



No Mix Production Clear LV-641

No Mix Production Clear is a premium 2K, medium solids clearcoat that provides outstanding durability and gloss for panels, multi-panel and overall repairs. It is formulated for use with the No Mix line of refinish products for optimum performance. It enables customers to perform efficient repairs in their every day repair process without sacrificing durability or appearance.



Mix Ratio

4:1 – 4 parts LV-641 Production Clear to 1 part LV-604/614/624 Activators

Can be reduced up to 5% with No Mix 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 above. 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 2.4 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**

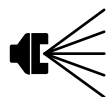
Flash between coats.....	5-15 min
Dust free.....	10-25 min
Dry to sand.....	2-3 hrs
Deliver	4 hrs
Force drying.....	10-20 min @ 140°F (60°C)

Activator**Flash time****Dust free**

LV-604 Fast	5 min	10-15 min
LV-614 Medium	5-10 min	15-20 min
LV-624 Slow	5-15 min	15-25 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 (LV-641).....	Gallon
Shelf life.....	3 years	(LV-604/614/624).....	Quart
RTS solids by weight.....	34%	Weight per gallon.....	8.99 #/gal
Approx. coverage.....	520 ft ² /gal @ 1 mil		

Regulatory**LV-641**

Category.....	Clearcoat	Wt % of volatiles.....	71.33
VOC actual.....	0.68#/gal (81 g/l)	Wt % of water	0
VOC regulatory.....	1.87#/gal (224 g/l)	Wt % of exempt compound	63.80
Density.....	8.99 #/gal	Vol % of exempt compound	63.81
Ready to use (less water exempt compounds)			
with LV-604	2.04#/gal (245 g/l)		
with LV-614	2.04#/gal (245 g/l)		
with LV-624	2.05#/gal (245 g/l)		

LV-604

Category.....	Clearcoat	Wt % of volatiles.....	45.28
VOC actual.....	1.86#/gal (223 g/l)	Wt % of water	0
VOC regulatory.....	2.36#/gal (282 g/l)	Wt % of exempt compound	25.30
Density.....	9.41 #/gal	Vol % of exempt compound	21.10

LV-614

Category.....	Clearcoat	Wt % of volatiles.....	45.34
VOC actual.....	1.84#/gal (221 g/l)	Wt % of water	0
VOC regulatory.....	2.36#/gal (282 g/l)	Wt % of exempt compound	25.82
Density.....	9.39 #/gal	Vol % of exempt compound	21.90

LV-624

Category	Clearcoat	Wt % of volatiles	45.35
VOC actual	1.86#/gal (222 g/l)	Wt % of water	0
VOC regulatory	2.37#/gal (284 g/l)	Wt % of exempt compound	25.62
Density	10.48 #/gal	Vol % of exempt compound	21.68



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.