

# Technical Data Sheet

Kwik Finish Clearcoat is an acrylic urethane clearcoat. It can be used with all solvent based and water based basecoats. It can be buffed in 2 hours at 75°F (24°C). With Kwik Finish a shop can clearcoat, buff/polish and deliver the vehicle in the same day! The reduced bake time requirements enable over twice as many vehicles to be processed through the paint booths. These advantages translate into less energy usage and more profit per job.

## 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 6571/6574 Kwik Finish Clearcoat  
1 part 6800 Series Activators  
Optional: Up to 10% 6700 or 6700-F Series Urethane Grade Reducer\*

Pot Life 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 2-15 minutes  
Dust Free 10-30 minutes  
Dry to Sand 1-2 hours  
Delivery 1-3 hours MIN  
Force Drying 15 minutes @ 140°F (25°C) without purging

Activator	Flash Time	Dust Free
6854 Lightning	2-3 min	10-15 min
6874/6877 Spot & Panel	3-5 min	10-20 min
6894 Overall	5-10 min	15-25 min
6894HT/6897HT Hi Temp	10-15 min	20-30 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	1.2-1.4 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) - Should not be used in temps above 65°F (24°C). For temps below 65°F (24°C) use 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. Flash for 2-15 minutes between coats depending on activator used. Keep spray gun nozzle 6-10 inches from vehicle to avoid entrapment of air in paint film. Keep containers closed to prevent moisture contamination. Clean equipment thoroughly after use.

**Critical Recoat Time:** Do not flash for more than 20 minutes between coats. If more than 45 minutes @ 70°F (21°C) is reached, wait at least 3 hours before applying more clear or basecoat. For Temps above 85°F (28°C), do not flash more than 15 minutes between coats. 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: 9.41	Shelf Life: 3 years
RTS Solids by Weight: 34%	Color: Clear Liquid
Approximate Coverage: 524 ft <sup>2</sup> /gal @ 1 mil	Size: Gallon (6571), Quart (6574)

## REGULATORY

Category: Clearcoat	6571/6574	6854	6874/6877	6894	6894HT
VOC Actual	0.33#/gal (40 g/l)	3.5#/gal (420 g/l)	3.4#/gal (407 g/l)	3.5#/gal (422 g/l)	3.5#/gal (419 g/l)
VOC Regulatory	0.97#/gal (117 g/l)	3.7#/gal (437 g/l)	3.7#/gal (446 g/l)	3.6#/gal (435 g/l)	3.7#/gal (438 g/l)
Weight % of Volatiles	70.13	46.98	49.93	46.20	46.20
Weight % of Water	0	0	0	0	0
Weight % of Exempt Compounds	66.59	5.20	11.00	4.00	5.50
Volume % of Exempt Compounds	65.71	3.92	8.62	3.00	4.25
Density of Material #/gal	9.41	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)		2.1#/gal (250 g/l)	2.1#/gal (249 g/l)	2.1#/gal (250 g/l)	2.1#/gal (250 g/l)