

Motor City Euro Clearcoat 8121

Motor City Euro Clearcoat (4.2 VOC) is an acrylic urethane clearcoat that is suitable for all automotive refinishing as well as trucks and equipment. It can be used with all solvent and water based basecoats.



Mix Ratio

2 parts 8121 Motor City Euro Clearcoat
1 part 8136/8146 activators

Can be reduced up to 5% with 6700 or 6700-F Series Urethane Grade Reducer*.

Pot life: 3 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. 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 above. Flash for 5 – 20 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 6 hours before applying more clear or basecoat. After 24 hours, lightly scuff the clearcoat before applying additional material.

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 ¼ to ½ oz per sprayable quart with no reduction.
Fisheye Remover* (6737)	Can be used at a rate of ½ oz per sprayable quart with no reduction.
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 with reduction.

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



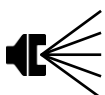
Flash Times/Dry Times

Flash between coats.....	5-20 min
Dust free	15-40 min
Dry to sand.....	8 hrs
Deliver.....	12 hrs MIN
Force drying.....	40 min @ 140°F (60°C) after a 15 min flash
Activator	Flash time Dust free
8136	5-10 min 15-25 min
8146	15-20 min 30-40 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).....	psi

Fluid Pressure

Pressure feed..... .8 - 10 psi



Product Specifications

Weight per Gallon: 7.80	Shelf Life: 3 years
RTS Solids by Weight: 39%	Color: Clear
Approximate Coverage: 520 ft ² /gal @ 1 mil	Size: 5 liter (8121) / 2.5 Liter (8136 / 8146)

Regulatory

Category: Clear Coating: Gloss	8121	8136	8146
VOC Actual	2.36 #/gal (283 g/l)	4.87 #/gal (584 g/l)	4.87 #/gal (584 g/l)
VOC Regulatory	3.55 #/gal (425 g/l)	4.87 #/gal (584 g/l)	4.87 #/gal (584 g/l)
Weight % of Volatiles	61.32	60.73	60.73
Weight % of Water	0.00	0.00	0.00
Weight % of Exempt Compounds	31.10	0.00	0.00
Volume % of Exempt Compounds	33.56	0.00	0.00
Density of Material #/gal	7.80	8.03	8.02

		with 8136	with 8146
No reduction	Ready to Use (less water, less exempt compounds)	4.11 #/gal (492 g/l)	4.12 #/gal (494 g/l)
No reduction + additives	Ready to Use (less water, less exempt compounds)	4.21 #/gal (504 g/l)	4.22 #/gal (506 g/l)
Reduced (2:1:5%)	Ready to Use (less water, less exempt compounds)	4.32 #/gal (518 g/l)	4.33 #/gal (519 g/l)
Reduced + additives	Ready to Use (less water, less exempt compounds)	4.39#/gal (535 g/l)	4.40 #/gal (527 g/l)



Limitations & Precautions

- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- 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.