

3164 OVERALL CLEARCOAT

PRODUCT DESCRIPTION:

3164 Overall Acrylic Urethane Clearcoat is a high production easy buffing clear for use over basecoat color systems. 3164 is designed for 2-coat application and will exhibit outstanding gloss, flow and durability; based on the most recent state-of-the-art urethane resin technology. 3164 is clear so it absolutely will not change basecoat color. Simple 4 to 1 mix ratio that produces less than 3.5 V.O.C. per sprayable gallon.

FEATURES:

1. Outstanding gloss and D.O.I.
2. Easy next day buffing (after 10 hrs. @70 F.)
3. Bake at 140 F, 40 minutes after a 10 minute flash
4. Apply over all urethane basecoat systems
5. Extremely durable, clear formula

MIXING INSTRUCTIONS:

Clear = 4 parts

Activator = 1 part (3701/3703/3705/3707) [Match activator selection to the reducer temp range selection, or slower]

CP-80 = Fast 55 to 65 F

CP-82 = Slow 75 F - 90 F

CP-81 = Medium 65 to 75 F

CP-83 = Ex-Slow 90 F - up

Note: Can be reduced up to 25% with urethane grade reducer (CP-80/81/82/83). Some reduction may be necessary when using HVLP spray equipment. Only in 4.4 V.O.C. National Rule Areas.

BASECOAT COLOR:

Apply basecoat color as per manufacturer's instructions. Be sure to allow correct flash times for best results.

APPLICATION:

1. Select appropriate activator (see chart).
2. ASE 50-65 PSI air pressure at gun for a conventional spray gun. Use mfr. Recommended pressure and 1.3 – 1.5 mm fluid tip and cap with HVLP.
3. Apply 2 full wet coats. Note: Clear will atomize better and lay flatter when using gun with smaller fluid nozzle. We recommend 1.3 or 1.4mm or .050 to .055.
4. Allow 15-20 minutes flash between coats.

BLENDING:

1. Be sure blend area is prepared with a gray scuff pad for blending clears or compound for blending single stage colors and thoroughly cleaned with pre-cleaner; compound residue must be removed.
2. Apply wet coat of clear several inches beyond painted area. Let flash 5 minutes.
3. Apply second wet coat several inches beyond first coat of clear.
4. Reduce remainder of clear 100% with urethane grade reducer (CP-80/81/82/83).
5. Reverse blend reduced clear back into repaired area. Spray very lightly on clear edge only.

CLEANING:

Use good quality lacquer thinner or urethane reducer (CP-80/81/82/83) to thoroughly clean all equipment. Do not leave activated clear in gun longer than 4-6 hours. Clean equipment immediately when using CP-9900 Universal Accelerator.

FORCE DRY:

1. Allow booth to purge 0 - 5 minutes after final coat.
2. Bake at 140 F for 40 minutes.
3. Allow at least one hour cool down before wet sanding.
4. Using 3705 or 3707 Activator will increase gloss level when baking (due to the slower solvents of these activators).

SANDING:

1. Wet sand with 1200 grit or finer sandpaper.
2. Sanding and buffing is much easier when done within 48 hours.

BUFFING:

1. Buff according to desired appearance after 10 - 12 hours dry.
2. Baking will reduce buff time.

ACCELERATION:

3164 can be accelerated with CP-9900 to compensate for cold shop conditions. 9900 Accelerator should be used at a rate of one cap full per sprayable quart maximum. For best results maintain 70 F shop temperature throughout cure period.

TECHNICAL DATA:

Coating Type:	Acrylic Urethane
Color:	Clear
Catalyst:	3701 (Fast),3703 (Medium),3705 (Slow),3707 (Extra Slow)
Slow Mix Ratio:	4 parts clear to 1 part activator Reduction (optional) Up to 20% Urethane Reducer if desired, only in 4.4 Rule Areas.
Viscosity:	18-20 seconds #2 Zahn Solids by Volume 38% RTS
Recommended Film Build:	2.0 - 2.5 Mils Dry
Coverage:	610 sq. ft. per Gallon at 1 Mil
Dry Times:	
Dust Free-	10-12 minutes
Wet Sand-	10-12 hours
Tack Free-	40 minutes
Delivery-	Overnight (10 – 12 hours)
Pot Life:	4 - 6 hours
V.O.C w/ 3701,3703,3705,3707	3.5 lbs/gal (420 g/l) Ready To Spray