



PRODUCT HIGHLIGHTS

4900-01, 4900-04

True Finish Urethane Clearcoat

DESCRIPTION:

True Finish Urethane Clearcoat is a two component, universal urethane clearcoat designed for spot, panel and overall refinish jobs. It is fast-drying, easy to use and provides a durable finish with excellent gloss.

PRODUCTS:

4900-01	True Finish Urethane Clearcoat, Gallon (3.78 L), 2/case
4900-04	True Finish Urethane Clearcoat, Quart (0.946 L), 6/case
5901-04	True Finish Hardener - Fast, Quart (0.946 L), 4/case
5901-07	True Finish Hardener - Fast, 1/2 pint (237 ml), 12/case
5902-04	True Finish Hardener - Medium, Quart (0.946 L), 4/case
5902-07	True Finish Hardener - Medium, 1/2 pint (237 ml), 12/case
5903-04	True Finish Hardener - Slow, Quart (0.946 L), 4/case



SURFACE PREP:

Tack thoroughly before application.



MIX RATIO:

4:1

Pot Life: 3 hours @ 70°F (21°C) and 50% R.H.



REDUCER:

Optional: Up to 5% using 6700-F Series Zero VOC Urethane Grade Reducer or 6700 Series Urethane Grade Reducer appropriate to the shop conditions. Note: Using Urethane Grade reducer will increase VOC's.



HVLP/LVLP:

1.2 - 1.6 mm

2 - 3 medium wet coats



5 - 25 minute flash

1.2 mils per coat (dry film thickness)



Please refer to gun manufacturer for proper spray pressure recommendations.



DRY TO SAND TIMES:

@ 70°F (21°C), 50% R.H.:

ACTIVATOR	FLASH TIME	DUST FREE	SAND	DELIVERY
5901-04/-07	5 - 10 min	10 - 15 min	8 - 10 hrs	12 hrs MIN
5902-04/-07	10 - 15 min	15 - 20 min	8 - 10 hrs	12 hrs MIN
5903-04	20 - 25 min	20 - 25 min	8 - 10 hrs	12 hrs MIN



SANDING:

DA (Dry): #1200-1500, finish #2000

Hand (Wet): #1200-1500, finish #2000

See next page for more detailed product application. See website for this document in other languages.
Vea la página siguiente para un uso más detallado del producto. Vea el Web site para este documento en español.
Voir la prochaine page pour une application plus détaillée de produit. Voir le site Web pour ce document en français.

PRODUCT DATA

4900-01, 4900-04

True Finish Urethane Clearcoat

SUITABLE SUBSTRATES:

True Finish Urethane Clearcoat may be applied over automotive refinish basecoats (water and solvent based); automotive refinish single stage, with the exception of acrylic lacquers; and existing finishes which have been sanded and cleaned.

SURFACE PREPARATION:

Tack thoroughly before application.

APPLICATION & MIXING:

Mix 4 parts clearcoat to 1 part activator (5900 series) by volume. (Use a measuring stick or mixing cup for accurate measuring.) Reduction is optional up to 5% by volume using the 6700 Series Urethane Grade Reducer or 6700-F Series Zero VOC Urethane Grade Reducer suitable for the shop temperature. (Note: Urethane Grade Reducers will increase sprayable VOC content and Zero VOC Urethane Grade Reducers will not increase VOC.) For optimum appearance, activate clearcoat immediately before applying. **Clearcoat should not be applied over acrylic lacquers, or unsanded existing finishes.**



Recommended spraying viscosity is 14-15 seconds using a Zahn #2 cup (@77°F (25°C)). Follow base/top coat manufacturer's instructions regarding flash and dry times prior to application of clearcoat.

Apply 2 - 3 flowing coats (2.2 - 3.6 mils @ 1.2 mils per coat) using the spray gun setting listed below. Flash for 5 – 25 minutes depending on activator used (refer to dry to sand chart 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.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.2 - 1.6 mm	35 - 50 PSI (at gun)	n/a
Gravity Feed	1.2 - 1.6 mm	35 - 50 PSI (at gun)	n/a
Pressure Feed	1.0 - 1.2 mm	40 - 50 PSI (at gun)	8 - 10 PSI
HVLP/LVLP	1.2 - 1.6 mm	10 PSI max. (at aircap)	n/a

TECHNICAL DATA:

APPEARANCE:	Clear Liquid
% SOLIDS (RTU):	36%
SHELF LIFE:	One Year (unopened)
REDUCER:	Optional: 6700 Series Urethane Grade Reducer or 6700-F Series Zero VOC Reducer Note: Reduction with Urethane Grade Reducer increases the VOC of the product mixture, reduction with Zero VOC Reducer does not increase VOC
MIX RATIO:	4:1 (If reduction is desired, add up to 5% Transtar Reducer)
POT LIFE:	3 hours @ 70°F (21°C) and 50% R.H.
COVERAGE:	474 ft ² /gal. @ 1 mil

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REGULATORY:

Category: Clearcoat	Individual Component
VOC Actual	3.66#/gal (439 g/l)
VOC Regulatory (less water, less exempt compounds)	4.76#/gal (571 g/l)
Weight % of Volatiles	68.13
Weight % of Water	0
Weight % of Exempt Compounds	20.06
Volume % of Exempt Compounds	23.12
Density of Material	7.62

Category: Clearcoat	5901-04/5901-07	5902-04/5902-07	5903-04
VOC Actual	3.4#/gal (407 g/l)	3.52#/gal (422 g/l)	3.5#/gal (419 g/l)
VOC Regulatory (less water, less exempt compounds)	3.72#/gal (446 g/l)	3.63#/gal (435 g/l)	3.65#/gal (438 g/l)
Weight % of Volatiles	49.93	46.2	46.20
Weight % of Water	0	0	0
Weight % of Exempt Compounds	11.00	4.00	5.50
Volume % of Exempt Compounds	8.62	3.00	4.25
Density of Material	8.73	8.34	8.59

	With 5901	With 5902	With 5903
Ready to Use (less water, less exempt compounds)	4.53#/gal (542)	4.49#/gal (538 g/l)	4.5#/gal (539 g/l)

TECHNICAL TIPS:

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.

FORCE DRYING:

True Finish Urethane Clearcoat may be force dried after a 5-10 minute flash, baking at 140°F (60°C) for 30 minutes. Allow a 2 hour cool down prior to any further work.

POLISHING:

For dirt removal, lightly nib sand with 1500 grit wet sandpaper and compound with Cutting Compound 5361/5364. Finish with Machine Polish 5374. For dark colors, use Swirl Remover 5384. It is best to compound within 24 hours of application blending.

PERFORMANCE ADDITIVES

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

6487 Appearance Improver – Can be used at a rate of 1 - 2 oz per sprayable quart.

6737 Fisheye Remover – Can be used at a rate of 1/2 oz per sprayable quart.

9194 Universal Urethane Flex Additive – Recommended when used on soft flexible substrates such as bumper & trim applications. May be used, refer to TDS for mixing recommendations.