



# Kwik Gloss Clearcoat

## 6841, 6844

**Kwik Gloss Clearcoat is a fast drying acrylic urethane clearcoat. It can be used with all solvent and water based basecoats to provide ultimate productivity and gloss. Kwik Gloss is formulated for use with a complete line of activators for application over a wide range of job sizes and temperatures. It is suitable for all automotive refinishing as well as trucks and equipment.**



### Mix Ratio

4:1 – 4 parts 6841/6844 Kwik Gloss Clearcoat to 1 part 6800 series activators  
 Can be reduced up to 10% with 6700 or 6700-F Series Urethane Grade Reducer\*.  
 Pot life: 4-6 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 on next page. 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 one hour between coats. If more than one 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**

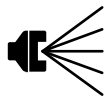
Flash between coats.....5 min  
 Dust free.....5-25 min  
 Dry to sand.....4-8 hrs  
 Deliver .....6-12 hrs MIN  
 Force drying.....30 min @ 140°F (60°C) after a 5-10 min flash.

| Activator            | Flash time | Dust free |
|----------------------|------------|-----------|
| 6854/6856            | 5 min      | 5-10 min  |
| 6874/6876/6877       | 5-10 min   | 5-10 min  |
| 6894/6896            | 5-15 min   | 10-15 min |
| 6894HT/6896HT/6897HT | 10-15 min  | 15-25 min |



**Gun Set-up**

Siphon feed.....1.4 - 1.6 mm Gravity feed.....1.2 - 1.4 mm  
 Pressure feed .....1.0 - 1.2 mm HVLP/LVLP .....1.2 - 1.4 mm



**Air Pressure**

Siphon feed (@ gun) .....35 - 45 psi Gravity feed (@ gun) .....25 - 35 psi  
 Pressure feed (@ gun).....40 - 50 psi HVLP/LVLP (@ aircap).....10 psi

**Fluid Pressure**

Pressure feed .....8 - 10 psi



**Product Specifications**

Color.....Translucent Size (6841).....Gallon  
 Shelf life.....3 years (6844).....Quart  
 RTS solids by weight.....37% Weight per gallon.....7.56 #/gal  
 Approx. coverage.....476 ft<sup>2</sup>/gal @ 1 mil

**Regulatory**

**6841/6844**

|  |                                     |
|--|-------------------------------------|
| Category.....Clearcoat                     | Wt % of volatiles.....68.00         |
| VOC actual.....2.96#/gal (355 g/l)         | Wt % of water .....0                |
| VOC regulatory.....4.42#/gal (530 g/l)     | Wt % of exempt compound .....28.80  |
| Density.....7.56 #/gal                     | Vol % of exempt compound .....32.95 |
| Ready to use (less water exempt compounds) |                                     |
| with 6854.....4.2#/gal (505 g/l)           |                                     |
| with 6874.....4.2#/gal (508 g/l)           |                                     |
| with 6894.....4.2#/gal (505 g/l)           |                                     |
| with 6894HT .....4.2#/gal (506 g/l)        |                                     |

**6854/6856**

|  |                                    |
|--|------------------------------------|
| Category.....Clearcoat                 | Wt % of volatiles.....46.98        |
| VOC actual.....3.50#/gal (419 g/l)     | Wt % of water .....0               |
| VOC regulatory.....3.64#/gal (419 g/l) | Wt % of exempt compound .....5.20  |
| Density.....8.37 #/gal                 | Vol % of exempt compound .....3.91 |

**6874/6876/6877**

|  |                                    |
|--|------------------------------------|
| Category.....Clearcoat                 | Wt % of volatiles.....49.93        |
| VOC actual.....3.40#/gal (407 g/l)     | Wt % of water .....0               |
| VOC regulatory.....3.72#/gal (446 g/l) | Wt % of exempt compound .....11.00 |
| Density.....8.73 #/gal                 | Vol % of exempt compound .....8.62 |

**6894/6896**

|                      |                     |                                |       |
|----------------------|---------------------|--------------------------------|-------|
| Category .....       | Clearcoat           | Wt % of volatiles.....         | 46.20 |
| VOC actual .....     | 3.52#/gal (422 g/l) | Wt % of water .....            | 0     |
| VOC regulatory ..... | 3.63#/gal (435 g/l) | Wt % of exempt compound .....  | 4.00  |
| Density .....        | 8.34 #/gal          | Vol % of exempt compound ..... | 3.00  |

**6894HT/6896HT/6897HT**

|                      |                     |                                |       |
|----------------------|---------------------|--------------------------------|-------|
| Category .....       | Clearcoat           | Wt % of volatiles.....         | 46.20 |
| VOC actual .....     | 3.50#/gal (419 g/l) | Wt % of water .....            | 0     |
| VOC regulatory ..... | 3.65#/gal (438 g/l) | Wt % of exempt compound .....  | 5.50  |
| Density .....        | 8.59 #/gal          | Vol % of exempt compound ..... | 4.25  |



**Limitations & Precautions**

- Visit [www.tat-co.com](http://www.tat-co.com) to assure use of the most current instructions and TDS on this product.
- See website ([www.tat-co.com](http://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.