

Technical Data Sheet

20-0011 Clearcoat is a 2K universal clearcoat designed for all refinish jobs. It is fast-drying, easy to use and provide a durable finish with excellent gloss.

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 20-0011 Clearcoat
1 part 40-0024/40-0034/40-0044 Activators
Reducer optional: Up to 5% 6700 or 6700-F Series Urethane Grade Reducer*

Pot Life 3 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 5-25 minutes
Dust Free 10-25 minutes
Dry to Sand 8-10 hours
Delivery 12 hours MIN
Force Drying 30 minutes @ 140°F (25°C) after a 5-10 minute flash

Activator	Flash Time	Dust Free
40-0024 Fast	5-10 min	10-15 min
40-0034 Medium	10-15 min	15-20 min
40-0044 Slow	20-25 min	20-25 min

SURFACE PREPARATION



Tack surface thoroughly before application.

SPRAY GUN SET-UP/APPLICATION



Gun Type HVLP/LVLP Gravity Feed
Fluid Tip 1.2 - 1.6 1.2 - 1.6
Air Pressure 10 PSI @ aircap 30 - 40 PSI @ gun inlet
Mil Thickness: 2-3 coats (@ 1.2 mils per coat dry film thickness). Must have a minimum of 2.0 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.

Visit www.tat-co.com to assure you are using most updated TDS, to view in other languages and for links to Standard Operating Procedures (SOPs).

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SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.2-1.6 mm	1.2-1.6 mm	1.0-1.2 mm	1.2-1.6 mm
Air Pressure	35-50 PSI (@gun)	35-50 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 surface 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 ¼ to 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. Flash for 5-25 minutes between coats depending on activator used. 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 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. Must have a minimum of 2.0 mils and not to exceed 3.6 mils.

PRODUCT SPECIFICATIONS

Weight per gallon: 7.62	Shelf Life: 1 year
RTS Solids by Weight: 36%	Color: Clear Liquid
Approximate Coverage: 474 ft ² /gal @ 1 mil	Size - Gallon (20-0011), Quart (40-0024, 40-0034, 40-0044)

REGULATORY

Category: Clearcoat	20-0011	40-0024	40-0034	40-0044
VOC Actual	3.66#/gal (439 g/l)	3.4#/gal (407 g/l)	3.52#/gal (422 g/l)	3.5#/gal (419 g/l)
VOC Regulatory	4.76#/gal (571 g/l)	3.72#/gal (446 g/l)	3.63#/gal (435 g/l)	3.65#/gal (438 g/l)
Weight % of Volatiles	68.13	49.93	46.2	46.20
Weight % of Water	0	0	0	0
Weight % of Exempt Compounds	20.06	11.00	4.00	5.50
Volume % of Exempt Compounds	23.12	8.62	3.00	4.25
Density of Material #/gal	7.62	8.73	8.34	8.59
	with 40-0024	with 40-0034	with 40-0044	
Ready to Use (less water, less exempt compounds)	4.53#/gal (542 g/l)	4.49#/gal (538 g/l)	4.5#/gal (539 g/l)	