



Technical Data Sheet

AUTOXTREME MS CLEARCOAT

DESCRIPTION:

Autotxtreme MS Clearcoat is a high quality acrylic urethane clear designed for multi-panel and overall applications. Autotxtreme MS Clearcoat contains European resins which provides a high gloss, long-lasting finish, and chemical resistance properties. Easy 4:1 mixing ratio along with the 2-coat application, provides less booth time and cost savings. Conforms to the 3.5 V.O.C. regulations.

To be applied over Autokote Colors and OEM finishes.

PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
Autotxtreme MS Clearcoat	6501	Gallon
Autotxtreme MS Clearcoat	6504	Quart
Autotxtreme Fast Hardener	6659	½ Pint
Autotxtreme Fast Hardener	6654	Quart
Autotxtreme Medium Hardener	6759	½ Pint
Autotxtreme Medium Hardener	6754	Quart
Autotxtreme Slow Hardener	6859	½ Pint
Autotxtreme Slow Hardener	6854	Quart
Autotxtreme X-Slow Hardener	6954	Quart
Autosolv Reducers (5-10% ONLY IF NEEDED)	Various	Qt/Gal

COMPATIBLE SUBSTRATES:

Autokote Colors
OEM Finishes

SAFETY ASPECTS:



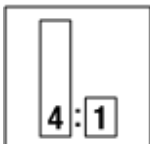
Users should review the Safety Data Sheet (SDS) and product label for the material to be used to determine possible health hazards, appropriate engineering controls and precautions to be observed in the use of the material. Copies of the SDS are available on the ordering portal. Click on the SDS button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



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MIXING RATIOS:



MIX 4:1

4 parts: Autoxtreme MS Clearcoat

1 part: Fast, Medium, Slow or X-Slow Autoxtreme Hardeners

Optional: 5 - 10% Autosolv Urethane Reducers

Additional reducer may raise V.O.C. above 3.5 lbs./gal.

Note: Autoxtreme MS Clearcoat is a 3.5 lbs./gal VOC product. Not for sale in 2.1 lbs./gal VOC areas.

GUN SETUP:



TYPE	FLUID TIP	SPRAYING PRESSURE
Mini Jet Gravity	1.0 mm - 1.2 mm	10 - 15 psi @ gun
Conventional Gravity	1.3 mm - 1.4 mm	40- 45 psi @ gun
HVLP Gravity	1.3 mm - 1.4 mm	8 - 10 psi @ gun

NUMBER OF COATS:

For best results: the first coat of Autoxtreme MS Clearcoat should be one full wet coat allowing to flash approximately 10-15 minutes, depending on temperature and activator used. Then apply a second full wet coat.

FLASH TIMES:

10-15 minutes.

PURGE TIME:

5 minutes.

DRYING TIMES:



METAL TEMP	DUST FREE	TACK FREE	DRY
75°F/24°C	10-12 minutes	30-40 minutes	6-8 hours
140°F/60°C	N/A	N/A	20-40 minutes

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

RECOATABILITY:

Autoxtreme MS Clearcoat may be recoated after bake cycle when metal has completely cooled down. Air dry repair can be done after 8+ hours. For best results in air dry situations repair next day.

FILM THICKNESS:

Approximately 1.0 -1.2 mils per single coat.

POLISHING:



For optimum results, allow cool down after baking or at 90 minutes if air dried. Allow these times if sanding, light de-nib with 2000 grit. Recommended to use foam pads if compounding and/or polishing.



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

CLEANING EQUIPMENT Clean equipment immediately with lacquer thinner.

TECHNICAL DATA:



Color	Clear
Activator/Hardener	Fast, Medium, Slow or X-Slow Autokote Hardeners
Mix Ratio	4:1
Reducer	Autosolv Reducers Optional: 5-10% if needed
Additives	N/A
Number of Coats	2 full wet coats
Flash Time	10-15 minutes
Purge Time	5 minutes
Dry Time	8 hours @ 75°/24°C
Force Dry	20 - 40 minutes @ 140°F/60°C
Additional Fluid Adjustment Settings	1.3mm Fluid Adjustment- turn out 3 full turns
" " " "	1.4mm Fluid Adjustment- turn out 2 1/2 turns
Pot Life:	4-6 hours @ 72°F 50% RH
Sprayable V.O.C.	3.46 lbs/gal (426 g/l)
V.O.C. Limit	5.0 lbs/gal (600 g/l) BC/CC combine
% Solids, Sprayable by Weight	41% (Unreduced)
Package Size	Quart / Gallon
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.

DISCLAIMER: The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as Autokote Systems, LLC deems appropriate.