



Signature Series Speed Clearcoat

9451, 9454

Signature Series Speed Clearcoat is a medium solids, ultra fast cure clearcoat for spot and panel topcoating. Productivity is increased with 10 minute dust, 20 minute touch and 30 minute polish times.



Mix Ratio

4:1 – 4 parts 9451/9454 Speed Clearcoat to 1 part 9424/9427 activators
 Can be reduced up to 5% with 6700 or 6700-F Series Urethane Grade Reducer*.
 Pot life: 2 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 1 double coat using the spray gun setting listed above. One double coat is defined as one pass down and back up with no flash time in between. 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 apply additional coats beyond the recommend application directions. If additional coats are necessary, wait at least 5 hours before applying more basecoat or clear. Lightly scuff surface and degrease before application. Film build: 1 double coat @ 1.0 mils per coat. Must have a minimum of 2.0 mils.

Additives

- Kicker (6417)Do not use; will cause solvent popping and blushing.
- Appearance Improver (6487).....Use only in extreme heat conditions.
- 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.



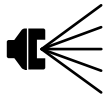
Flash Times/Dry Times

Flash between coats.....N/A
Dust free..... 10 min
Dry to sand.....30 min
Deliver 30 min
Force drying.....Do not force dry. Force drying will result in solvent popping and/or blushing.



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 (9451).....Gallon
Shelf life.....3 years (9454).....Quart
RTS solids by weight.....36% Weight per gallon..... 9.22 #/gal
Approx. coverage.....556 ft²/gal @ 1 mil

Regulatory

9451/9454

Category.....Clearcoat Wt % of volatiles..... 68.10
VOC actual.....0.62#/gal (75 g/l) Wt % of water 0
VOC regulatory.....1.58#/gal (190 g/l) Wt % of exempt compound 61.34
Density.....9.22 #/gal Vol % of exempt compound 60.66
Ready to use (less water exempt compounds)
with 9424/9427.....1.85#/gal (221 g/l)

9424/9427

Category.....Clearcoat Wt % of volatiles..... 45.31
VOC actual.....1.86#/gal (222 g/l) Wt % of water 0
VOC regulatory.....2.37#/gal (284 g/l) Wt % of exempt compound 25.62
Density.....9.42 #/gal Vol % of exempt compound 21.68



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.

LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.