

E3 Clearcoat (2.1 V.O.C)

Economy • Ecology • Excellence



E3 Clearcoat

- Meets SCAQMD
- Can be used with solvent-based and water-based basecoats
- Excellent flow and leveling
- High gloss finish
- 50 State & Canada compliant

Availability:

- | | |
|---------|-----------------------------------|
| 6801 | E3 Clearcoat (2.1 V.O.C.), Gallon |
| 6854 | Lightning Activator, Quart |
| 6874 | Spot & Panel Activator, Quart |
| 6894 | Overall Activator, Quart |
| 6894-HT | Hi Temp Overall Activator, Quart |



TRANSTAR[®]
AUTOBODY TECHNOLOGIES, INC.

E3 Clearcoat (2.1 V.O.C.)



DESCRIPTION:

E3 Clearcoat #6801 is an acrylic urethane clearcoat with a sprayable V.O.C. of 2.1#/gal (using EPA Test Method 24). This product can be used with all solvent-based and water-based basecoats. It is suitable for automotive refinishing as well as trucks and equipment.

TECHNICAL DATA:

APPEARANCE:	Clear Liquid
% SOLIDS:	34.0% RTU
V.O.C. CONTENT:	0.70#/gal (84 g/l) - As Packaged 2.1#/gal (252g/l) - Ready to Spray
SHELF LIFE:	One Year (unopened)
REDUCERS:	Use Transtar Urethane Grade Reducer depending upon shop temperature. (Adding reducer will increase V.O.C.s)
ACTIVATORS:	6800 Series Activators
MIX RATIO:	4:1 (If reduction is desired, add up 10% Transtar Reducer)
POT LIFE:	4 hours @ 68°F – 75°F (17°C – 24°C)
COVERAGE:	500 ft ² /gal (13m ² /l) @ 1.0 mil

SUITABLE SUBSTRATES:

Automotive refinish basecoats (water-based and solvent-based), automotive refinish single stage (except acrylic lacquer), and existing finishes that have been sanded and cleaned.

INSTRUCTIONS – MIX RATIO:

Mix 4 parts #6801 E3 Clearcoat to 1 part activator (6854, 6874, 6894, 6894-HT) by volume. Mix immediately before use. Pot life of activated material is 4 hours at 68 – 75°F (17 – 24°C). Always follow basecoat/topcoat manufacturer's instructions regarding flash time and dry times before application of E3 Clearcoat.

REDUCTION:

E3 Clearcoat may be reduced up to 10% by volume using the Transtar Urethane Grade Reducer suitable for the shop temperature. (Note: This will increase sprayable VOC content).

APPLICATION OF CLEARCOAT:

Apply 2 – 3 medium wet flowing coats using the spray gun settings listed below. Allow 10 – 15 minutes flash time between coats. E3 Clearcoat should not be applied over acrylic lacquers or unsanded existing finishes. Applying 2 – 3 medium wet coats will result in a film build of 2.2 – 3.6 mils @ 1.2 mils per coat. A minimum of 2.2 mils is recommended to ensure long term durability.

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 for clearcoat or basecoat.

FORCE DRYING:

E3 Clearcoat may be force dried after a 20 minute flash and then baked for 40 minutes at 140°F (60°C). Allow 2 hour cool down prior to further work.

POLISHING:

For dirt removal, lightly nib sand with 1500 grit wet sandpaper and compound with Tri-Cut II #5331/5334. Finish with Final Finish #5354. It is best to compound within 24 hours of application blending.

KICKER:

To increase the speed of dry and polishing times, E3 Clearcoat may be accelerated up to 1/2 oz. per sprayable quart with Transtar Kicker #6417.

SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE	FLUID PRESSURE
Siphon Feed	1.4 – 1.6 mm	35 – 45 PSI (at gun)	n/a
Gravity Feed	1.2 – 1.6 mm	25 – 35 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 air cap	n/a

DRYING SCHEDULE @ 77°F (25°C), 50% RELATIVE HUMIDITY:

ACTIVATOR	FLASH TIME	DUST FREE	SAND	DELIVERY
6854	3 – 5 min	10 – 15 min	2 – 4 hrs	6 – 8 hrs MIN
6874/6877	5 – 10 min	15 – 20 min	6 – 8 hrs	12 hrs MIN
6894	5 – 15 min	20 – 30 min	8 – 10 hrs	12 hrs MIN
6894-HT	10 – 15 min	20 – 40 min	8 – 10 hrs	12 hrs MIN



PRODUCT HIGHLIGHTS

6854

Lightning Activator

DESCRIPTION:

Lightning Activator 6854 is designed for use in Transtar's Finish-Tec® Clearcoats - 6531, 6571, 6841, 6801, 6861 and 7761-MTR to provide a long lasting high gloss finish. Ideal for spot & panel repairs and for use in cool/cold temperatures. It significantly accelerates flash and cure times. This product provides low overspray.

PRODUCTS:

6854 Lightning Activator, Quart (0.946 L), 4/case



POT LIFE

This product significantly reduces pot life from times shown on datasheet or label.



DRY TO SAND TIMES:

DRYING SCHEDULE @ 69°F (20°C), 50% RELATIVE HUMIDITY

Product	Mix Ratio	Flash Time	Dust-Free	Sand/Buff	Delivery
6531 2.1 Clearcoat	4:1	6 min	12 min	3.5 hrs	5 hrs
6571 Kwik Finish 2.1	4:1	8 min	12 min	1 hr 45 min	2.5 hrs
6801 E3 Clearcoat	4:1	3 - 5 min	10 - 15 min	2 - 4 hrs	6 - 8 hrs
6841 Kwik Gloss	4:1	5 min	10 min	4.5 hrs	6 hrs
6861 High Gloss	4:1	6 min	15 min	4.5 hrs	6 hrs
7761-MTR Max Clear	4:1	2 min	10 min	1 hr	2 - 3 hrs

Note: Shop temperature, film build (number of coats applied) and airflow will effect dry times. Excessive film build (over application) or use in temperatures above 75°F (25°C) will result in die back or solvent pop.

PRODUCT DATA

6854

Lightning Activator

MIXING & APPLICATION:

Do not use at temperatures above 70°F (21°C). The mixing ratio is dependent upon the clearcoat used. Refer to the clearcoat label or datasheet for specific instructions and application information. Use in same mix ratio as indicated for Transtar Activators 6874, 6894, and 6894HT.



TECHNICAL DATA:

APPEARANCE: Clear Liquid
% SOLIDS: 53.0%
FOR USE WITH: Transtar's clearcoats 6531, 6571, 6801, 6841, 6861 and 7761-MTR
MIX RATIO: Refer to clearcoat label or datasheet
POT LIFE: This product significantly reduces pot life from times shown on datasheet or label.

REGULATORY:

Category: Clearcoat	Individual Component
VOC Actual	3.50#/gal (420 g/l)
VOC Regulatory (less water, less exempts)	3.65#/gal (437 g/l)
Weight % of Volatiles	46.98
Weight % of Water	0
Weight % of Exempt Compounds	5.2
Volume % of Exempt Compounds	3.92
Density of Material	8.39

ADVANTAGES:

- Improves cycle times
- Ideal for use in cool/cold temperatures (below 70°F (21°C))
- Increases productivity
- Accelerates flash and cure times
- Reduces overspray