



Flash Clearcoat

OR3001

Transtar Select Flash OR3001 Clearcoat is a medium solids, fast cure clearcoat for spot and panel topcoating. It has 10 minute dust, 20 minute touch and 30 minute polish times.



Mix Ratio

4:1 – 4 parts OR3001 Speed Clearcoat to 1 part OR1044 activator
 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. A double coat is one pass down and back up without any flash between. Keep spray gun nozzle 6-10 inches from vehicle to avoid entrapment of air in paint film. Keep containers closed to prevent moisture contamination. Clean equipment thoroughly after use.
 Critical recoat time: Do not apply additional coats per the application directions. If additional coats are needed, wait 5 hours before applying more basecoat or clearcoat. 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 at a rate of 1-2 oz per sprayable quart.
- 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. Additionally, the use of Universal Urethane Flex Additive will increase dry times (15 minutes), cure times (45 minutes) and polish times (2 hours).



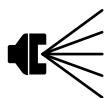
Flash Times/Dry Times

Flash between coats.....N/A
 Dust free..... 10 min
 Print free.....20 min
 Deliver30 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
 HVLP/LVLP1.2 - 1.4 mm



Air Pressure

Siphon feed (@ gun)35 - 45 psi Gravity feed (@ gun) 25 - 35 psi
 HVLP/LVLP (@ aircap)..... 10 psi



Product Specifications

Color.....Translucent Size (OR3001)..... Gallon
 Shelf life.....3 years (OR1044)..... Quart
 RTS solids by weight.....36% Weight per gallon..... 9.22 #/gal
 Approx. coverage.....556 ft²/gal @ 1 mil

Regulatory

OR3001

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 OR1044.....1.84#/gal (221 g/l)	

OR1044

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.

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