

Technical Data Sheet

2.1 Low VOC Clearcoat is an acrylic urethane clearcoat that meets all current and proposed VOC regulations. This product can be used with all solvent and water based basecoats. It is suitable for all automotive refinishing as well as trucks and equipment. It offers high gloss and superior finish when allowed to air dry or when force dried.

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 6531/6534 Kwik Finish Clearcoat
1 part 6800 Series Activators
Optional: Up to 10% 6700 or 6700-F Series Urethane Grade Reducer*

Pot Life 4 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 5-15 minutes
Dust Free 20-50 minutes
Dry to Sand 4-8 hours
Delivery 12 hours MIN
Force Drying 40 minutes @ 140°F (25°C) after specified flash time below

Activator	Flash Time	Dust Free
6854 Lightning	5-10 min	20-30 min
6874/6877 Spot & Panel	10-15 min	30-35 min
6894 Overall	10-15 min	35-45 min
6894HT/6897HT Hi Temp	10-15 min	40-50 min

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 - 1.4
Air Pressure 10 PSI @ aircap 25 - 35 PSI @ gun inlet
Mil Thickness: 2-3 coats (@ 1.2 mils per coat dry film thickness). Must have a minimum of 2.2 mils.

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	1.2-1.4 mm	1.0-1.2 mm	1.2-1.6 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) - Can be used at a rate of ¼ oz per sprayable quart.
Appearance Improver (6487) - Can be used at a rate of 1-2 oz per sprayable quart.
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 2 - 3 flowing coats (2.2 - 3.6 mils @ 1.2 mils per coat) using the spray gun setting listed above. Flash for 5 – 15 minutes depending on activator used (refer to flash/dry times on page one). 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: Can be recoated after eight hours (@ 75°F (24°C), and 50% relative humidity). Clearcoat must be sanded with 1200 grit or coarser paper prior to applying additional material.

Film Build: 2-3 coats @ 1.2 mils. Must have a minimum of 2.2 mils and not to exceed 3.6 mils.

PRODUCT SPECIFICATIONS

Weight per gallon: 9.41	Shelf Life: 3 years
RTS Solids by Weight: 34%	Color: Clear Liquid
Approximate Coverage: 527 ft ² /gal @ 1 mil	Size: Gallon (6531), Quart (6534)

REGULATORY

Category: Clearcoat	6531/6534	6854	6874/6877	6894	6894HT
VOC Actual	0.29#/gal (35 g/l)	3.5#/gal (420 g/l)	3.4#/gal (407 g/l)	3.52#/gal (422 g/l)	3.5#/gal (419 g/l)
VOC Regulatory	0.87#/gal (104 g/l)	3.64#/gal (437 g/l)	3.72#/gal (446 g/l)	3.63#/gal (435 g/l)	3.65#/gal (438 g/l)
Weight % of Volatiles	70.02	46.98	49.93	46.20	46.20
Weight % of Water	0	0	0	0	0
Weight % of Exempt Compounds	66.89	5.20	11.00	4.00	5.50
Volume % of Exempt Compounds	66.06	3.91	8.62	3.00	4.25
Density of Material #/gal	9.42	8.37	8.73	8.34	8.59
		with 6854	with 6874/6877	with 6894	with 6894HT
Ready to Use (less water, less exempt compounds)		2.02#/gal (242 g/l)	2.02#/gal (242 g/l)	2.02#/gal (242 g/l)	2.02#/gal (242 g/l)