



True Finish 2.1 Urethane Clearcoat

4921-01

True Finish Urethane Clearcoat is a two component, universal urethane clearcoat designed for spot, panel and overall refinish jobs with a sprayable VOC of 2.1 #/gal. It is fast-drying, easy to use and provides a durable finish with excellent gloss.



Mix Ratio

4:1 – 4 parts 4921-01 to 1 part 5900 series activators

Can be reduced up to 5% with 6700 or 6700-F Series Urethane Grade Reducer*.

Pot life: 4 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 - 3 flowing coats (2.2 - 3.6 mils @ 1.2 mils per coat) using the spray gun setting listed on the next page. Flash for 5-25 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 1 hour between coats. If more than 1 hour @ 70°F (21°C) is reached, wait at least 8 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 2.2 mils and not to exceed 3.6 mils.

Additives

Kicker (6417) Can be used at a rate of 1/2 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

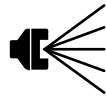
Flash between coats.....5-25 min
 Dust free.....10-25 min
 Dry to sand.....6-8 hrs
 Deliver12+ hrs MIN
 Force drying.....40 min @ 140°F (60°C) after 5-10 min flash.

Activator	Flash time	Dust free
5901-04/-07 Fast	5-10 min	10-15 min
5902-04/-07 Medium	10-15 min	15-20 min
5903-04 Slow	20-25 min	20-25 min



Gun Set-up

Siphon feed.....1.2 - 1.6 mm Gravity feed..... 1.2 - 1.6 mm
 Pressure feed1.0 - 1.2 mm HVLP/LVLP 1.2 - 1.6 mm



Air Pressure

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

Fluid Pressure

Pressure feed8 - 10 psi



Product Specifications

Color.....Clear Size.....Gallon
 Shelf life.....3 years RTS solids by weight..... 33%
 Approx. coverage.....572 ft²/gal @ 1 mil Weight per gallon..... 9.42 #/gal

Regulatory

4921-01

Category.....Clearcoat Wt % of volatiles..... 70.02
 VOC actual.....0.29#/gal (35 g/l) Wt % of water 0
 VOC regulatory.....0.87#/gal (104 g/l) Wt % of exempt compound 66.89
 Density.....9.42 #/gal Vol % of exempt compound 66.06
 Ready to use (less water exempt compounds)
 with 5901.....2.0#/gal (241 g/l)
 with 5902.....2.0#/gal (242 g/l)
 with 5903.....2.0#/gal (242 g/l)

5901-04

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

5902-04

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

5903-04

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

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