

PRODUCT HIGHLIGHTS

6531, 6534

2.1 Low V.O.C. Clearcoat

DESCRIPTION:

Finish-Tec® 2.1 Low V.O.C Clearcoat is an acrylic urethane clearcoat with a sprayable V.O.C. of 2.1 #/gal (using EPA Test Method 24) for spot, panel and overall refinishing. This product can be used with all solvent based and water based basecoats.



PRODUCTS:

- 6531 2.1 Low V.O.C. Clearcoat, Gallon (3.78 L), 2 case
- 6534 2.1 Low V.O.C. Clearcoat, Quart (0.946 L), 4/case



SURFACE PREP:

Tack thoroughly before application.



MIX RATIO:

4:1
 Pot Life: 4 hours @ 68°-75°F (20°-24°C)



REDUCER:

Optional: Use Transtar's Zero VOC Urethane Grade Reducer (TDS601) or Urethane Grade Reducer (TDS600) appropriate to shop conditions.



HVLP/LVLP:

1.2 - 1.6 mm
 2 - 3 medium wet coats



5-10 minute flash
 1.2 mil per coat (dry film thickness)

Please refer to gun manufacturer for proper spray pressure recommendations.



DRY TO SAND TIMES:

DRYING SCHEDULE @ 77°F (25°C), 50% R.H.:

ACTIVATOR	FLASH TIME	DUST FREE	SAND	DELIVERY
6854	5 - 10 min	20 - 30 min	4 - 6 hrs	6 - 8 hrs
6874/6877	10 - 15 min	30 - 35 min	6 - 8 hrs	12 hrs MIN
6894	10 - 15 min	35 - 45 min	6 - 8 hrs	12 hrs MIN
6894HT	10 - 15 min	40 - 50 min	6 - 8 hrs	12 hrs MIN



SANDING:

DA (Dry): #1200-1500, finish #2000

Hand (Wet): #1200-1500, finish #2000

See next page for more detailed product application. See website for this document in other languages.
 Vea la página siguiente para un uso más detallado del producto. Vea el Web site para este documento en español.
 Voir la prochaine page pour une application plus détaillée de produit. Voir le site Web pour ce document en français.

PRODUCT DATA

6531,6534

2.1 Low V.O.C. Clearcoat

SURFACE PREPARATION:

Tack thoroughly before application.

MIXING & APPLICATION

The mixing ratio by volume for this product is: 4 parts Clearcoat #6531/6534 and 1 part Activator Series (TDS600 or TDS601). Clearcoat should not be applied over acrylic lacquers, or unsanded existing finishes.



Use a measuring stick or mixing cup for easy and accurate measuring. Recommended spraying viscosity is 14-15 seconds using a Zahn #2 cup (@77°F (25°C)). Pot life of activated material is 4 hours at 70°F (21°C) and 50% relative humidity. Follow base/top coat manufacturer's instructions regarding flash and dry times prior to application of Transtar's 2.1 Low V.O.C. Clearcoat. Always keep containers tightly closed to prevent moisture contamination. Clean equipment thoroughly after use.

Apply 2 - 3 flowing coats (2.2 - 3.6 mils @ 1.2 mils per coat) using the spray gun setting listed above. For optimum appearance, activate clearcoat immediately before applying. Keep spray gun nozzle 6 - 10 inches from the vehicle to avoid entrapment of air in paint film.

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 - 1.4 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 - 1.4 mm	10 PSI max. (at aircap)	n/a

TECHNICAL DATA:

APPEARANCE: Clear Liquid
% SOLIDS (RTU): Weight: 34% Volume: 33%
SHELF LIFE: One year (unopened)
REDUCER: Optional: Transtar Urethane Grade Reducer (TDS600 or TDS601)
Note: Reduction with 6700 Series reducer (TDS600) increases the V.O.C. of the product mixture, reduction with 6700-F Series reducer (TDS601) does not increase V.O.C.
MIX RATIO: 4:1
POT LIFE: 4 hours @ 68°-75°F (20°-24°C)
COVERAGE: 527 ft²/gal @ 1 mil.

See website (www.tat-co.com) for this document in other languages.

Vea el Web site (www.tat-co.com) para este documento en español.

Voir le site Web (www.tat-co.com) pour ce document en français.

6531,6534

2.1 Low V.O.C. Clearcoat

REGULATORY:

Category: Clear Coating	Individual Component
VOC Actual	0.29#/gal (35g/l)
VOC Regulatory (less water, less exempt compounds)	0.87#/gal (104g/l)
Weight % of Volatiles	70.02
Weight % of Water	0
Weight % of Exempt Compounds	66.89
Volume % of Exempt Compounds	66.06
Density of Material	9.42
Ready to Use (less water, less exempt compounds)	1.52#/gal (182g/l)

TECHNICAL TIPS:

REDUCTION:

2.1 Low V.O.C. Clearcoat may be reduced up to 10% by volume using the Transtar Urethane Grade Reducer (TDS600 or TDS601) suitable for the shop temperature. (Note: 6700 series reducers (TDS600) will increase sprayable VOC content and 6700-F series reducers (TDS601) will not increase VOC.)

CRITICAL RECOAT TIME:

Can be recoated after eight hours (@ 75°F (24°C), and 50% relative humidity). Clearcoat must be sanded with 1200 grit or coarser paper prior to applying additional material.

FORCE DRYING:

Allow clear to flash until dust free, then bake for 40 minutes at 140°F (60°C). Allow 2 hour cool down prior to further work.

POLISHING:

For dirt removal, lightly nib sand with 1500 grit wet sandpaper and compound with Cutting Compound (TDS404). Finish with Machine Polish (TDS405). For dark colors, use Swirl Remover (TDS406). It is best to compound within 24 hours of application blending.

COMPETITION:

Diamont DC98
PCL 2200 Euroclear
Valspar AC2135

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.