

# Technical Data Sheet

Transtar Select Flash OR3001 Clearcoat is a medium solids, fast cure clearcoat for spot and panel topcoating. It has 10 minute dust, 20 minute touch and 30 minute polish times.

## 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 OR3001 Select Flash Clearcoat  
1 part OR1044 Select Activator Slow  
Optional: Up to 5% 6700 or 6700-F Series Urethane Grade Reducer\*

Pot Life 2 hours (@78°F 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



Dust Free 10 minutes  
Print Free 20 minutes  
Polish/Delivery 30 minutes  
Force Drying Do not force dry. It will result in solvent popping and/or blushing.

## SURFACE PREPARATION



Tack surface thoroughly before application.

## SPRAY GUN SET-UP/APPLICATION



Gun Type HVLP/LVLP Gravity Feed  
Fluid Tip 1.2 - 1.4 mm 1.2 - 1.6 mm  
Air Pressure 10 PSI @ aircap 25 - 35 PSI @ gun inlet  
Mil Thickness: 1 double coat (@ 1.0 mils per pass 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.

# Technical Data Sheet

## SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	HVLP/LVLP
Fluid Tip	1.4-1.6 mm	1.2-1.6 mm	1.2-1.4 mm
Air Pressure	35-45 PSI (@gun)	25-35 PSI (@ gun)	10 PSI (@ aircap)
Fluid Pressure	N/A	N/A	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) - Do not use, will cause solvent popping/blushing.  
Appearance Improver (6487) - Use only in extreme heat conditions at a rate of 1-2 oz per sprayable quart.  
Fisheye Remover (6737) - Can be used at a rate of 1/2 oz per sprayable quart.  
Universal Urethane Flex Additive (9194) - Use with soft, flexible substrates. Refer to TDS for mixing information. Additionally, the use of Universal Urethane Flex Additive will increase dry times (15 minutes), cure times (45 minutes) and polish times (2 hours).

## APPLICATION & FILM BUILD

Apply 1 double coat. A double coat is one pass down and back up without any flash between. 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 apply additional coats per the application directions. If additional coats are needed, wait 5 hours before applying more basecoat or clearcoat. Lightly scuff surface and degrease before application.

Film Build: 1 double coat = 2.0 mils dry film thickness. (Must have a minimum of 2.0 mils.)

## PRODUCT SPECIFICATIONS

Weight per gallon: 9.22	Shelf Life: 3 years
RTS Solids by Weight: 36%	Color: Clear
Approximate Coverage: 556 ft <sup>2</sup> /gal @ 1 mil	

## REGULATORY

Category: Clearcoat	OR3001 Select Flash Clearcoat	OR1044 Select Activator Slow
VOC Actual	0.62#/gal (75 g/l)	1.86#/gal (222 g/l)
VOC Regulatory	1.58#/gal (190 g/l)	2.37#/gal (284 g/l)
Weight % of Volatiles	68.10	45.31
Weight % of Water	0	0
Weight % of Exempt Compounds	61.34	25.62
Volume % of Exempt Compounds	60.66	21.68
Density of Material #/gal	9.22	9.42
		with OR1044
Ready to Use (less water, less exempt compounds)		1.84#/gal (221 g/l)