



PRODUCT DATA

6861, 6864 Hi-Gloss Clearcoat

DESCRIPTION:

Finish-Tec™ Hi-Gloss Clearcoat is an acrylic urethane clearcoat with a sprayable V.O.C. of 4.0 #/gal (using EPA Test Method 24) **formulated for higher temperatures and bake booths**. This product meets V.O.C. regulations of 5.0 #/gal V.O.C. for multi-stage two part systems and can be used with all solvent and water based basecoats. It is suitable for all automotive refinishing as well as trucks and equipment. To increase dry and polishing times, Hi-Gloss Clearcoat may be accelerated with Transtar Kicker #6417 at a rate of 1/4 to 1/2 ounce per sprayable quart.

TECHNICAL DATA:

| | |
|--------------|--|
| APPEARANCE: | Clear Liquid |
| % SOLIDS: | 42.0% RTU |
| VOC CONTENT: | 3.97 #/gal (475g/l) - As Packaged 3.97 #/gal Ready to Spray 4.40 #/gal RTU using 1/2 part reducer |
| SHELF LIFE: | One Year (unopened) |
| REDUCERS: | Use Transtar Urethane Grade Reducer depending upon shop temperature. Note: Adding reducer will increase V.O.C.'s. |
| MIX RATIO: | 4:1 (If reduction is desired, add up to 1/2 part Transtar Reducer) |
| ACTIVATORS: | 6800 Series Activators |
| POT LIFE: | 2 - 3 hours @ 68°F -75°F |
| COVERAGE: | 540 ft ² /gal at 1.0 mil |

SUITABLE SUBSTRATES:

Automotive refinish basecoats (water and solvent based); automotive refinish single stage (**except acrylic lacquer**); existing finishes that have been sanded and cleaned.

SEE REVERSE SIDE FOR APPLICATION INSTRUCTIONS

(Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin.)

PACKAGE SIZES:

#6861 Hi-Gloss Clearcoat, Gallon, 2/case

#6864 Hi-Gloss Clearcoat, Quart, 6/case

DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on Transtar Autobody Technologies experience and research and is believed to be reliable. As Transtar has no control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.



6861, 6864

Hi-Gloss Clearcoat

INSTRUCTIONS:

Follow manufacturer's instructions for basecoat/topcoat applications regarding flash times and dry times before the application of Hi-Gloss Clearcoat. Use a measuring stick or Mixing Cup #6350 for easy and accurate mixing. When reducing, use the Transtar Urethane Grade Reducer suitable for shop temperatures. Keep containers tightly closed when not in use to avoid moisture contamination. Clean equipment thoroughly after each use.

APPLICATION:

Stir or shake product before use. Apply 2-3 medium wet flowing coats using the gun settings listed in the table below. Allow 10 - 15 minutes flash time between coats (depending upon activator used). For optimum appearance, activate Clear immediately before applying. **Hi-Gloss Clearcoat should not be applied over acrylic lacquers.**

| GUN TYPE | FLUID TIP | AIR PRESSURE | FLUID PRESSURE |
|---------------|--------------|--------------------------------|----------------|
| Siphon Feed | 1.4 - 1.6 mm | 35 - 45 PSI(at gun) | n/a |
| Gravity Feed | 1.2 - 1.6 mm | 25 - 35 PSI(at gun) | n/a |
| Pressure Feed | 1.0 - 1.2 mm | 40 - 50 PSI(at gun) | 8- 10 PSI |
| HVLP | 1.2 - 1.6 mm | 10 PSI <u>Max.</u> (at aircap) | n/a |

DRYING SCHEDULE @ 77°F, 50% RELATIVE HUMIDITY:

| ACTIVATORS | FLASH TIME | DUST FREE | DRY TO SAND | DELIVERY |
|------------------------------|--------------|--------------|-------------|-----------|
| 6854 Lightning Activator | 6 min | 15 min | 4.5 hours | 6 hours |
| 6874 Extra Solids Spot/Panel | 10 - 15 min. | 20 - 30 min. | 6-8 hours | 16+ hours |
| 6894 Extra Solids Overall | 10 - 15 min. | 25 - 35 min. | 6-8 hours | 16+ hours |
| 6894-HT Overall Hi-Temp | 10 - 15 min. | 35 - 45 min. | 6-8 hours | 16+ hours |

NOTE: Hi-Gloss Clearcoat may be force dried after a 5-10 minute flash, baking at 140°F (60°C) for 30 minutes. Do not flash for more than one hour between coats. If more than one hour @ 70°F (21°C) is reached, wait at least 5 hours before applying more clear or basecoat.

POLISHING RECOMMENDATION:

For dirt removal, lightly nib sand with 1500 grit wet sandpaper and compound with Finish-Tec™ Ultimate Finish System Tri-Cut #5334. Finish with Transtar's Final Finish #5354. It is best to compound within 24 hours of application

TIPS FOR USE OF 6861 HI-GLOSS CLEARCOAT:

For small jobs (spot and panel) no reduction should be necessary. For larger areas, the use of 6894 or 6894-HT and extra slow speed reducer #6751 will help in achieving excellent flow and leveling.

USE WITH KICKER (#6417):

This clear has a strong cure response with the use of Kicker. Below are the sand and buff/repair times when using various amounts of Kicker.

| OZ'S/ RTU QT. | SAND&BUFF/ REPAIR TIMES |
|------------------|----------------------------|
| 0 | 6 - 8 HOURS |
| 1/4 | 4 - 6 HOURS |
| 1/2 | 3 - 5 HOURS |

NOTE:

These times are for application conditions of 75°F and 50% relative humidity. When repairing, wet sand with 600-800 grit removing all the gloss before reapplying subsequent coatings.

COMPETITION:

| | | | |
|------------------|---------------------------|--------|---------|
| Sherwin Williams | CC633 | | |
| PPG | DCU 2042, DCU 2082, D-893 | RM | DC-88NR |
| DuPont | V-7500S, V7800S | Matrix | MS42 |
| UTech | H.S. Clearcoat | | |