

# 4:1 Clear Coat

## Technical Data Sheet #2400



### COMPONENTS

- 2400 4:1 Clear
- 2001 4:1 Clear Fast Activator
- 2002 4:1 Clear Med Activator
- 2003 4:1 Clear Slow Activator

### MIX BY VOLUME

- 4 Parts 2400 4:1 Clear
- 1 Part 2001, 2002, 2003 4:1 Clear Activator (see chart for proper catalyst selection)
- Optional: 10% with VOC Compliant Reducers

**Note:** We recommend using catalysts within 14 days of opening to maintain maximum performance. Replace lids on all paint products immediately after use to avoid moisture or oxygen contamination.

Catalyst	Temperature Range
2001 Fast	60–70°F
2002 Medium	70–80°F
2003 Slow	80°F +

### POT LIFE

- 3 hours at 75° F.

### Equipment Setup

Gun Type	Fluid Tip	Air Pressure
HVLP Siphon	1.3-1.4mm	8-10 PSI at cap
High Efficiency	1.3-1.4mm	27-32 PSI

**Note:** These are starting points for spray gun recommendations. Refer to spray gun manufacturers recommendations for proper setup and operation. Additional adjustments may be necessary

### Application

- Allow basecoat to properly dry according to suggested dry times and spray conditions.
- Apply one medium-wet coat and allow 10–15 minutes flash. Apply a second coat of clear.
- Do not apply more clear after 1 hour of applying previous coats of clear.

### BAKING

**Note:** Do not bake clear when using accelerator.

### Full Bake Cycle

#### For Heavy Buffing/Compounding or Assembly

- No purge time is necessary, bake 30–35 minutes at 140°F.
- Allow a 1–2 hour cool down prior to assembling or buffing.
- Infrared Short Wave 5 minutes at half power, then full power for 15 minutes (20 minutes total)

### BUFFING

**Note:** Due to variations in compounds, polishes, and buffing pads, refer to the product manufacturer for suggested use of their products. Always use a quality clearcoat polishing system. Excessive clear films, slower activators, or cooler temperatures will result in extended dry time before polishing or compounding.

### Light Polishing Dry Time

For removing minor imperfections such as fine dust, dirt, or debris. Best used for blend edges, under cured, or soft fresh clear.

- Air dry: 8 hours at 75° F.

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### **Compounding Dry Time**

For aggressively removing sand scratches and to flatten and level the paint surface. (for use on longer air-dried or fully baked clear):

- Air dry: 10–12 hours at 75° F then proceed with heavy compounding and polishing.
- Full Bake: Allow cool down for 1–2 hours prior to heavy compounding or polishing.

### **RE-WORKING**

- Due to the strength of some reducers, care needs to be taken if new color coat is going to be applied over fresh clear.
- Allow clear to dry overnight at 75° F prior to reapplying color coat. If a full break through of clear is done while making a repair, lightly apply color using a faster flashing reducer.
- In temperatures below 75° F, the use of a heat lamp will help cure the break through edge so lifting will be minimized.
- Re-clearing may be done as soon as 16 hours or up to 72 hours without having to scuff clear.

### **PERFORMANCE TIPS**

- If problem occurs during application, painter must get a minimum 2 coats on vehicle before stopping for repair or additional recoat. Allow to dry overnight, then scuff before primer, color or clear application.
- Shop and surface temperatures should be maintained at or above 75°F for the first 24-hours of the cure cycle.
- Use a mixing cup for accurate volume measurements.
- Clear will be water resistant in 24-hours.  
**Note:** Do not allow raindrops to dry on any new finish for the first 3–4 days to prevent staining.

- Urethane coatings take 5–7 days at 75° F to properly cure. Care should be taken during first week of washing. Do not use a pressure washer on fresh clear. Do Not wax or seal for 60 days.
- Stain free body filler is recommended for use under light colors.
- Do not use over lacquer.

### **CLEAN-UP**

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner.

### **DISPOSAL**

Dispose of all paint and paint related materials in accordance with state and local regulations.

### **SAFETY & HEALTH**

Read and follow all technical product information, labels, and SDS prior to application. Keep product out of reach of children and animals. Always wear proper safety equipment (respirator, gloves, eye, and clothing protection) when using this product.

**Refer to all labels on products and information sheets for hazards and proper handling procedures for each component. Read the Safety Data Sheets (SDS) supplied with the materials.**

**KEEP OUT OF REACH OF CHILDREN**