



# Technical Data Sheet

## AUTOXTREME XP CLEARCOAT

### DESCRIPTION:

**Autoxtreme XP Clearcoat** has been specifically formulated for the mobile repair industry. Autoxtreme XP Clearcoat is a 2K acrylic urethane clear with superior UV and chemical resistance properties and offers a fantastic high gloss appearance. Easy 3:1 mixing ratio with a  $\frac{3}{4}$  gallon or quart. Sand and buff in 90 minutes.

To be applied over Autokote Colors and OEM finishes.

\*SHAKE PRIOR TO USING

### PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
Autoxtreme XP Clearcoat	6204	.75 Quart
Autoxtreme XP Clearcoat	6201	$\frac{3}{4}$ Gallon
Autoxtreme Fast Hardener	6659	$\frac{1}{2}$ Pint
Autoxtreme Fast Hardener	6654	Quart
Autoxtreme Medium Hardener	6759	$\frac{1}{2}$ Pint
Autoxtreme Medium Hardener	6754	Quart
Autoxtreme Slow Hardener	6859	$\frac{1}{2}$ Pint
Autoxtreme Slow Hardener	6854	Quart
Autoxtreme X-Slow Hardener	6954	Quart
Reducer (ONLY IF NEEDED)	Various	Qt/Gal

### COMPATIBLE SUBSTRATES:

Autokote Colors  
OEM Finishes

### SAFETY ASPECTS:



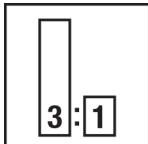
Users should review the Safety Data Sheet (SDS) and product label for the material to be used to determine possible health hazards, appropriate engineering controls and precautions to be observed in the use of the material. Copies of the SDS are available on the ordering portal. Click on the SDS button 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 3:1

3 parts: Autoxtreme XP Clearcoat

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

**Optional:** 0-5% NR Reducers

*Additional reducer may raise V.O.C. above 4.2 lbs./gal.*

*Note:* Autoxtreme XP Clearcoat is a National Rule, 4.2 lbs./gal VOC product. Not for sale in 2.1 lbs./gal VOC areas.

### GUN SETUP:



TYPE	FLUID TIP	SPRAYING PRESSURE
Mini Jet Gravity	1.2 mm – 1.3 mm	5 - 15 psi @ gun
HVLP/Conventional Gravity	1.2 mm – 1.4 mm	25 - 30 psi @ gun

### NUMBER OF COATS:

For best results the first coat of Autoxtreme XP Clearcoat should be one full wet coat allowing to flash approximately 1-5 minutes, depending on temperature. Then apply a second full wet coat.

### FLASH TIMES:

1-5 minutes.

### PURGE TIME:

5 minutes.

### DRYING TIMES:



METAL TEMP	DUST FREE	TACK FREE	DRY
75°F/24°C	5-10 minutes	15-20 minutes	90 minutes
140°F/60°C	N/A	N/A	30 minutes

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

### RECOATABILITY:

Autoxtreme XP Clearcoat may be recoated after bake cycle when metal has completely cooled down. Air dry repair can be done after 2-4 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 Autoxtreme Hardeners
Mix Ratio	3:1
Reducer	Optional: 5% if needed
Additives	N/A
Number of Coats	2 full wet coats
Flash Time	1-5 minutes
Purge Time	5 minutes
Dry Time	90 minutes @ 75°/24°C 30 minutes @ 140°F/60°C
Gun Set-Up	Refer to Table on Page 2
Air Pressure @ Gun	Refer to Table on Page 2
<b>Pot Life:</b>	4 hours @ 68°F
Sprayable V.O.C.	4.2 lbs/gal (500 g/l)
Package Size	.75 Quart / ¾ 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.*

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