

Technical Data Sheet

True Finish Urethane Clearcoat is a two component, universal urethane clearcoat designed for spot, panel and overall refinish jobs with a sprayable VOC of 2.1 #/gal. It is fast-drying, easy to use and provides a durable finish with excellent gloss.

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 4921-04 True Finish 2.1 Urethane Clearcoat
 1 part 5900 Series Activators
 Optional: Up to 5% 6700 or 6700-F Series Urethane Grade Reducer*

Pot Life 4 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 5-25 minutes
 Dust Free 10-25 minutes
 Dry to Sand 6-8 hours
 Delivery 12+ hours MIN
 Force Drying 40 minutes @ 140°F (25°C) after 5-10 minute flash

Activator	Flash Time	Dust Free
5901-04/5901-07 Fast	5-10 min	10-15 min
5902-04/5902-07 Medium	10-15 min	15-20 min
5903-04 Slow	20-25 min	20-25 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 - 1.6
 Air Pressure 10 PSI @ aircap 35 - 50 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	1.2-1.6 mm	1.2-1.6 mm	1.0-1.2 mm	1.2-1.6 mm
Air Pressure	35-50 PSI (@gun)	35-50 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 at a rate of ½ 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 - 3 flowing coats (2.2 - 3.6 mils @ 1.2 mils per coat) using the spray gun setting listed above. Flash for 5-25 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 1 hour between coats. If more than 1 hour @ 70°F (21°C) is reached, wait at least 8 hours before applying more clear or basecoat. 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: 9.42	Shelf Life: 3 years
RTS Solids by Weight: 33%	Color: Clear Liquid
Approximate Coverage: 527 ft ² /gal @ 1 mil	Size: Gallon

REGULATORY

Category: Clearcoat	4921-01	5901-04/5901-07	5902-04/5902-07	5903-04
VOC Actual	0.29#/gal (35 g/l)	3.4#/gal (407 g/l)	3.52#/gal (422 g/l)	3.5#/gal (419 g/l)
VOC Regulatory	0.87#/gal (104 g/l)	3.72#/gal (446 g/l)	3.63#/gal (435 g/l)	3.65#/gal (438 g/l)
Weight % of Volatiles	70.02	49.93	46.2	46.20
Weight % of Water	0	0	0	0
Weight % of Exempt Compounds	66.89	11.00	4.00	5.50
Volume % of Exempt Compounds	66.06	8.62	3.00	4.25
Density of Material #/gal	9.42	8.73	8.34	8.59
		with 5901	with 5902	with 5903
Ready to Use (less water, less exempt compounds)		2.0#/gal (241 g/l)	2.0#/gal (242 g/l)	2.0#/gal (242 g/l)