

# Technical Data Sheet

Kwik Gloss Clearcoat is a fast drying acrylic urethane clearcoat. It can be used with all solvent and water based basecoats to provide ultimate productivity and gloss. Kwik Gloss is formulated for use with a complete line of activators for application over a wide range of job sizes and temperatures. It is suitable for all automotive refinishing as well as trucks and equipment.

## 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 6841 Kwik Gloss Clearcoat  
1 part 6800 Series Activators  
Optional: Up to 10% 6700 or 6700-F Series Urethane Grade Reducer\*

Pot Life 4-6 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 5-15 minutes  
Dust Free 5-25 minutes  
Dry to Sand 4-8 hours  
Delivery 6-12 hours MIN  
Force Drying 30 minutes @ 140°F (25°C) after a 5-10 minute flash

Activator	Flash Time	Dust Free
6854 Lightning	5 min	5-10 min
6874/6877 Spot & Panel	5-10 min	5-10 min
6894 Overall	5-15 min	10-15 min
6894HT/6897HT Hi Temp	10-15 min	15-25 min

## SURFACE PREPARATION



Tack surface thoroughly before application.

## SPRAY GUN SET-UP/APPLICATION



Gun Type	HVLP/LVLP	Gravity Feed
Fluid Tip	1.2 - 1.4	1.2 - 1.4
Air Pressure	10 PSI @ aircap	25 - 35 PSI @ gun inlet

Mil Thickness: 2-3 coats (@ 1.2 mils per coat dry film thickness). Must have a minimum of 2.2 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.

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## SPRAY GUN SET-UP

Gun Type	Siphon Feed	Gravity Feed	Pressure Feed	HVLP/LVLP
Fluid Tip	1.4-1.6 mm	1.2-1.4 mm	1.0-1.2 mm	1.2-1.4 mm
Air Pressure	35-45 PSI (@gun)	25-35 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 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 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 using the spray gun setting listed above. Flash for 5 – 15 minutes depending on activator used (refer to flash/dry times on page one). 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 one hour between coats. If more than one 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 2.2 mils and not to exceed 3.6 mils.

## PRODUCT SPECIFICATIONS

Weight per gallon: 7.56	Shelf Life: 3 years
RTS Solids by Weight: 37%	Color: Clear Liquid
Approximate Coverage: 476 ft <sup>2</sup> /gal @ 1 mil	Size: Gallon (6841), Quart (6844)

## REGULATORY

Category: Clearcoat	6841/6844	6854	6874/6877	6894	6894HT
VOC Actual	2.96#/gal (355 g/l)	3.5#/gal (420 g/l)	3.4#/gal (407 g/l)	3.52#/gal (422 g/l)	3.5#/gal (419 g/l)
VOC Regulatory	4.42#/gal (530 g/l)	3.65#/gal (437 g/l)	3.72#/gal (446 g/l)	3.63#/gal (435 g/l)	3.65#/gal (438 g/l)
Weight % of Volatiles	68.00	46.98	49.93	46.20	46.20
Weight % of Water	0	0	0	0	0
Weight % of Exempt Compounds	28.80	5.20	11.00	4.00	5.50
Volume % of Exempt Compounds	32.95	3.92	8.62	3.00	4.25
Density of Material #/gal	7.56	8.39	8.73	8.34	8.59
		with 6854	with 6874/6877	with 6894	with 6894HT
Ready to Use (less water, less exempt compounds)		4.2#/gal (505 g/l)	4.2#/gal (508 g/l)	4.2#/gal (505 g/l)	4.2#/gal (506 g/l)