



Kwik Finish Clearcoat

6571, 6574

Kwik Finish Clearcoat is an acrylic urethane clearcoat. It can be used with all solvent based and water based basecoats. It can be buffed in 2 hours at 75°F (24°C). With Kwik Finish a shop can clearcoat, buff/polish and deliver the vehicle in the same day! The reduced bake time requirements enable over twice as many vehicles to be processed through the paint booths.



Mix Ratio

4:1 – 4 parts 6571/6574 Kwik Finish Clearcoat to 1 part 6800 series activators
 Can be reduced up to 10% with 6700 or 6700-F Series Urethane Grade Reducer*.
 Pot life: 3 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. Flash for 2-15 minutes between coats depending on activator used (refer to flash/dry times on next page). 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 20 minutes between coats. If more than 45 minutes @ 70°F (21°C) is reached, wait at least 3 hours before applying more clear or basecoat. For Temps above 85°F (28°C), do not flash more than 15 minutes between coats. 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) Should not be used in temps above 65°F (24°C). For temps below 65°F (24°C) use 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

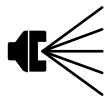
Flash between coats.....2-15 min
Dust free.....10-30 min
Dry to sand.....1-2 hrs
Deliver1-3 hrs MIN
Force drying.....15 min @ 140°F (60°C) without purging

Activator	Flash time	Dust free
6854/6856	2-3 min	10-15 min
6874/6876/6877	3-5 min	10-20 min
6894/6896	5-10 min	15-25 min
6894HT/6896HT/6897HT	10-15 min	20-30 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.....Translucent Size (6571).....Gallon
Shelf life.....3 years (6574).....Quart
RTS solids by weight.....34% Weight per gallon.....9.41 #/gal
Approx. coverage.....524 ft²/gal @ 1 mil

Regulatory

6571/6574

Category.....Clearcoat Wt % of volatiles.....70.13
VOC actual.....0.33#/gal (40 g/l) Wt % of water0
VOC regulatory.....0.97#/gal (117 g/l) Wt % of exempt compound66.59
Density.....9.41 #/gal Vol % of exempt compound65.71
Ready to use (less water exempt compounds)
with 6854.....2.1#/gal (250 g/l)
with 6874.....2.1#/gal (249 g/l)
with 6894.....2.1#/gal (250 g/l)
with 6894HT2.1#/gal (250 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.)
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