

Technical Data Sheet

Optimum Clear is an acrylic urethane clearcoat for basecoat/clearcoat systems that can be used with all solvent and waterborne basecoats. It is suitable for all automotive refinishing as well as trucks and equipment. Optimum clear has fast dry, sand and delivery times allowing for quick movement through the shop!

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: 2 parts 20-0171 Optimum Clear
1 part 6800 Series Clearcoat Activators
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 5-10 minutes
Dust Free 10-25 minutes
Dry to Sand 2-3 hours
Delivery 4 hours
Force Drying (only with 6896HT activator) 10-20 minutes @ 120°F (49°C) immediately without purging

Activator	Flash Time	Dust Free
6856 Lightning (coming soon)	5 min	5 - 10 min
6876 Medium	5 - 10 min	15 - 20 min
6896 Slow	10 - 15 min	25 - 35 min
6896HT Hi-Temp	20 - 25 min	30 - 40 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: 1.0-1.5 mil per coat (dry film thickness) Must have a minimum of 2.0 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.

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).

TRANSTAR AUTOBODY TECHNOLOGIES • 2040 HEISERMAN DRIVE, BRIGHTON, MI 48114 • (800) 824-2843

FAX (800) 477-7923 • EMAIL: info@tat-co.com

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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) - Can be used in temperatures BELOW 65°F (18°C) at 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 9194 TDS for mixing information.

APPLICATION & FILM BUILD

Apply 2 coats using the spray gun setting listed above. Flash for 5 – 10 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 30 minutes between coats. If more than 30 minutes at 70°F (21°C) is reached, wait for at least 3 hours before applying more clearcoat or basecoat. For temperatures above 85°F (29°C), do not flash more than 20 minutes between coats. Lightly scuff surface and degrease before application.

Film Build: 2 coats @ 1.0-1.5 mils. Must have a minimum of 2.0 mils.

PRODUCT SPECIFICATIONS

Weight per gallon: 8.12	Shelf Life: 3 years
RTS Solids by Weight: 47.50	Color: Clear Liquid
Approximate Coverage: 614 ft ² /gal @ 1 mil	Size: 5 Liter Clear (20-0171), 2.5 Liter Activators (6876/6896/6896HT)

REGULATORY

Category: Clearcoat	20-0171	6856	6876	6896	6896HT
VOC Actual	2.22#/gal (266 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	3.23#/gal (387 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	55.25	46.98	49.93	46.20	46.20
Weight % of Water	0	0	0	0	0
Weight % of Exempt Compounds	27.85	5.20	11.00	4.00	5.50
Volume % of Exempt Compounds	31.12	3.91	8.62	3.00	4.25
Density of Material #/gal	8.12	8.37	8.73	8.34	8.59
		6856	6876	6896	6896HT
Ready to Use (less water, less exempt compounds)		3.40 #/gal (407 g/l)	3.42 #/gal (410 g/l)	3.39 #/gal (407 g/l)	3.40 #/gal (407 g/l)

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