

Technical Data Sheet

Signature Series Production Clearcoat is a premium 2K, medium solids clearcoat that provides outstanding durability and gloss for panel, multi-panel and overall repairs. Its 15 minute dust free time enables customers to perform efficient repairs in their every day repair processes without sacrificing durability or appearance.

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 9511/9514 Production Clearcoat
1 part 9400 Series Activators
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 5-15 minutes
Dust Free 10-25 minutes
Dry to Sand 2-3 hours
Delivery 4 hours
Force Drying 10-20 minutes @ 140°F (60°C)

Activator	Flash Time	Dust Free
9404 Fast	5 min	10-15 min
9414/9417 Medium	5-10 min	15-20 min
9424/9427 Slow	5-15 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)		

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 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 per coat. Must have a minimum of 2.4 mils and not to exceed 3.6 mils.

PRODUCT SPECIFICATIONS

Weight per gallon: 9.30	Shelf Life: 1 year
RTS Solids by Weight: 36%	Color: Clear Liquid
Approximate Coverage: 493 ft ² /gal @ 1 mil	Size: Gallon (9511), Quart (9514)

REGULATORY

Category: Clearcoat	9511/9514	9404	9414/9417	9424/9427
VOC Actual	0.65#/gal (77 g/l)	1.86#/gal (223 g/l)	1.84#/gal (221 g/l)	1.86#/gal (222 g/l)
VOC Regulatory	1.62#/gal (194 g/l)	2.36#/gal (282 g/l)	2.36#/gal (282 g/l)	2.37#/gal (284 g/l)
Weight % of Volatiles	68.38	45.31	45.31	45.31
Weight % of Water	0	0	0	0
Weight % of Exempt Compounds	61.44	25.30	25.82	25.62
Volume % of Exempt Compounds	60.13	21.10	21.90	21.68
Density of Material #/gal	9.30	9.29	9.44	9.42
		with 9404	with 9414/9417	with 9424/9427
Ready to Use (less water, less exempt compounds)		1.86#/gal (223 g/l)	1.86#/gal (223 g/l)	1.87#/gal (224 g/l)