



Technical Data Sheet

AUTOXTREME LG CLEARCOAT

DESCRIPTION:

Autoxtreme LG Clearcoat is a fast curing urethane clearcoat designed to provide a LOW-GLOSS durable UV resistant finish. Perfect for exterior panels, underside of hoods, engine compartment, trunk lids and backside of body panels. Autoxtreme LG Clearcoat is mixed 4:1 with the Autoxtreme Hardeners.

*SHAKE PRIOR TO USING: Shaking is required to insure the clear and flattening agent is thoroughly mixed prior to adding hardener.

PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
Autoxtreme LG Clearcoat	6304	Quart
Autoxtreme Fast Hardener	6654	Quart
Autoxtreme Fast Hardener	6659	½ Pint
Autoxtreme Medium Hardener	6754	Quart
Autoxtreme Medium Hardener	6759	½ Pint
Autoxtreme Slow Hardener	6854	Quart
Autoxtreme Slow Hardener	6859	½ Pint
Autoxtreme X-Slow Hardener	6954	Quart
Autosolv Slow Reducer (see mixing)	2851/2854	Gal/Qt
Autosolv Extra Slow Reducer (see mixing)	2951/2954	Gal/Qt
Autosolv Urethane Retarder (see mixing)	2194	Quart

COMPATIBLE SUBSTRATES:

Autokote Colors
 Wheelkote Colors
 OEM Finishes



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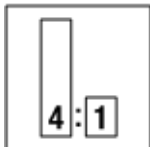
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SAFETY ASPECTS:



Users should review the Safety Data Sheet (SDS) and product label for the material to be used to determine possible health hazards, appropriate engineering controls and precautions to be observed in the use of the material. Copies of the SDS are available on the ordering portal. Click on the SDS button located under each product. You can also locate the SDS on the tech center website or call the technical department and request them.

MIXING RATIOS:



MIX 4:1

4 parts: Autotxtreme LG Clearcoat (Shake well prior to pouring)

1 part: Fast, Medium or Slow Autotxtreme Hardeners

****When Baking:** use up to 5% Autosolv Slow or Extra Slow Reducer

Hot Weather Note: For temperatures over 100°F add 1 ounce of AK.2194 Autosolv Urethane Retarder per sprayable quart of clear to improve flow, leveling and through cure.

GUN SETUP:



TYPE	FLUID TIP	SPRAYING PRESSURE
Conventional Gravity	1.3 mm – 1.4 mm	40 - 45 psi @ gun
HVLP Gravity	1.3 mm – 1.4 mm	8 - 10 psi @ gun

Fluid Adjustment for: 1.3mm nozzle = turn out 3 full turns

1.4mm nozzle = turn out 2 ½ turns

NUMBER OF COATS:

Apply Two (2) wet coats. Allow 5 minutes flash between coats

FLASH TIMES:

5 minutes between coats

PURGE TIME:

5 minutes.



Technical Data Sheet

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DRYING TIMES:



METAL TEMP	DUST FREE	TACK FREE	DRY
75°F/24°C	10 - 15 minutes	15-20 minutes	6-8 hours
120°F/49°C	N/A	N/A	20-30 minutes

Note: Purge time before force dry is generally 5 minutes.

RECOATABILITY:

Autoxtreme LG Clearcoat may be recoated after bake cycle when metal has completely cooled down. Air dry repair can be done after 3-4 hours. For best results in air dry situations repair next day.

FILM THICKNESS:

Approximately 1.0 -1.2 mils per single coat.

POLISHING:



Not Recommended

NOTE: If any polishing is performed it will increase the gloss level and create visible areas. To repair this situation, the Autoxtreme LG Clearcoat would need to be re-applied over the entire panel for a consistent low gloss appearance.

DECALS:

Decals, lettering or stripes can be applied after 24 hours.

CLEANING EQUIPMENT

Clean equipment immediately with lacquer thinner.



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TECHNICAL DATA:



Color	Clear
Activator/Hardener	Fast, Medium or Slow Autoktreme Hardeners
Mix Ratio	4:1
Reducer	Optional: 0- 5% Autosolv Slow or Extra Slow Reducer only if needed when baking
Additives	AK.2194 Autosolv Retarder (see mixing)
Number of Coats	2 full wet coats
Flash Time	5 minutes
Purge Time	5 minutes
Dry Time	6-8 hours @ 75°/24°C 20-30 minutes @ 120°F/49°C
Gun Set-Up	Refer to Table on Page 2
Air Pressure @ Gun	Refer to Table on Page 2
Pot Life:	1 hours @ 72°F
Actual V.O.C.	0.86 lb/gal 103.01 g/L
Regulatory V.O.C.	1.99 lb/gal 238.81 g/L
Package Size	Quart
Shelf Life	12 months unopened

All data given below are MAXIMUM THEORETICAL VALUES based on the product AS CURRENTLY FORMULATED. Variations may occur on individual batches due to adjustments made during production.

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