

Technical Data Sheet

No Mix Production Clear is a premium 2K, medium solids clearcoat that provides outstanding durability and gloss for panels, multi-panel and overall repairs. It is formulated for use with the No Mix line of refinish products for optimum performance. It enables customers to perform efficient repairs in their every day repair process without sacrificing durability or appearance. It is very easy to apply, and offers excellent flow and leveling for the ultimate factory match finish.

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 LV-641 Production Clear
1 part LV-604/LV-614/LV-624 Activators
Optional: Up to 5% No Mix Reducer* (LV-541/LV-551/LV-571/LV-581)

Pot Life 2 hours (@70°F (21°C) and 50% relative humidity)

* Use reducer according to shop conditions. Using reducers other than Zero VOC 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
LV-604 Fast	5 min	10-15 min
LV-614 Medium	5-10 min	15-20 min
LV-624 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.

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: 8.99	Shelf Life: 1 year
RTS Solids by Weight: 34%	Color: Clear Liquid
Approximate Coverage: 520 ft ² /gal @ 1 mil	Size: Gallon

REGULATORY

Category: Clearcoat	LV-641	LV-604	LV-614	LV-624
VOC Actual	0.68#/gal (81 g/l)	1.86#/gal (223 g/l)	1.84#/gal (221 g/l)	1.86#/gal (222 g/l)
VOC Regulatory	1.87#/gal (224 g/l)	2.36#/gal (282 g/l)	2.36#/gal (282 g/l)	2.37#/gal (284 g/l)
Weight % of Volatiles	71.33	45.28	45.34	45.35
Weight % of Water	0	0	0	0
Weight % of Exempt Compounds	63.80	25.30	25.82	25.62
Volume % of Exempt Compounds	63.81	21.10	21.90	21.68
Density of Material #/gal	8.99	9.41	9.39	10.48
		with LV-604	with LV-614	with LV-624
Ready to Use (less water, less exempt compounds)		2.04#/gal (245 g/l)	2.04#/gal (245 g/l)	2.05#/gal (245 g/l)