



Royal Clearcoat

OR3101

Transtar Select Royal OR3101 Clearcoat is a high solids clearcoat for multi-panel and overall repairs. It features excellent flexibility, UV protection and is highly resistant to stone chips and abrasions. This product is ideal for use over single stage or base/clearcoat applications.



Mix Ratio

2:1 – 2 parts OR3101 Royal Clearcoat to 1 part OR1024/1034/1044 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 surface thoroughly before application. For blending clearcoat refer to SOP #513 and #514.

Apply 2-3 flowing coats. Flash for 10-20 minutes between coats depending on activator used. 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 flash for more than 60 minutes between coats. If more than 60 minutes @ 70°F (21°C) is reached, wait at least 6 hours before applying more clear or basecoat. After 24 hours, lightly scuff the clearcoat before applying more material.

Film build: 2-3 coats @ 1.0 mils. Must have a minimum of 2.0 mils.

Additives

Kicker (6417)Can be used at a rate of 1/2 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 1/2 oz per sprayable quart.

Flex Additive (9194)Use with soft, flexible substrates. Refer to TDS for mixing information.



Flash Times/Dry Times

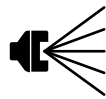
Flash between coats..... 10-20 min
 Dust free..... 40-45 min
 Dry to sand..... 6-8 hrs
 Deliver 12 hrs
 Force drying..... 40 min @ 140°F (60°C) after a 5 min flash.

Activator	Flash time	Dust free
OR1024 Fast	10 min	20-30 min
OR1034 Medium	10-15 min	30-40 min
OR1044 Slow	15-20 min	35-45 min



Gun Set-up

Siphon feed..... 1.4 - 1.6 mm Gravity feed..... 1.2 - 1.4 mm
 HVLP/LVLP 1.2 - 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..... Clear Size (OR3101)..... Gallon
 Shelf life..... 3 years (OR1024/1034/1044)..... Quart
 RTS solids by weight..... 47% Weight per gallon..... 8.87 #/gal
 Approx. coverage..... 727 ft²/gal @ 1 mil

Regulatory

OR3101

Category..... Clearcoat	Wt % of volatiles..... 57.69
VOC actual..... 1.07#/gal (128 g/l)	Wt % of water 0
VOC regulatory..... 1.89#/gal (226 g/l)	Wt % of exempt compound 45.72
Density..... 8.87 #/gal	Vol % of exempt compound 43.53
Ready to use (less water exempt compounds)	
with OR1024..... 2.08#/gal (249 g/l)	
with OR1034..... 2.07#/gal (249 g/l)	
with OR1044..... 2.08#/gal (249 g/l)	

OR1024

Category..... Clearcoat	Wt % of volatiles..... 45.31
VOC actual..... 1.86#/gal (223 g/l)	Wt % of water 0
VOC regulatory..... 2.36#/gal (282 g/l)	Wt % of exempt compound 25.3
Density..... 9.29 #/gal	Vol % of exempt compound 21.1

OR1034

Category..... Clearcoat	Wt % of volatiles..... 45.31
VOC actual..... 1.84#/gal (221 g/l)	Wt % of water 0
VOC regulatory..... 2.36#/gal (284 g/l)	Wt % of exempt compound 25.82
Density..... 9.44 #/gal	Vol % of exempt compound 21.9

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.

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.