



Kwik Gloss Clearcoat

6841, 6844

Kwik Gloss Clearcoat is a fast-drying acrylic urethane clearcoat. It can be used with all solvent and water-based basecoats to provide ultimate productivity and gloss. Kwik Gloss is formulated for use with a complete line of activators for application over a wide range of job sizes and temperatures. It is suitable for all automotive refinishing as well as trucks and equipment.



Mix Ratio

4 parts 6841/6844 Kwik Gloss Clearcoat
1 part 6800 Series or 6900 Series Activators*

Can be reduced up to 5% with 6700, 10% with 6700-F Series, or VOC exempt Urethane Grade Reducer**
Pot Life 4-6 hours (@70°F (21°C) and 50% relative humidity)

**Oxsol and TBAC free use 6900 series activators. **6700-F series reducers contain Oxsol (PCBTF). Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC. Check local regulatory requirements for reducer selection.*



Suitable Substrates

- Solvent-borne basecoat
- Waterborne basecoat
- 2K enamel
- OEM finish & old paint work - non-reversible



Surface Prep & Application

Tack thoroughly before application. For blending clearcoat refer to SOP #513 and #514.

Apply 2 - 3 flowing coats using the spray gun setting listed on next page. Flash for 5 – 15 minutes depending on activator used (refer to flash/dry times on next page).

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.

Critical recoat time: Do not flash for more than one hour between coats. If more than one hour @ 70°F (21°C) is reached, wait at least 5 hours before applying more clear or basecoat. Lightly scuff surface and degrease before application.

Film build: 2-3 coats @ 1.2 mils. Must have a minimum of 2.2 mils and not to exceed 3.6 mils.

Additives

Kicker* (6417)	Can be used at a rate of ½ oz per sprayable quart with no reduction with 6700 series reducer.
Fisheye Remover* (6737)	Can be used at a rate of ½ oz per sprayable quart with no reduction with 6700 series reducer.
Flex Additive (9194)	Use with soft, flexible substrates. Refer to TDS for mixing information.
Appearance Improver** (6487)	Can be used at a rate of 1 – 2 oz per sprayable quart.

**Will increase VOC, verify compliance to local regulations. **Contains Oxsol, cannot be used in restricted regions.*



Flash Times/Dry Times

Flash between coats..... 5 min
 Dust free 5-25 min
 Dry to sand 4-8 hrs
 Deliver 6-12 hrs MIN
 Force drying 30 min @ 140°F (60°C) after a 5-10 min flash.

Activator	Flash time	Dust free
6854 / 6954 Lightning	5 min	5-10 min
6874 / 6877 / 6974 Spot and Panel	5 min	5-10 min
6894 / 6994 Overall	5-15 min	10-15 min
6894HT / 6994HT Hi Temp	10-15 min	15-25 min



Gun Set-up

Siphon feed 1.4 - 1.6 mm
 Pressure feed 1.0 - 1.2 mm
 Gravity feed 1.2 - 1.4 mm
 HVLP/LVLP 1.2 - 1.4 mm



Air Pressure

Siphon feed (@ gun) 35 - 45 psi
 Pressure feed (@ gun) 40 - 50 psi
 Gravity feed (@ gun) 25 - 35 psi
 HVLP/LVLP (@ aircap) psi

Fluid Pressure

Pressure feed 8 - 10 psi



Product Specifications

Weight per Gallon: 7.57
 RTS Solids by Weight: 36%
 Approximate Coverage: 477 ft²/gal @ 1 mil
 Shelf Life: 3 years
 Color: Clear Liquid
 Size: Gallon (6841), Quart (6844)

Regulatory

Category: Clearcoat Gloss		6841/6844	6854/6856	6874/6876/ 6877	6894/6896	6894HT/6896HT / 6897HT
VOC Actual		2.97 #/gal (356 g/l)	3.48 #/gal (417 g/l)	3.39 #/gal (406 g/l)	3.45 #/gal (413 g/l)	3.48 #/gal (417 g/l)
VOC Regulatory		4.23 #/gal (507 g/l)	3.62 #/gal (434 g/l)	3.71 #/gal (445 g/l)	3.62 #/gal (434 g/l)	3.64 #/gal (436 g/l)
Weight % of Volatiles		68.00	46.98	49.93	46.24	46.06
Weight % of Water		0.00	0.00	0.00	0.00	0.00
Weight % of Exempt Compounds		28.80	5.20	11.00	6.08	5.50
Volume % of Exempt Compounds		29.88	3.88	8.59	4.68	4.22
Density of Material #/gal		7.57	8.32	8.70	8.59	8.55
			with 6854/6856	with 6874/ 6876/6877	with 6894/6896	with 6894HT/ 6896HT/6897HT
No Reduction	Ready to Use (less water, less exempt compounds)		4.08 #/gal (489 g/l)	4.10 #/gal (491 g/l)	4.07 #/gal (489 g/l)	4.08 #/gal (490 g/l)
No Reduction + 6417	Ready to Use (less water, less exempt compounds)		4.16 #/gal (498 g/l)	4.18 #/gal (501 g/l)	4.15 #/gal (497 g/l)	4.16 #/gal (498 g/l)

No Reduction + 6487	Ready to Use (less water, less exempt compounds)	4.05 #/gal (485 g/l)	4.08 #/gal (489 g/l)	4.05 #/gal (485 g/l)	4.06 #/gal (486 g/l)
No reduction + 6737	Ready to Use (less water, less exempt compounds)	4.12 #/gal (494 g/l)	4.15 #/gal (497 g/l)	4.12 #/gal (494 g/l)	4.13 #/gal (495 g/l)
Reduced (4:1:5%) 6700 series	Ready to Use (less water, less exempt compounds)	4.29 #/gal (514 g/l)	4.32 #/gal (518 g/l)	4.29 #/gal (514 g/l)	4.29 #/gal (514 g/l)
Reduced (4:1:10%) 6700-F series	Ready to Use (less water, less exempt compounds)	4.08 #/gal (489 g/l)	4.10 #/gal (491 g/l)	4.07 #/gal (488 g/l)	4.08 #/gal (489 g/l)
5% Reduced 6700 Series + 6487	Ready to Use (less water, less exempt compounds)	4.26#/gal (510 g/l)	4.28 #/gal (513 g/l)	4.25 #/gal (509 g/l)	4.26#/gal (510 g/l)

Category: Clearcoat Gloss		6841/6844	6954	6974	6994	6994HT
VOC Actual		2.97 #/gal (356 g/l)	3.73 #/gal (447 g/l)	3.81 #/gal (457 g/l)	3.81 #/gal (457 g/l)	3.81 #/gal (457 g/l)
VOC Regulatory		4.23 #/gal (507 g/l)	3.73 #/gal (447 g/l)	3.81 #/gal (457 g/l)	3.81 #/gal (457 g/l)	3.81 #/gal (457 g/l)
Weight % of Volatiles		68.00	45.17	45.17	45.17	45.17
Weight % of Water		0.00	0.00	0.00	0.00	0.00
Weight % of Exempt Compounds		28.80	0.00	0.00	0.00	0.00
Volume % of Exempt Compounds		29.88	0.00	0.00	0.00	0.00
Density of Material #/gal		7.57	8.25	8.43	8.42	8.43
			with 6954	with 6974	with 6994	with 6994HT
No reduction	Ready to Use (less water, less exempt compounds)		4.10 #/gal (491 g/l)	4.12 #/gal (494 g/l)	4.11 #/gal (492 g/l)	4.12 #/gal (494 g/l)
No Reduction + 6417	Ready to Use (less water, less exempt compounds)		4.17 #/gal (500 g/l)	4.19 #/gal (502 g/l)	4.19 #/gal (502 g/l)	4.19 #/gal (502 g/l)
No Reduction + 6487	Ready to Use (less water, less exempt compounds)		4.07 #/gal (563 g/l)	4.09 #/gal (490 g/l)	4.09 #/gal (490 g/l)	4.09 #/gal (490 g/l)
No reduction + 6737	Ready to Use (less water, less exempt compounds)		4.14 #/gal (496 g/l)	4.16 #/gal (498 g/l)	4.16 #/gal (498 g/l)	4.16 #/gal (498 g/l)
Reduced (4:1:5%) 6700 series	Ready to Use (less water, less exempt compounds)		4.31 #/gal (516 g/l)	4.32 #/gal (518 g/l)	4.32 #/gal (518 g/l)	4.32 #/gal (518 g/l)
Reduced (4:1:10%) 6700-F series	Ready to Use (less water, less exempt compounds)		4.10 #/gal (491 g/l)	4.12 #/gal (494 g/l)	4.11 #/gal (492 g/l)	4.12 #/gal (494 g/l)
5% Reduced 6700 Series + 6487	Ready to Use (less water, less exempt compounds)		4.27 #/gal (512 g/l)	4.29 #/gal (514 g/l)	4.29 #/gal (514 g/l)	4.29 #/gal (514 g/l)



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.

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