ 25°C	18-19 seconds
	Gravity Feed	Fluid Tip: CONVENTIONAL: 1.2 - 1.5mm HVLP: 1.5 - 1.9mm Spraying Pressure: 400 kPa/ 4 bar 200 kPa/ 2 bar <small>Or refer to manufacturer's recommendations</small>
	Suction Feed	CONVENTIONAL: 1.4 - 1.8mm HVLP: 1.8 - 2.2mm 400 kPa/ 4 bar 200 kPa/ 2 bar. <small>Or refer to manufacturer's recommendations</small>
	Application	Apply two even coats
	Air Flash	5-10 minutes air flash
	Baking	30 mins @ 50°C (980-89290) 15 mins @ 50°C (980-89790)

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	Infrared	Short wave: 8 mins Medium wave: 10 - 15 mins
	Spraying	Use air fed mask at all times. Refer to applicable AS/NZS Standards

Recommendation:

Dulux recommend the complete painting of panels to provide maximum durability when applying topcoats such as clear coats. Blend outs will not give the appropriate film builds required and may break down prematurely.

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Weight Mixing Ratios for 488-S0016 AutoSpeed 2K MS Clear and Flex 485-89930

a. Using the Intelligent balance and adding by percentage addition

Note: This order of addition must be maintained when using the intelligent balance. The RFU quantity is approximately twice the clear that you start with.

488-S0016 AutoSpeed 2K MS Clear	100
485-89930 Flex Additive	20.0%
980-89290 2K Hardener	58.3%
920-89292 2K Thinner	5.3%

The quantity of thinner added can be varied to suit your spraying conditions. See notes below regarding alternate thinners and hardener.

b. Using an ordinary balance and adding by grams.

Volume of RFU Clear (ml)	488-S0016 Clear (g)	485-89930 Flex (g)	980-89290 Hardener* (g)	920-89292 Thinner ** (g)
50	24.69	4.94	17.28	2.47
100	49.39	9.88	34.56	4.93
150	74.09	14.82	51.84	7.4
200	98.78	19.76	69.12	9.86
250	123.48	24.7	86.4	12.33
300	148.17	29.64	103.68	14.79
350	172.9	34.58	121	17.23
400	197.6	39.52	138.2	19.72
450	222.2	44.46	155.5	22.19
500	247.0	49.4	172.8	24.65
550	271.6	54.34	190.1	27.11
600	296.3	59.28	207.4	29.58
650	321.0	64.22	224.6	32.04
700	345.7	69.16	241.9	34.51
750	370.4	74.1	259.2	36.98
800	395.1	79.04	276.5	39.44
850	419.8	83.98	293.8	41.90
900	444.5	88.92	311.0	44.37
950	469.2	93.86	328.3	46.84
1000 (1L)	493.9	98.8	345.6	49.3

* Use 980-89790 Autospeed RP 2K Hardener for improved production times

** Use 920-89819 Autospeed RP Thinner in cold weather or 920-89847 AutoSpeed 2K Thinner High Temp as required.

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Weight Mixing Ratios for 488-S0016 AutoSpeed 2K MS Clear

a. Using the Intelligent balance and adding by percentage addition

Note: This order of addition must be maintained when using the intelligent balance. The RFU quantity is approximately twice the clear that you start with.

488-S0016 AutoSpeed 2K MS Clear	100
980-89290 2K Hardener	50.00%
920-89292 2K Thinner	5.00%

The quantity of thinner added can be varied to suit your spraying conditions. See notes below regarding alternate thinners and hardener.

b. Using an ordinary balance and adding by grams.

Volume of RFU Clear (ml)	488-S0016 Clear (g)	980-89290 Hardener* (g)	920-89292 Thinner ** (g)
50	31.35	15.68	2.35
100	62.70	31.36	4.70
150	94.05	47.03	7.05
200	125.41	62.71	9.40
250	156.76	78.39	11.75
300	188.11	94.07	14.10
350	219.46	109.75	16.45
400	250.81	125.43	18.80
450	282.16	141.10	21.15
500	313.51	156.78	23.50
550	344.86	172.46	25.86
600	376.22	188.14	28.21
650	407.57	203.82	30.56
700	438.92	219.49	32.91
750	470.27	235.17	35.26
800	501.62	250.85	37.61
850	532.97	266.53	39.96
900	564.32	282.21	42.31
950	595.68	297.88	44.66
1000 (1L)	627.03	313.56	47.01

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920-89847 AutoSpeed 2K Thinner High Temp as required.

For Safe Handling:

Please refer to the Material Safety Data Sheet No: 1159 for this product before use. This product may contain materials that are being introduced to Australia under a permit.

In the event of an emergency contact: 1 800 033 111 (ALL HOURS)

For further information contact:

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