

Technical Data Sheet

Signature Series Production Clearcoat is a premium 2K, medium solids clearcoat that provides outstanding durability and gloss for panel, multi-panel and overall repairs. Its 15 minute dust free time enables customers to perform efficient repairs in their every day repair processes without sacrificing durability or appearance.

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 9511/9514 Production Clearcoat
 1 part 9400 Series 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 5-15 minutes
 Dust Free 10-25 minutes
 Dry to Sand 2-3 hours
 Delivery 4 hours
 Force Drying 10-20 minutes @ 140°F (60°C)

| Activator | Flash Time | Dust Free |
|------------------|------------|-----------|
| 9404 Fast | 5 min | 10-15 min |
| 9414/9417 Medium | 5-10 min | 15-20 min |
| 9424/9427 Slow | 5-15 min | 15-25 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 - 1.4 |
| Air Pressure | 10 PSI @ aircap | 25 - 35 PSI @ gun inlet |
| Mil Thickness: 2-3 coats (@ 1.2 mils per coat dry film thickness) | | |

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 | 1.4-1.6 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 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 TDS for mixing information.

APPLICATION & FILM BUILD

Apply 2 - 3 flowing coats using the spray gun setting listed above. Flash for 5 – 15 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 5 hours before applying more clear or basecoat. Lightly scuff surface and degrease before application.

Film Build: 2-3 coats @ 1.2 mils per coat. Must have a minimum of 2.4 mils and not to exceed 3.6 mils.

PRODUCT SPECIFICATIONS

| | |
|--|-----------------------------------|
| Weight per gallon: 9.30 | Shelf Life: 3 years |
| RTS Solids by Weight: 36% | Color: Clear Liquid |
| Approximate Coverage: 493 ft ² /gal @ 1 mil | Size: Gallon (9511), Quart (9514) |

REGULATORY

| Category: Clearcoat | 9511/9514 | 9404 | 9414/9417 | 9424/9427 |
|--|---------------------|---------------------|---------------------|---------------------|
| VOC Actual | 0.65#/gal (77 g/l) | 1.86#/gal (223 g/l) | 1.84#/gal (221 g/l) | 1.86#/gal (222 g/l) |
| VOC Regulatory | 1.62#/gal (194 g/l) | 2.36#/gal (282 g/l) | 2.36#/gal (282 g/l) | 2.37#/gal (284 g/l) |
| Weight % of Volatiles | 68.38 | 45.31 | 45.31 | 45.31 |
| Weight % of Water | 0 | 0 | 0 | 0 |
| Weight % of Exempt Compounds | 61.44 | 25.30 | 25.82 | 25.62 |
| Volume % of Exempt Compounds | 60.13 | 21.10 | 21.90 | 21.68 |
| Density of Material #/gal | 9.30 | 9.29 | 9.44 | 9.42 |
| | | with 9404 | with 9414/9417 | with 9424/9427 |
| Ready to Use (less water, less exempt compounds) | | 1.86#/gal (223 g/l) | 1.86#/gal (223 g/l) | 1.87#/gal (224 g/l) |