

# Technical Data Sheet

Top Speed Clearcoat is designed as part of the ClearSystem product line. It is a medium solids clear with ultra fast curing. It is designed to increase your production output.

## SUITABLE SUBSTRATES

Substrate		Substrate		Substrate	
Solvent-borne Basecoat	✓	Waterborne Basecoat	✓	Acrylic Lacquer	
1K Enamel		2K Enamel	✓		
OEM Finish & Old Paint Work - Reversible		OEM Finish & Old Paint Work - Non-Reversible	✓		

## MIXING



By Volume: 4 parts 20-8031 Top Speed Clearcoat  
 1 part 40-8064 Slow Activator ONLY  
 Optional: Up to 5% 6700 or 6700-F Series Urethane Grade Reducer\*

Pot Life 2 hours (@70°F (21°C) and 50% relative humidity)

\* Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC.

## FLASH TIMES/DRY TIMES



Flash Between Coats 1 - 3 minutes  
 Dust Free 10 minutes  
 Dry to Sand 30 minutes  
 Delivery 30 minutes  
 Force Drying Do not force dry.  
 Force drying will result in solvent popping and/or blushing.

## SURFACE PREPARATION



Tack surface thoroughly before application.

## SPRAY GUN SET-UP/APPLICATION



Gun Type	HVLP/LVLP	Gravity Feed
Fluid Tip	1.2 - 1.4	1.2 - 1.6
Air Pressure	10 PSI @ aircap	25 - 35 PSI @ gun inlet
Mil Thickness: 2 flowing coats (2.0 - 2.4 mils @ 1.0 - 1.2 mil per coat).		

## LIMITATIONS & PRECAUTIONS

- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.
- See next page for more detailed production application.

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## SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.4-1.6 mm	1.2-1.6 mm	1.0-1.2 mm	1.2-1.4 mm
Air Pressure	35-45 PSI (@gun)	25-35 PSI (@ gun)	40-50 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	8-10 PSI	N/A
<i>Always refer to gun manufacturer's recommendation for proper set up and spray pressure.</i>				

## SURFACE PREPARATION

Tack thoroughly before application.  
 For blending clearcoat refer to SOP #513 and # 514.

## ADDITIVES

**Additives:** Kicker (6417) - Do not use; will cause solvent popping and blushing.  
 Appearance Improver (6487) - Use only in extreme heat conditions.  
 Fisheye Remover (6737) - Can be used at a rate of ½ oz per sprayable quart.  
 Universal Urethane Flex Additive (9194) - Use with soft, flexible substrates. Refer to TDS for mixing information.

## APPLICATION & FILM BUILD

Apply 1 - 2 flowing coats using the spray gun setting listed above. Keep spray gun nozzle 6 - 10 inches from the vehicle to avoid entrapment of air in paint film. Always keep containers tightly closed to prevent moisture contamination. Clean equipment thoroughly after use.

**Critical Recoat Time:** Do not apply additional coats beyond the recommend application directions. If additional coats are necessary, wait at least 5 hours before applying more basecoat or clear. Lightly scuff surface and degrease before application.

**Film Build:** 2 coats @ 1.0 - 1.2 mils. Must have a minimum of 2.0 mils DFT.

## PRODUCT SPECIFICATIONS

Weight per gallon: 9.22	Shelf Life: 3 years
RTS Solids by Weight: 36%	Color: Clear Liquid
Approximate Coverage: 556 ft <sup>2</sup> /gal @ 1 mil	Size - Gallon (20-8031), Quart (40-8064)

## REGULATORY

Category: Clearcoat	20-8031	40-8064
VOC Actual	0.62#/gal (75 g/l)	1.86#/gal (222 g/l)
VOC Regulatory	1.58#/gal (190 g/l)	2.37#/gal (284 g/l)
Weight % of Volatiles	68.11	45.31
Weight % of Water	0	0
Weight % of Exempt Compounds	61.36	25.62
Volume % of Exempt Compounds	60.70	21.68
Density of Material #/gal	9.22	9.42
		with 40-8064
Ready to Use (less water, less exempt compounds)		1.85#/gal (221 g/l)