



Optimum Clear

20-0171

Optimum Clear is an acrylic urethane clearcoat for basecoat/clearcoat systems that can be used with all solvent and waterborne basecoats. It is suitable for all automotive refinishing as well as trucks and equipment. Optimum clear has fast dry, sand and delivery times allowing for quick movement through the shop!



Mix Ratio

2:1 – 2 parts 20-0171 Optimum Clear to 1 part 6800 series activators
 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 coats using the spray gun setting listed on the next page. Flash for 5 – 10 minutes depending on activator used (refer to flash/dry times on next page). Keep spray gun nozzle 6 - 10 inches from the vehicle to avoid entrapment of air in paint film. Always keep containers tightly closed to prevent moisture contamination. Clean equipment thoroughly after use.
 Critical recoat time: Do not flash for more than 30 minutes between coats. If more than 30 minutes at 70°F (21°C) is reached, wait for at least 3 hours before applying more clearcoat or basecoat. For temperatures above 85°F (29°C), do not flash more than 20 minutes between coats. Lightly scuff surface and degrease before application.
 Film build: 2 coats @ 1.0-1.5 mils. Must have a minimum of 2.0 mils.

Additives

- Kicker (6417) Can be used in temperatures BELOW 65°F (18°C) at 1/4 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 1/2 oz per sprayable quart.
- Flex Additive (9194)Use with soft, flexible substrates. Refer to TDS for mixing information.



Flash Times/Dry Times

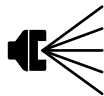
Flash between coats.....5-10 min
 Dust free.....10-25 min
 Dry to sand.....2-3 hrs
 Deliver4 hrs
 Force drying.....(only with 6896HT activator) 10-20 min @ 120°F (49°C)
 immediately without purging.

Activator	Flash time	Dust free
6856 Lightning	5 min	5-10 min
6876 Medium	5-10 min	15-20 min
6896 Slow	10-15 min	25-35 min
6896HT Hi-Temp	20-25 min	30-40 min



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.....5 liter
 Shelf life.....3 years RTS solids by weight.....47.5%
 Approx. coverage.....614 ft²/gal @ 1 mil Weight per gallon.....8.12 #/gal

Regulatory

20-0171

Category.....Clearcoat Wt % of volatiles.....55.25
 VOC actual.....2.22#/gal (266 g/l) Wt % of water0
 VOC regulatory.....3.23#/gal (387 g/l) Wt % of exempt compound27.85
 Density.....8.12 #/gal Vol % of exempt compound31.12
 Ready to use (less water exempt compounds)
 with 6856.....3.40#/gal (407 g/l)
 with 6876.....3.42#/gal (410 g/l)
 with 6896.....3.39#/gal (407 g/l)
 with 6896HT3.40#/gal (407 g/l)

6856

Category.....Clearcoat Wt % of volatiles.....46.98
 VOC actual.....3.5#/gal (420 g/l) Wt % of water0
 VOC regulatory.....3.64#/gal (437 g/l) Wt % of exempt compound5.20
 Density.....8.37 #/gal Vol % of exempt compound3.91

6876

Category	Clearcoat	Wt % of volatiles.....	49.93
VOC actual	3.4#/gal (407 g/l)	Wt % of water	0
VOC regulatory	3.72#/gal (446 g/l)	Wt % of exempt compound	11.00
Density	8.73 #/gal	Vol % of exempt compound	8.62

6896

Category	Clearcoat	Wt % of volatiles.....	46.20
VOC actual	3.52#/gal (422 g/l)	Wt % of water	0
VOC regulatory	3.63#/gal (435 g/l)	Wt % of exempt compound	4.00
Density	8.34 #/gal	Vol % of exempt compound	3.00

6896HT

Category	Clearcoat	Wt % of volatiles.....	46.20
VOC actual	3.5#/gal (419 g/l)	Wt % of water	0
VOC regulatory	3.65#/gal (438 g/l)	Wt % of exempt compound	5.50
Density	8.59 #/gal	Vol % of exempt compound	4.25



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.

LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.