



# Hi-Gloss Clearcoat

## 6861

**Finish-Tec® Hi-Gloss Clearcoat is an acrylic urethane clearcoat formulated for higher temperatures and bake booths. It meets all current and proposed national VOC regulations. It can be used with all solvent and water based basecoats. It is suitable for all automotive refinishing as well as trucks and equipment.**



### Mix Ratio

4:1 – 4 parts 6861 Hi-Gloss Clearcoat to 1 part 6800 series activators  
 Can be reduced up to 10% with 6700 or 6700-F Series Urethane Grade Reducer\*.  
 Pot life: 2-3 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 using the spray gun setting listed on next page. Flash for 3 – 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: Do not flash for more than 1 hour between coats. If more than 1 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.

### 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**

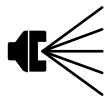
Flash between coats.....3-15 min  
 Dust free.....10-45 min  
 Dry to sand.....4-10 hrs  
 Deliver .....6-12 hrs MIN  
 Force drying.....30 min @ 140°F (60°C) after a 5-10 min flash

Activator	Flash time	Dust free
6854/6856	3-5 min	10-15 min
6874/6876/6877	10-15 min	20-30 min
6894/6896	10-15 min	25-35 min
6894HT/6896HT/6897HT	10-15 min	35-45 min



**Gun Set-up**

Siphon feed.....1.4 - 1.6 mm Gravity feed..... 1.2 - 1.6 mm  
 Pressure feed .....1.0 - 1.2 mm HVLP/LVLP ..... 1.2 - 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 feed .....8 - 10 psi



**Product Specifications**

Color.....Translucent Size.....Gallon  
 Shelf life.....3 years RTS solids by weight..... 42%  
 Approx. coverage.....567 ft<sup>2</sup>/gal @ 1 mil Weight per gallon..... 7.91 #/gal

**Regulatory**

**6861**

Category.....Clearcoat	Wt % of volatiles..... 60.45
VOC actual.....3.14#/gal (377 g/l)	Wt % of water ..... 0
VOC regulatory.....4.18#/gal (500 g/l)	Wt % of exempt compound ..... 20.68
Density.....7.91 #/gal	Vol % of exempt compound ..... 24.73
Ready to use (less water exempt compounds)	
with 6854.....4.05#/gal (485 g/l)	
with 6874.....4.07#/gal (488 g/l)	
with 6894.....4.04#/gal (485 g/l)	
with 6894HT .....4.05#/gal (485 g/l)	

**6854/6856**

Category.....Clearcoat	Wt % of volatiles..... 46.98
VOC actual.....3.50#/gal (419 g/l)	Wt % of water ..... 0
VOC regulatory.....3.64#/gal (419 g/l)	Wt % of exempt compound ..... 5.20
Density.....8.37 #/gal	Vol % of exempt compound ..... 3.91

**6874/6876/6877**

Category.....Clearcoat	Wt % of volatiles..... 49.93
VOC actual.....3.40#/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

**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](http://www.tat-co.com) to assure use of the most current instructions and TDS on this product.
- See website ([www.tat-co.com](http://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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