



Technical Data Sheet

Automotive Art 4:1 Clear 84-51 (2.1 VOC)



General Information:

Automotive Art Clear 84-51 is a quality low VOC production clear coat with 4:1 mixing ratio, very versatile that can be used for spot, panel and overall repair. It's easy to spray and apply with a high gloss and fast drying.

Substrates:

Apply on top of clean & dust free Automotive Art Basecoat.

Mixing Ratio:



4:1

100% by vol. Automotive Art Top Clear

25% by vol. Automotive Art Hardener

No reducer required

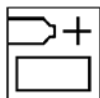
Part

84-51

34-65, 34-75 or 34-85

Pot Life: 1 hours at 20° C (68F)

Additives:



20 - 45 Flex additive (Add 25% by vol. before adding hardener)

20 - 10 Accelerator (Add up to 5% to RTS mixture)

Air Pressure and Spray gun Setup:

	<u>Air Pressure</u>	<u>Nozzle Size</u>
HVLP:	21-29 psi (1.4-2.0 bar)	1.3-1.4 mm
Conventional:	2.5 bar (35 psi)	1.3-1.5 mm

Note: For best overall result, refer to spray gun manufacturer's recommendations.

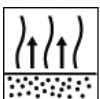
Application:



Apply: 2 full coats

Coat Thickness: 2.0 mil (50 µm)

Drying Times:



Between Coats: 8 - 10 minutes at 20°C (68°F)



<u>Tack-Free</u>	<u>Assembly</u>	<u>Polish</u>	<u>Recoat</u>
30 min	4 hours	4 hours	12 hours

Selection Guide Charts:

Hardeners

Temperature Range

Description	Part #	55°F-70°F (12°C-21°C)	70°F-85°F (21°C-30°C)	+ 85°F (+30°C)
High Temp/Slow	34-65			
Medium Temp/Normal	34-75			
Low Temp/ Fast	34-85			

Surface Preparation:



- Apply over Automotive Art Basecoat, it may require to pass a light tack cloth over the surface to remove dirt and overspray.
- Please allow the basecoat to dry at least 15 - 20 min before applying clearcoat.

Sanding:

- For recoating it can be sanded with P 600 - P 800
- To Polish P 1200 – P 5000

Packing & Shelf Life:

Sizes: 5L, 1L, 500ML
Shelf life: Under normal storage conditions minimum two years (unopened tins).



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Notes:

- Do not overapply, solvent pop may occur.
- Humidity affects clear coat components, so the application equipment should be absolutely dry. Close the hardener container immediately after use.
- Do not use at temperatures lower than +50°F/10°C in this case, dry in spray booth.

Technical Data:

RTS Combinations:	84-51 : 34-65/75/85
Volume Ratio:	4:1
Specific Gravity:	1.113 kg/l
Flash Point:	17°C, (63°F)
Solids Vol %:	36.5%
Solids Wt. %:	NA
Coverage:	8 -9 m ² /L (per layer 50 µm)
Viscosity (RTS):	14-16 sec. Cup DIN 4
Gloss:	High Gloss
Color:	Clear
V.O.C. Actual:	155 g/l, (1.3 lbs/gal)
V.O.C. Regulatory RTS (less water, less exempts):	361 g/l, (2.1 lbs/gal)
V.O.C. Ready to Spray:	249 g/l, (2.1 lbs/gal)
Applicable Use Category:	Clear Coating

See Material Safety Data Sheet and Labels for additional Safety Information and handing instructions.