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# PRODUCT DATA

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**6861, 6864**

## **Hi-Gloss Clearcoat**

### **DESCRIPTION:**

Finish-Tec<sup>®</sup> Hi-Gloss Clearcoat is an acrylic urethane clearcoat **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 (RTU):	Weight: 42%    Volume: 35%
VOC CONTENT:	4.20#/gal (504 g/l) - Ready to Spray
SHELF LIFE:	One Year (unopened)
REDUCERS:	Use Transtar Urethane Grade Reducer #6700 Series 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)
POT LIFE:	2 - 3 hours @ 68° - 75°F (20° - 24°C)
COVERAGE:	565 ft <sup>2</sup> /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.

### **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.

### **SEE REVERSE SIDE FOR APPLICATION INSTRUCTIONS**

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

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### **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

### 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.**

### SPRAY GUN SET-UP:

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/LVLP	1.2 - 1.6 mm	10 PSI max. (at aircap)	n/a

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

ACTIVATOR	FLASH TIME	DUST FREE	SAND	DELIVERY
6854	5 min	10 min	4 - 5 hrs	6 hrs
6874/6877	10 - 15 min	20 - 30 min	6 - 8 hrs	16 + hrs MIN
6894	10 - 15 min	25 -35 min	6 - 8 hrs	16 + hrs MIN
6894HT	10 - 15 min	35 - 45 min	6 - 8 hrs	16 + hrs MIN

**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 Tri-Cut II #5331/5334. Finish with 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 6894HT 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 Quart	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 & 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
DuPont	V-7500S, V7800S
UTech	H.S. Clearcoat
RM	DC-88NR
Matrix	MS42