

Technical Data Sheet

Deep Gloss Baking 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. You will only need one activator to perform any size job. 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.

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: 2 parts Deep Gloss Baking Clear 20-0101
 1 part Deep Gloss Baking Clear Activator 40-0116
 Pot Life 2-4 hours(@70°F (21°C) and 50% relative humidity)

FLASH TIMES/DRY TIMES



Flash Between Coats 5-15 minutes
 Dust Free 30-45 minutes
 Force Drying 30 minutes @ 140°F (60°C)
 Dry to Sand 1 hour after cool down
 Delivery 1 hour after cool down

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: 1.2 mils per coat (dry film thickness). Must have a minimum of 2.2 mils and not to exceed 3.6 mils.

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) - 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 ½ oz per sprayable quart.
Universal Urethane Flex Additive (9194) - Use with soft, flexible substrates. Refer to 9194 TDS for mixing information.

APPLICATION & FILM BUILD

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.

PRODUCT SPECIFICATIONS

Weight per gallon: 8.3 lb/gal	Shelf Life: 1 year
RTS Solids by Volume: 40%	Color: Clear Liquid
Approximate Coverage: 644 ft ² /gal @ 1 mil	Size: 5 Liter (20-0101), 2.5 Liter (40-0116)

REGULATORY

Category: Clearcoat	20-0101	40-0116
VOC Actual	4.61#/gal (552 g/l)	4.17#/gal (500 g/l)
VOC Regulatory	4.61#/gal (552 g/l)	4.17#/gal (500 g/l)
Weight % of Volatiles	55.46	50.26
Weight % of Water	0	0
Weight % of Exempt Compounds	0	0
Volume % of Exempt Compounds	0	0
Density of Material #/gal	8.30	8.31
Ready to Use (less water, less exempt compounds)		4.46#/gal (535 g/l)