

# Technical Data Sheet

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.

## 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 9451/9454 Speed Clearcoat  
1 part 9424/9427 Signature Series Activator Slow ONLY  
Optional: Up to 5% 6700 or 6700-F Series Urethane Grade Reducer\*

Pot Life 2 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 N/A  
Dust Free 10 minutes  
Dry to Sand 30 minutes  
Delivery 30 minutes  
Force Drying Do not force dry. Force drying will result in solvent popping and/or blushing.

## 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 - 1.6
Air Pressure	10 PSI @ aircap	25 - 35 PSI @ gun inlet
Mil Thickness: 1 double coat (2.0 mils @ 1.0 mil per coat).		

## 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	1.2-1.6 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) - 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 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 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.

## PRODUCT SPECIFICATIONS

Weight per gallon: 9.22	Shelf Life: 1 year
RTS Solids by Weight: 36%	Color: Clear Liquid
Approximate Coverage: 556 ft <sup>2</sup> /gal @ 1 mil	Size: Gallon (9451), Quart (9454)

## REGULATORY

Category: Clearcoat	9451/9454	9424/9427
VOC Actual	0.62#/gal (75 g/l)	1.86#/gal (222 g/l)
VOC Regulatory	1.58#/gal (190 g/l)	2.37#/gal (284 g/l)
Weight % of Volatiles	68.1	45.31
Weight % of Water	0	0
Weight % of Exempt Compounds	61.34	25.62
Volume % of Exempt Compounds	60.66	21.68
Density of Material #/gal	9.22	9.42
		with 9424/9427
Ready to Use (less water, less exempt compounds)		1.85#/gal (221 g/l)