

# Signature SERIES

## Production Clearcoat

### Advantages:

- Medium solids clear that is dust free in 15 minutes.
- Suitable for all automotive refinishes, including fleet vehicles and equipment.
- Excellent flow and non sag properties that deliver a high gloss, durable finish.
- Ideal for spot repairs and overall jobs.
- Easily duplicates OEM appearance.
- Factory-backed warranty.



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# Signature Series Production Clearcoat

## DESCRIPTION:

Signature Series Production Clearcoat is a premium 2K, medium solids clearcoat that provides outstanding durability and gloss for panel, multi-panel and overall repairs. Its 15 minute dust free time enables customers to perform efficient repairs in their every day repair processes without sacrificing durability or appearance.

## TECHNICAL DATA:

APPEARANCE: Clear liquid  
 % SOLIDS: Weight: 36% Volume: 35%  
 REDUCER: Optional: Up to 1/2 part  
 Note: Reduction with 6700 Series Urethane Grade Reducer (TDS600) increases the V.O.C. of the product mixture. Reduction with 6700-F Series Zero V.O.C. Urethane Grade Reducer (TDS601) does not increase V.O.C.  
 MIX RATIO: 4:1  
 POT LIFE: 2 - 3 hours @ 68 - 75°F (20 - 24°C) & 50% R.H.  
 SHELF LIFE: One year (unopened)  
 COVERAGE @ 1 mil: 493 ft<sup>2</sup>/gal

## SUITABLE SUBSTRATES:

Automotive refinish basecoats (water and solvent based); automotive refinish single stage (except acrylic lacquer); existing finishes that have been sanded and cleaned.

## SURFACE PREPARATION:

Tack thoroughly before application.

## MIXING & APPLICATION:

Mix 4 parts Production Clearcoat, #9511, with 1 part #9400 Series Clearcoat Activator by volume. Pot life of activated material is 2 – 3 hours at 68° – 75°F and 50% relative humidity. Stir product before use. Apply 2 – 3 medium wet flowing coats using the gun settings listed in the table below. Allow 5 - 15 minutes flash time between coats (depending upon activator used). For optimum appearance, activate clear immediately before applying. Signature Series Product Clearcoat should not be applied over acrylic lacquers.

## REGULATORY:

Category: Clear Coating 9511/9514	Individual Component	Using 9404/9407	Using 9414/9417	Using 9424/9427
VOC Actual	0.65#/gal (77 g/l)	1.87#/gal (224 g/l)	1.84#/gal (221 g/l)	1.86#/gal (222 g/l)
VOC Regulatory (less water, less exempt compounds)	1.62#/gal (195 g/l)	2.36#/gal (283 g/l)	2.36#/gal (282 g/l)	2.37#/gal (284 g/l)
Weight % of Volatiles	68.38	45.31	45.31	45.31
Weight % of Water	0	0	0	0
Weight % of Exempt Compounds	61.44	25.3	25.8	25.6
Volume % of Exempt Compounds	60.13	21.1	21.8	21.6
Density of Material	9.30	9.3	9.5	9.4
VOC Actual Ready to Use		0.89#/gal (107 g/l)	0.88#/gal (106 g/l)	0.89#/gal (106 g/l)
VOC Regulatory Ready to Use		1.86#/gal (223 g/l)	1.86#/gal (223 g/l)	1.87#/gal (224 g/l)

## FORCE DRYING:

Signature Series Production Clearcoat may be force dried at 140°F (60°C) for 10 – 20 minutes.

## DRY TIMES:

68°F - 75°F (20° - 24°C), 50% R.H.

Activator	Flash Time	Dust Free	Sand	Delivery
9404/9407	5 min	10 - 15 min	2 - 3 hrs	4 hrs
9414/9417	5 - 10 min	15 - 20 min	2 - 3 hrs	4 hrs
9424/9427	5 - 15 min	15 - 25 min	2 - 3 hrs	4 hrs

## SPRAY GUN SET UP:

GUN TYPE	FLUID TIP	AIR PRESSURE
Siphon Feed	1.4 – 1.6 mm	35 - 45 PSI (at gun)
Gravity Feed	1.2 – 1.4 mm	25 - 35 PSI (at gun)
Pressure Feed	1.0 – 1.2 mm	40 - 50 PSI (at gun)
HVLP/LVLP	1.2 - 1.6 mm	10 PSI max. (at aircap)

## 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.

## SANDING:

DA (Dry): #1200-1500, finish #2000  
 Hand (Wet): #1200-1500, finish #2000

## TECHNICAL TIPS:

For small jobs (spot & panel) no reduction should be necessary. For larger areas, the use of #9424 will help in achieving excellent flow and leveling.

POLISHING: For dirt removal, lightly nib sand with 1500 grit or finer. Continue with Cutting Compound (TDS404) and Machine Polish (TDS405) for a deep finish and shine. For best results, compound within 24 – 72 hours.

## AVAILABILITY:

9511 Production Clearcoat, Gallon (3.78 L), 2/case  
 9514 Production Clearcoat, Quart (0.946 L), 6/case