

Motor City Clearcoat

8041

Motor City Clearcoat 8041 is an acrylic urethane clearcoat with a sprayable V.O.C. of 4.5 #/gal. This product can be used with all solvent and water based basecoats. It is suitable for all automotive refinishing as well as trucks and equipment.



Mix Ratio

4:1 – 4 parts 8041 Motor City Clearcoat to 1 part 8004/8014 activators
 Can be reduced up to 5% with 6700 or 6700-F Series Urethane Grade Reducer*.
 Pot life: 3 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 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 2.2 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

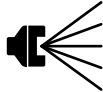
Flash between coats.....5-15 min
 Dust free.....10-20 min
 Dry to sand.....6-8 hrs
 Deliver12 hrs MIN
 Force drying.....30 min @ 140°F (60°C) after a 5-10 min flash

Activator	Flash time	Dust free
8004	5-10 min	10-15 min
8014	10-15 min	15-20 min



Gun Set-up

Siphon feed.....1.2 - 1.6 mm	Gravity feed..... 1.2 - 1.6 mm
Pressure feed1.0 - 1.2 mm	HVLP/LVLP 1.2 - 1.6 mm



Air Pressure

Siphon feed (@ gun)35 - 50 psi	Gravity feed (@ gun) 35 - 50 psi
Pressure feed (@ gun).....40 - 50 psi	HVLP/LVLP (@ aircap)..... 10 psi

Fluid Pressure

Pressure feed8 - 10 psi



Product Specifications

Color.....Translucent	Size (8041).....Gallon
Shelf life.....3 years	(8004/8014).....Quart
RTS solids by weight.....36%	Weight per gallon.....7.62 #/gal
Approx. coverage.....474 ft ² /gal @ 1 mil	

Regulatory

8041

Category.....Clearcoat	Wt % of volatiles.....68.13
VOC actual.....3.66#/gal (439 g/l)	Wt % of water0
VOC regulatory.....4.76#/gal (571 g/l)	Wt % of exempt compound20.06
Density.....7.62 #/gal	Vol % of exempt compound23.12
Ready to use (less water exempt compounds) with 8004.....4.52#/gal (542 g/l)	
with 8014.....4.49#/gal (538 g/l)	

8004

Category.....Clearcoat	Wt % of volatiles.....49.93
VOC actual.....3.40#/gal (407 g/l)	Wt % of water0
VOC regulatory.....3.72#/gal (446 g/l)	Wt % of exempt compound11.00
Density.....8.73 #/gal	Vol % of exempt compound8.62

8014

Category.....Clearcoat	Wt % of volatiles.....46.2
VOC actual.....3.52#/gal (422 g/l)	Wt % of water0
VOC regulatory.....3.63#/gal (446 g/l)	Wt % of exempt compound4.00
Density.....8.34 #/gal	Vol % of exempt compound3.00



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.