

Technical Data Sheet

Matte Urethane Clearcoat is designed to offer a matte gloss look as well as to duplicate low gloss OEM Finishes, while offering the UV protection and durability of a standard clear coat finish.

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: Less than 10% Gloss
 4 parts Urethane Matte Clearcoat
 1 part 6800 Series Activators
 Pot Life 4 hours (@70°F (21°C) and 50% relative humidity)

FLASH TIMES/DRY TIMES



Flash Between Coats 10-15 minutes
 Dust Free 20-50 minutes
 Delivery 6-24 hours
 Force Drying 30 minutes @ 140°F (60°C) after dust free flash time, allow 2 hours cool down prior to further work

Activator	Flash Time	Dust Free	Delivery
6854 Lightning	10-15 min	20-30 min	6-8 hours
6874/6877 Spot & Panel	10-15 min	30-35 min	16-24 hours
6894 Overall	10-15 min	35-45 min	16-24 hours
6894HT/6897HT Hi Temp	10-15 min	40-50 min	16-24 hours

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.

IMPORTANT INFORMATION

- As with any reduced gloss material, be sure to thoroughly shake before opening, then stir from the bottom of the can to ensure all flattening agents are evenly dispersed.
- Do NOT use if temperature is below 60°F (15°C). Be sure spray environment is clean and tack job thoroughly before application.
- Use accurate weights and measures to ensure proper mixes.
- Blending not recommended, full panel spray out is recommended.
- Apply EVEN wet coats. Heavy wet coats will increase the gloss level.
- Observe flash times for proper flat finish.
- Do NOT buff, sand, wax or polish surface. This will increase the gloss level, changing the appearance of the finish.
- If mixed with other components, mixture may be hazards of all combined components.

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.

Visit www.tat-co.com to assure you are using most updated TDS, to view in other languages and for links to Standard Operating Procedures (SOPs).

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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.

ADDITIVES

Additives: Kicker (6417) - Do not use. Appearance Improver (6487) - Do not use.
 Fisheye Remover (6737) - Do not use. Universal Urethane Flex Additive (9194) - Do not use.

APPLICATION & FILM BUILD

Apply 2 - 3 even wet coats (2.2 - 3.6 mils @ 1.2 mils per coat). Flash for 10 – 15 minutes depending on activator used (refer to drying chart on page one). Keep spray gun nozzle 6 - 10 inches from the vehicle to avoid entrapment of air in paint film. Extreme differences in film build and inconsistent spray techniques will cause variations in gloss and possible banding or striping of finish. 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.

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: 9.56	Shelf Life: 3 years
RTS Solids by Weight: 36%	Color: Translucent Liquid
Approximate Coverage: 500 ft ² /gal @ 1 mil	Size: Quart

REGULATORY

Category: Clearcoat	20-0094	6854	6874/6877	6894	6894HT/6897HT
VOC Actual	0.37#/gal (44 g/l)	3.50#/gal (419 g/l)	3.40#/gal (407 g/l)	3.52#/gal (422 g/l)	3.50#/gal (419 g/l)
VOC Regulatory	1.01#/gal (121 g/l)	3.64#/gal (436 g/l)	3.72#/gal (446 g/l)	3.63#/gal (435 g/l)	3.65#/gal (438 g/l)
Weight % of Volatiles	67.07	46.98	49.93	46.20	46.20
Weight % of Water	0	0	0	0	0
Weight % of Exempt Compounds	63.18	5.20	11.00	4.00	5.50
Volume % of Exempt Compounds	63.34	3.91	8.62	3.00	4.25
Density of Material #/gal	9.56	8.37	8.73	8.34	8.59
		with 6854	with 6874	with 6894	with 6894HT
Ready to Use (less water, less exempt compounds)		2.05#/gal (246 g/l)	2.05#/gal (246 g/l)	2.05#/gal (246 g/l)	2.06#/gal (246 g/l)