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

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AUTOBODY TECHNOLOGIES, INC.

E3 Clearcoat (2.1 V.O.C.)

50 State Compliant

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

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PRODUCT HIGHLIGHTS

6874, 6877, 6894, 6894-HT, 6897-HT
Clearcoat Activators

DESCRIPTION:

Extra Solids Acrylic Urethane Clearcoat Activators are specifically designed for high productivity shops using Transtar Finish-Tec® Clearcoats. Activators are suitable for use in clearcoat applications over single stage topcoats and for base/clear applications (except lacquers). Spot & Panel Activator #6877/6874 is designed for use in temperatures between 65° - 80°F (19° - 27°C) or for spot & panel applications. Overall Activator #6894 is designed for use in temperatures between 75° - 90°F (24° - 32°C) or for large jobs which require longer open times. Hi Temp Activator #6894HT/6897HT is designed for use on larger jobs in temperatures above 90°F (32 °F).

PRODUCTS:

6874 Extra Solids Spot & Panel Activator, Quart (0.946 L), 4/case
6877 Extra Solids Spot & Panel Activator, 1/2 Pint (237 ml), 12/case
6894 Extra Solids Overall Activator, Quart (0.946 L), 4/case
6894HT Extra Solids Hi Temp Activator, Quart (0.946 L), 4/case
6897HT Extra Solids Hi Temp Activator, 1/2 Pint (237 ml), 12/case

TECHNICAL DATA:

APPEARANCE:	Clear Liquid	
% SOLIDS:	6874/6877	50%
	6894	53.8%
	6894HT/6897HT	53.8%
SHELF LIFE:	One Year (unopened)	
REDUCERS:	Use 6700-F Series Zero VOC Urethane Grade Reducer or 6700 Series Urethane	
Grade	Reducer appropriate to the shop conditions.	
	Note: Use of Urethane Grade Reducer increases the V.O.C. of the product mixture. Use of Zero VOC Urethane Grade Reducer does not increase V.O.C.	
MIX RATIO:	Refer to clearcoat label	

REGULATORY:

6874 & 6877	Individual Component
VOC Actual	3.4#/gal (407 g/l)
VOC Regulatory (less water, less exempt compounds)	3.7#/gal (446 g/l)
Weight % of Volatiles	49.93
Weight % of Water	0
Weight % of Exempt Compounds	11.00
Volume % of Exempt Compounds	8.62
Density of Material	8.73

PRODUCT DATA

6874, 6877, 6894, 6894-HT, 6897-HT
Clearcoat Activators

REGULATORY CON'T:

6894	Individual Component
VOC Actual	3.5#/gal (422 g/l)
VOC Regulatory (less water, less exempt compounds)	3.6#/gal (435 g/l)
Weight % of Volatiles	46.2
Weight % of Water	0
Weight % of Exempt Compounds	4.00
Volume % of Exempt Compounds	3.00
Density of Material	8.34

6894-HT & 6897-HT	Individual Component
VOC Actual	3.5#/gal (419 g/l)
VOC Regulatory (less water, less exempt compounds)	3.7#/gal (438 g/l)
Weight % of Volatiles	46.2
Weight % of Water	0
Weight % of Exempt Compounds	5.5
Volume % of Exempt Compounds	4.25
Density of Material	8.59