

# Technical Data Sheet

Finish-Tec® Hi-Gloss Clearcoat is an acrylic urethane clearcoat formulated for higher temperatures and bake booths. It meets all current and proposed national VOC regulations. It can be used with all solvent and water based basecoats. It is suitable for all automotive refinishing as well as trucks and equipment.

## 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 6861 Hi-Gloss Clearcoat  
1 part 6800 Series Activators  
Optional: Up to 10% 6700 or 6700-F Series Urethane Grade Reducer\*

Pot Life 2-3 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 3-15 minutes  
Dust Free 10-45 minutes  
Dry to Sand 4-10 hours  
Delivery 6-12 hours MIN  
Force Drying 30 minutes @ 140°F (25°C) after a 5-10 minute flash

Activator	Flash Time	Dust Free
6854 Lightning	3-5 min	10-15 min
6874/6877 Spot & Panel	10-15 min	20-30 min
6894 Overall	10-15 min	25-35 min
6894HT/6897HT Hi Temp	10-15 min	35-45 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	1.2-1.6 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

*Always refer to gun manufacturer's recommendation for proper set up and spray pressure.*

## 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 ½ 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 using the spray gun setting listed above. Flash for 3 – 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:** Do not flash for more than 1 hour between coats. If more than 1 hour @ 70°F (21°C) is reached, wait at least 5 hours before applying more clear or basecoat. Lightly scuff surface and degrease before application.

**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: 7.91	Shelf Life: 3 years
RTS Solids by Weight: 42%	Color: Clear Liquid
Approximate Coverage: 567 ft <sup>2</sup> /gal @ 1 mil	Size: Gallon (6861)

## REGULATORY

Category: Clearcoat	6861	6854	6874/6877	6894	6894HT
VOC Actual	3.14#/gal (377 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	4.18#/gal (500 g/l)	3.65#/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	60.45	46.98	49.93	46.20	46.20
Weight % of Water	0	0	0	0	0
Weight % of Exempt Compounds	20.68	5.20	11.00	4.00	5.50
Volume % of Exempt Compounds	24.73	3.92	8.62	3.00	4.25
Density of Material #/gal	7.91	8.39	8.73	8.34	8.59
		with 6854	with 6874/6877	with 6894	with 6894HT
Ready to Use (less water, less exempt compounds)		4.05#/gal (485 g/l)	4.07#/gal (488 g/l)	4.04#/gal (485 g/l)	4.05#/gal (485 g/l)