



Low VOC Euro Classic Clearcoat 7311

Low V.O.C. Euro Classic Clearcoat is designed for applications requiring the ultimate finish appearance. This high solids clearcoat provides optimum flow and leveling and imparts a glass-like finish. This product can be used with all solvent based and water based basecoats.



Mix Ratio

2:1 – 2 parts 7311 Low VOC Euro Classic Clearcoat to 1 part 7326/7336 activators
Can be reduced up to 5% with 6700 or 6700-F Series Urethane Grade Reducer*.
Pot life: 2 hours (@70°F (21°C) and 50% R.H.).

** Use reducer according to shop conditions. Using reducers other than Zero VOC Urethane Grade Reducers will increase VOC.*



Suitable Substrates

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



Surface Prep & Application

Tack surface 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 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. 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 1/2 oz per sprayable quart.
Appearance Improver

(6487)..... Can be used at a rate of 1-2 oz per sprayable quart.

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

Flex Additive (9194)Use with soft, flexible substrates. Refer to TDS for mixing information.

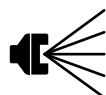
**Flash Times/Dry Times**

Flash between coats.....	5-15 min
Dust free.....	30-40 min
Dry to sand.....	16+ hrs
Deliver	16+ hrs
Force drying.....	40 min @ 140°F (60°C) after a 5-15 min flash

Activator	Flash time	Dust free
7326 Fast	5-10 min	30 min
7336 Slow	10-15 min	40 min

**Gun Set-up**

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

**Air Pressure**

Siphon feed (@ gun)	35 - 45 psi	Gravity feed (@ gun)	25 - 35 psi
Pressure feed (@ gun).....	40 - 50 psi	HVLP/LVLP (@ aircap).....	10 psi

Fluid Pressure

Pressure feed	8 - 10 psi
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**Product Specifications**

Color.....	Clear	Size (7311).....	5 liter
Shelf life.....	3 years	(7326/7336).....	2.5 liter
RTS solids by weight.....	41%	Weight per gallon.....	8.84 #/gal
Approx. coverage.....	656 ft ² /gal @ 1 mil		

Regulatory**7311**

Category.....	Clearcoat	Wt % of volatiles.....	54.93
VOC actual.....	1.32#/gal (159 g/l)	Wt % of water	0
VOC regulatory.....	2.14#/gal (257 g/l)	Wt % of exempt compound	39.97
Density.....	8.84 #/gal	Vol % of exempt compound	38.23
Ready to use (less water exempt compounds)			
with 7326.....	2.1#/gal (249 g/l)		
with 7336.....	2.1#/gal (249 g/l)		

7326

Category.....	Clearcoat	Wt % of volatiles.....	65.26
VOC actual.....	1.01#/gal (121 g/l)	Wt % of water	0
VOC regulatory.....	2.0#/gal (240 g/l)	Wt % of exempt compound	55.19
Density.....	10.02 #/gal	Vol % of exempt compound	49.66

7336

Category.....	Clearcoat	Wt % of volatiles.....	65.27
VOC actual.....	1.01#/gal (121 g/l)	Wt % of water	0
VOC regulatory.....	2.0#/gal (240 g/l)	Wt % of exempt compound	55.2
Density.....	10.01 #/gal	Vol % of exempt compound	49.65



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.

LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.
