

Technical Data Sheet

Transtar Select Royal OR3101 Clearcoat is a high solids clearcoat for multi-panel and overall repairs. It features excellent flexibility, UV protection and is highly resistant to stone chips and abrasions. This product is ideal for use over single stage or base/clearcoat applications.

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 OR3101 Select Royal Clearcoat
1 part Select Activators (OR1024/OR1034/OR1044)
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



Flash Between Coats 10-20 minutes
Dust Free 20-45 minutes
Dry to Sand 6-8 hours
Delivery 12 hours
Force Drying 40 minutes @ 140°F (60°C) after a 5 minute flash

Activator	Flash Time	Dust Free
OR1024 - Fast	10 min	20-30 min
OR1034 - Medium	10-15 min	30-40 min
OR1044 - Slow	15-20 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 mm 1.2 - 1.4 mm
Air Pressure 10 PSI @ aircap 25 - 35 PSI @ gun inlet
Mil Thickness: 2-3 coats (@ 1.0 mils 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).

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SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	HVLP/LVLP
Fluid Tip	1.4-1.6 mm	1.2-1.4 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) - Can be used at a rate of 1/2 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 1/2 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 10-20 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 60 minutes between coats. If more than 60 minutes @ 70°F (21°C) is reached, wait at least 6 hours before applying more clear or basecoat. After 24 hours, lightly scuff the clearcoat before applying more material.

Film Build: 2-3 coats @ 1.0 mils. Must have a minimum of 2.0 mils.

PRODUCT SPECIFICATIONS

Weight per gallon: 8.87	Shelf Life: 3 years
RTS Solids by Weight: 47%	Color: Clear
Approximate Coverage: 727 ft ² /gal @ 1 mil	

REGULATORY

Category: Clearcoat	OR3101 Select Royal Clear	OR1024 Select Activator Fast	OR1034 Select Activator Medium	OR1044 Select Activator Slow
VOC Actual	1.07#/gal (128 g/l)	1.86#/gal (223 g/l)	1.84#/gal (221 g/l)	1.86#/gal (222 g/l)
VOC Regulatory	1.89#/gal (226 g/l)	2.36#/gal (282 g/l)	2.36#/gal (282 g/l)	2.37#/gal (284 g/l)
Weight % of Volatiles	57.69	45.31	45.31	45.31
Weight % of Water	0	0	0	0
Weight % of Exempt Compounds	45.72	25.30	25.82	25.62
Volume % of Exempt Compounds	43.53	21.10	21.90	21.68
Density of Material #/gal	8.87	9.29	9.44	9.42
		with OR1024	with OR1034	with OR1044
Ready to Use (less water, less exempt compounds)		2.08#/gal (249 g/l)	2.07#/gal (249 g/l)	2.08#/gal (249 g/l)