



Deep Gloss Clear

20-0101

Deep Gloss Clear is a premium 2K clearcoat that is specifically formulated for bake booths, provides excellent film build, able to match OEM finishes, easy to polish, and provides a high gloss finish. Deep Gloss has a 5 minute flash time and 30 minute bake cycle that enables shops to perform efficient repairs as part of their everyday repair processes without sacrificing durability or appearance.



Mix Ratio

2:1 – 2 parts 20-0101 Deep Gloss Clear to 1 part 40-0116 Deep Gloss Activator
 Can be reduced up to 5% with 6700 or 6700-F Series Urethane Grade Reducer*.
 Pot life: 2 hours (@70°F (21°C) and 50% R.H.).

** Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC.*



Suitable Substrates

- Solvent-borne basecoat
- Waterborne basecoat
- 2K enamel
- OEM finish & old paint work - non-reversible



Surface Prep & Application

Tack surface thoroughly before application. For blending clearcoat refer to SOP #513 and #514.

Apply 2 flowing coats. Flash for 5-15 minutes between coats. Keep spray gun nozzle 6-10 inches from vehicle to avoid entrapment of air in paint film. Keep containers closed to prevent moisture contamination. Clean equipment thoroughly after use.
 Critical recoat time: Do not flash for more than 60 minutes between coats. If more than 60 minutes @ 70°F (21°C) is reached, wait at least 6 hours before applying more clear. After 24 hours, lightly scuff the clearcoat before applying additional material.
 Film build: 2 coats @ 1.2 mils (dry film thickness). Must have a minimum of 2.2 mils and not to exceed 3.6 mils.

Note: Although Deep Gloss Baking Clear is formulated for force dry, it can also be air dried for 16+ hours at 75°F (24°C) and 50% RH.

Additives

Kicker (6417) Do not use.

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 1/2 oz per sprayable quart.

Flex Additive (9194)Use with soft, flexible substrates. Refer to TDS for mixing information.



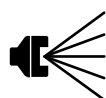
Flash Times/Dry Times

Flash between coats.....5-15 min
 Dust free.....30-45 min
 Dry to sand.....1 hr after cool down
 Deliver1 hr after cool down
 Force drying.....30 min@ 140°F (60°C).



Gun Set-up

Siphon feed.....1.4 - 1.6 mm	Gravity feed.....1.2 - 1.4 mm
Pressure feed1.0 - 1.2 mm	HVLP/LVLP1.2 - 1.4 mm



Air Pressure

Siphon feed (@ gun)35 - 45 psi	Gravity feed (@ gun)25 - 35 psi
Pressure feed (@ gun).....40 - 50 psi	HVLP/LVLP (@ aircap).....10 psi

Fluid Pressure

Pressure feed8 - 10 psi



Product Specifications

Color.....Clear	Size (20-0101)5 liter
Shelf life.....3 years	(40-0116)2.5 liter
RTS solids by weight.....40%	Weight per gallon.....8.3 #/gal
Approx. coverage.....644 ft ² /gal @ 1 mil	

Regulatory

20-0101

CategoryClearcoat	Wt % of volatiles.....55.46
VOC actual4.61#/gal (552 g/l)	Wt % of water0
VOC regulatory4.61#/gal (552 g/l)	Wt % of exempt compound0
Density8.30 #/gal	Vol % of exempt compound0
Ready to use (less water exempt compounds)	
40-01164.46 #/gal (535 g/l)	

40-8064

CategoryClearcoat	Wt % of volatiles.....50.26
VOC actual4.17#/gal (500 g/l)	Wt % of water0
VOC regulatory4.17#/gal (500 g/l)	Wt % of exempt compound0
Density8.31 #/gal	Vol % of exempt compound0



Limitations & Precautions

- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (www.tat-co.com) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.