



2.1 Low VOC Clearcoat 6531, 6534

2.1 Low VOC Clearcoat is an acrylic urethane clearcoat that meets all current and proposed VOC regulations. This product can be used with all solvent and water based basecoats. It is suitable for all automotive refinishing as well as trucks and equipment. It offers high gloss and superior finish when allowed to air dry or when force dried.



Mix Ratio

4:1 – 4 parts 6531/6534 2.1 Low VOC Clearcoat to 1 part 6800 series activators
Can be reduced up to 10% 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 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 – 15 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: Can be recoated after eight hours (@ 75°F (24°C), and 50% relative humidity). Clearcoat must be sanded with 1200 grit or coarser paper prior to applying additional material.

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 1/4 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

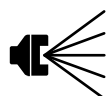
Flash between coats.....5-15 min
 Dust free.....25-50 min
 Dry to sand.....4-8 hrs
 Deliver12 hrs MIN
 Force drying.....40 min @ 140°F (60°C) after specified flash time below

Activator	Flash time	Dust free
6854/6856	5-10 min	15-25 min
6874/6876/6877	10-15 min	30-35 min
6894/6896	10-15 min	35-45 min
6894HT/6896HT/6897HT	10-15 min	40-50 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 - 1.6 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.....Translucent Size (6531).....Gallon
 Shelf life.....3 years (6534).....Quart
 RTS solids by weight.....34% Weight per gallon.....9.41 #/gal
 Approx. coverage.....527 ft²/gal @ 1 mil

Regulatory

6531/6534

Category.....Clearcoat	Wt % of volatiles.....70.02
VOC actual.....0.29#/gal (35 g/l)	Wt % of water0
VOC regulatory.....0.87#/gal (104 g/l)	Wt % of exempt compound66.89
Density.....9.42 #/gal	Vol % of exempt compound66.06
Ready to use (less water exempt compounds)	
with 6854.....2.02#/gal (242 g/l)	
with 6874.....2.02#/gal (242 g/l)	
with 6894.....2.02#/gal (242 g/l)	
with 6894HT2.02#/gal (242 g/l)	

6854/6856

Category.....Clearcoat	Wt % of volatiles.....46.98
VOC actual.....3.50#/gal (419 g/l)	Wt % of water0
VOC regulatory.....3.64#/gal (419 g/l)	Wt % of exempt compound5.20
Density.....8.37 #/gal	Vol % of exempt compound3.91

6874/6876/6877

Category.....Clearcoat	Wt % of volatiles.....49.93
VOC actual.....3.40#/gal (407 g/l)	Wt % of water0
VOC regulatory.....3.72#/gal (446 g/l)	Wt % of exempt compound11.00
Density.....8.73 #/gal	Vol % of exempt compound8.62

6894/6896

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

6894HT/6896HT/6897HT

Category	Clearcoat	Wt % of volatiles.....	46.20
VOC actual	3.50#/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.

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