

PRODUCT HIGHLIGHTS

9431, 9434

Production Clearcoat (2.1 VOC)

DESCRIPTION:

Signature Series Production Clearcoat is a medium solids clearcoat that flashes in 15 minutes or less! It is ideal for spot repairs and overall jobs. It can be used on all automotive refinishing jobs including fleet vehicles and equipment. The product can be air dried or force dried.

PRODUCTS:

- 9431 Signature Series Production Clearcoat, Gallon (3.78 L), 2/case
- 9434 Signature Series Production Clearcoat, Quart (0.946 L), 6/case



SURFACE PREP:

Tack thoroughly before application.



MIX RATIO:

4:1
Pot Life: 2 - 3 hours @ 68°F -75°F (20° - 24°C)



REDUCER:

Optional: Up to 5% by volume, if desired, using Transtar Zero VOC Urethane Grade Reducer (TDS601) or Urethane Grade Reducer (TDS600) Note: Using Urethane Grade reducer will increase VOC's.



HVLP/LVLP:

1.2 - 1.4 mm
2 - 3 medium wet coats



5- 15 minute flash
1.0 mil per coat (dry film thickness)

Please refer to gun manufacturer for proper spray pressure recommendations.



DRY TO SAND TIMES:

@ 77°F, 50% R.H.:

ACTIVATOR	FLASH TIME	DUST FREE	SAND	DELIVERY
9404/9407	5 min	10 - 15 min	2 - 3 hrs	4 hrs
9414/9417	5 - 10 min	15 - 20 min	2 - 3 hrs	4 hrs
9424/9427	5 - 15 min	15 - 25 min	2 - 3 hrs	4 hrs



SANDING:

DA (Dry): #1200-1500, finish #2000

Hand (Wet): #1200-1500, finish #2000

See next page for more detailed product application. See website for this document in other languages.
Vea la página siguiente para un uso más detallado del producto. Vea el Web site para este documento en español.
Voir la prochaine page pour une application plus détaillée de produit. Voir le site Web pour ce document en français.

PRODUCT DATA

9431, 9434

Production Clearcoat (2.1 VOC)

SUITABLE SUBSTRATES:

Automotive refinish basecoats (water and solvent based); automotive refinish single stage (**except acrylic lacquer**); existing finishes that have been sanded and cleaned.

SURFACE PREPARATION:

Tack thoroughly before application.

MIXING & APPLICATION:

Mix 4 parts Production Clearcoat, #9431/9434, with 1 part #9400 Series Activator by volume. Pot life of activated material is 2 – 3 hours at 68 – 75°F (20° - 24°C) and 50% relative humidity.



Stir product before use. Apply 2 – 3 medium wet flowing coats using the gun settings listed in the table below. Allow 5 - 15 minutes flash time between coats (depending upon activator used). For optimum appearance, activate clear immediately before applying. Signature Series Product Clearcoat should not be applied over acrylic lacquers.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.4 - 1.6 mm	35 - 45 PSI (at gun)	n/a
Gravity Feed	1.2 - 1.4 mm	25 - 35 PSI (at gun)	n/a
Pressure Feed	1.0 - 1.2 mm	40 - 50 PSI (at gun)	8 - 10 PSI
HVLP/LVLP	1.2 - 1.4 mm	10 PSI max. (at aircap)	n/a

TECHNICAL DATA:

APPEARANCE:	Clear Liquid
% SOLIDS (RTU):	Weight: 36% Volume: 35%
SHELF LIFE:	One Year (unopened)
ACTIVATORS:	9400 Signature Series Activators (9404/9407/9414/9417/9424/9427)
REDUCERS:	A zero V.O.C. Reducer (TDS601) or Urethane Grade Reducer (TDS600) depending upon shop temperature.
MIX RATIO:	4:1 (If reduction is desired, add up to 1/2 part acetone)
POT LIFE:	2 - 3 hours @ 68°F -75°F (20° - 24°C)
COVERAGE:	557 ft ² /gal @ 1 mil.

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REGULATORY:

Category: Clear Coating	Individual Component
VOC Actual	0.65#/gal (77g/l)
VOC Regulatory (less water, less exempt compounds)	1.62#/gal (194g/l)
Weight % of Volatiles	68.38
Weight % of Water	0
Weight % of Exempt Compounds	60.13
Volume % of Exempt Compounds	61.44
Density of Material	9.3
Ready to use (less water, less exempt compounds)	1.9#/gal (228g/l)

TECHNICAL TIPS:

REDUCTION: (Optional) May be reduced up to ½ part by volume with a Zero V.O.C. Urethane Grade Reducer (TDS601) or Urethane Grade Reducer (TDS600) appropriate to the shop conditions. *Note: Use of Urethane Grade Reducer increases the V.O.C. of the product mixture. Use of Zero V.O.C. Reducer does not increase V.O.C.*

FORCE DRYING: Signature Series Production Clearcoat may be force dried at 140°F (60°C) for 10 – 20 minutes.

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.

TIPS FOR USE OF 9431 PRODUCTION CLEARCOAT: For small jobs (spot & panel) no reduction should be necessary. For larger areas, the use of #9414 or #9424 will help in achieving excellent flow and leveling.

POLISHING: For defect removal, lightly nib sand with 1500 grit or finer. Finish sand with 2000 grit or finer. Continue with Cutting Compound (TDS404) and Machine Polish (TDS405) for a deep finish and shine. On dark colors, continue with Swirl Remover (TDS406) and finish with All in One Detailer (TDS407). For best results, compound within 24 and 72 hours of application.

Use with Kicker: This clear has a strong cure response with the use of Kicker. Below are the sand and buff/repair times when using various amounts of Kicker (TDS700).

Ozs/RTU Quart	Sand & Buff Repair Times
0	2 - 3 hours
1/4	1 - 2 hours
1/2	1 hour

NOTE: These times are for application conditions of 75°F (24°C) & 50% relative humidity. When repairing, wet sand with 600-800 grit removing all the gloss before reapplying subsequent coatings.

ADVANTAGES:

- Ideal for spot repairs and overall jobs
- Easily duplicates OEM appearance
- Medium solids clear that flashes in 15 minutes or less!
- Suitable for all automotive refinishes, including fleet vehicles and equipment
- Excellent flow and non sag properties that finishes to a high gloss, durable surface
- May be air dried or force dried
- Factory backed warranty

COMPETITION:

RM Diamont DC98

Spies Hecker 8095

DuPont 72100S

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