

# E3 Clearcoat (2.1 V.O.C)

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## *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<sup>®</sup>

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# 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 <sup>2</sup> /gal (13m <sup>2</sup> /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

