North America

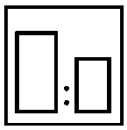
Programmed System Technique (PST)
Clearcoat
01/27/2022

4.0 Select Clearcoat

4.0 Select Clearcoat is a two-component polyurethane clearcoat. Provides a high gloss finish in two full wet coats. This product is designed for ease of buffing, even after aggressive color sanding or several days of cure. The ready to spray VOC is 4.0 lb/gal.

Safety Considerations
- Use suitable personal protection.
- When exposed to paint or solvents, AkzoNobel recommends the use of a fresh air supply respirator

Surface Preparation
- U-Base Basecoat
  - Wait until the indicated flash time before clearcoat application.
- Existing Clearcoat
  - Thoroughly sanded with P1000 dry or a gray scuff pad.



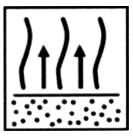
BY VOLUME
STICK #109

Mix	By Volume
4	• 4.0 Select Clearcoat
1	• 4.0 Select Activator - Fast, Medium or Slow

Spray-Gun Set-Up:

		Refer to gun manufacturer specifications	
• RP – Pressure Feed	• 0.8 – 1.4mm	• 30 – 36psi	• 12 – 16 oz/min
• RP – Gravity Feed	• 1.3 – 1.4mm	• 30 – 35psi	
• HVLP – Pressure Feed	• 1.0 – 1.2mm	• Max 10psi (cap)	• 12 – 16 oz/min
• HVLP – Gravity Feed	• 1.4 – 1.5mm	• Max 10psi (cap)	

Application
- 2 – 3 x 1 Coats (2 to 3 wet flowing coats)



Flash Between Coats at 70°F (21°C)
- 5 minutes

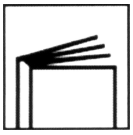
Flash at 70°F (21°C) Before Force Drying
- 5 minutes

Air Drying at 70°F (21°C)
- Dry to handle in 15 hours

Dependent on film weight and air flow.

Force Drying at 140°F (60°C)
- Dry to handle in 45 minutes

Allow to cool down to ambient temperature.



Recoatable With:
- 4.0 Select Clearcoat may be recoated with itself after a full drying cycle. Sanding becomes necessary after 24 hours.

4.0 Select Clearcoat

Description

4.0 Select Clearcoat is a two-component polyurethane clearcoat. Provides a high gloss finish in two full wet coats. This product is designed for ease of buffing, even after aggressive color sanding or several days of cure. The ready to spray VOC is 4.0 lb/gal.

Suitable Substrates

- U-TECH U-Base Basecoat – Wait until the indicated flash time before clearcoat application.
- Existing Finishes – In the case of spot or blend repair, degrease and sand with #P800 to #P1000 dry.

- Properly degrease substrate prior to sanding with either AutoPrep Ultra Prep or R859 wax and grease remover.

Products and Additives

Product	4.0 Select Clearcoat	Item # 399115	
Hardeners	4.0 Select Fast Activator	Item # 399097	Up to 85°F (30°C)
	4.0 Select Medium Activator	Item # 399098	70°F (21°C) - 85°F (30°C)
	4.0 Select Slow Activator	Item # 399099	80°F (27°C) - 95°F (35°C)
Additives	997 Enhancer	Item # 398679	Extends flash times and pot-life
	998 Accelerator	Item # 483670	Accelerates dry times
	T-890 Flattening Agent	Item # 399084	Used to achieve lower gloss
	LV Flex Additive	Item # 398767	For flexible substrates
	B91 Reducer SRA	Item # 510324	Special solvent for spot repairs

- SDS and TDS for products available online at – http://my.anaac.net/

Basic Raw Materials

Product	4.0 Select Clearcoat	Hydroxyl acrylic resins
	4.0 Select Activator Fast, Medium and Slow	Polyisocyanate resin and solvent
	LV Flex Additive	Special polyester resins

Substrate Preparation

Pre-Cleaning

- If needed, pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with R859 Surface Cleaner, AutoPrep Ultra-Prep (VOC compliant) or Anti-Static surface cleaners.

4.0 Select Clearcoat

Sanding Preparation

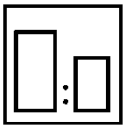
– Existing Finishes

– P800 to P1000 Dry

Surface Cleaning – Prior to Paint Application

- Clean with R859 Surface Cleaner, AutoPrep Ultra-Prep (VOC compliant), Anti-Static or OTO Quick surface cleaners.

Mixing

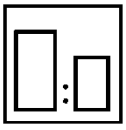


BY VOLUME
STICK # 109

Mix
4
1

Standard Mix

- 4.0 Select Clearcoat
- 4.0 Select Activator – Fast, Medium or Slow



BY VOLUME

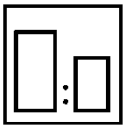
Mix-Step 1

100
15

Flexed Mix

- 4.0 Select Clearcoat
- LV Flex Additive

✓ **Stir this mixture well, THEN:**



BY VOLUME
STICK # 109

Mix-Step 2

4
1

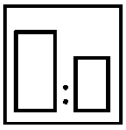
- 4.0 Select Clearcoat / LV Flex Additive Mixture (from Step 1)
- 4.0 Select Activator – Fast, Medium or Slow

✓ 4.0 Select Clear Flexed should be used in combination with flexed primers, sealers and topcoats

Mix
4
1
+

Accelerated Mix

- 4.0 Select Clearcoat
- 4.0 Select Activator – Fast, Medium or Slow
- Add a maximum of ½ oz of 998 Accelerator per RTS gallon or 3 – 4 grams per RTS quart



BY VOLUME
STICK # 109

Mix
4
1

Flattened Clearcoat Mix – Step 1

- 4.0 Select Clearcoat
- 4.0 Select Activator – Fast, Medium or Slow

✓ **Stir this mixture well**

Then, Add **– Step 2**

10% - 50%
(Refer to Table)

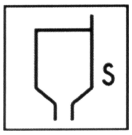
- T890 Flattening Agent (by volume) to the ready to spray clearcoat mixture from Step 1, using the following table as a guide:

4.0 Select Clearcoat

Gloss Level	% of T890
• Antique (70 – 80 gu)	– 10%
• Eggshell (50 - 60 gu)	– 20%
• Semi-gloss (40 -50 gu)	– 30%
• Matte (20 – 30 gu)	– 40%
• Flat (10 – 20 gu)	– 50%

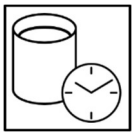
✓ A sprayout should be made to evaluate the gloss level needed.

Viscosity – Ready to Spray



14–20 Seconds Measured with a DIN #4 viscosity cup at 70°F (21°C)

Pot-Life When Mixed



4.0 Select Clearcoat at 70°F (21°C)	No Additives	998 Accelerator
• Fast Activator	– 2 hours	– 1 hour
• Medium Activator	– 3 hours	– 1.5 hours
• Slow Activator	– 3 hours	– 2 hours

✓ **Extended Pot-Life:** The pot-life of 4.0 Select Clearcoat may be extended to a maximum of 4 hours (@ 70°F (21°C)) by preparing a flexed mixture per TDS using 4.0 Select Clear Activator Slow and adding 2 ounces of U-TECH 997 Enhancer per ready to spray gallon.

Spray Gun Set-Up

Consult spray gun manufacturer instructions for gun pressure specifications.

Spray Gun	Fluid Tip	Application Pressure
RP Pressure Feed	0.8 – 1.4 mm	12 – 16 oz/min at 30 – 36 psi
RP Gravity Feed	1.3 – 1.4 mm	30 – 35 psi
HVLP Pressure Feed	1.0 – 1.2 mm	12 – 16 oz/min at <10 psi (0.68 bar) at cap.
HVLP Gravity Feed	1.4 – 1.5 mm	<10 psi (0.68 bar) at cap.

4.0 Select Clearcoat

Application

Application

- Apply two (2) to three (3) wet flowing coats

Flash Drying

Flash Between Coats at 70°F (21°C)

- 5 minutes
  - Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.

Flash at 70°F (21°C) Before Force Drying

- 5 minutes

Drying / Curing Time

4.0 Select Activator Fast

	No Additives		½ oz 998 Accelerator per gal	
	70°F (21°C)	140°F (60°C)	70°F (21°C)	140°F (60°C)
Dust Free	1 hr	N.A.	8 min	N.A.
Dry to handle	8 hrs	25 min	4 hrs	15 min

4.0 Select Activator Med

	No Additives		½ oz 998 Accelerator per gal	
	70°F (21°C)	140°F (60°C)	70°F (21°C)	140°F (60°C)
Dust Free	1 ½ hrs	N.A.	12 min	N.A.
Dry to handle	12 hrs	30 min	6 hrs	20 min

4.0 Select Activator Slow

	No Additives		½ oz 998 Accelerator per gal	
	70°F (21°C)	140°F (60°C)	70°F (21°C)	140°F (60°C)
Dust Free	2 hrs	N.A.	20 min	N.A.
Dry to handle	16 hrs	35 min	8 hrs	25 min

Note: 998 will decrease pot life. Extreme temperatures may require higher amounts of 997
Using LV Flex will extend curing times and effect the sandability of 4.0 Select Clearcoat

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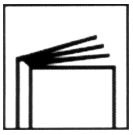
Recoating



- 4.0 Select Clearcoat is recoatable with itself after full drying cycle. Sanding becomes necessary after 24 hours.

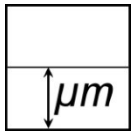
Decals and Lettering

- Decals and adhesive stripes can be applied after 48 hours at 70°F (21°C).
- Hand painted striping or lettering must be applied within 24 hours for good adhesion. After 24 hours, scuff with a grey scuffing pad before application.

Cleaning of Equipment

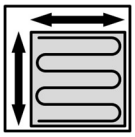
- Clean equipment and dispose of waste following local and federal regulations. In compliant localities, use a VOC compliant high-quality solvent borne gun cleaner. For national rule regions, a use high quality lacquer thinner.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

Film Thickness – Using Suitable Application



- 1 Coat will achieve a thickness of 1.2 – 1.4 mils (30.5µm – 35.6µm) dry.
- The minimum total thickness required is 2.0 mils (50.8µm) for adequate protection and appearance.

Theoretical Coverage



- With the recommended application the theoretical material usage is ±720 feet^2/gallon (17.7 m^2/liter) at a 1 mil thickness (24.5 µm).
- Actual coverage is dependent on many factors which may include the shape of the object, surface smoothness, application technique, and other application variables.

VOC / Regulatory Information

Product	VOC Pounds per Gallon	VOC Grams per Liter
• 4.0 Select Clearcoat (Ready to Spray)	– 4.0	– 476

- Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

4.0 Select Clearcoat

Product Storage

- Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures. Optimum storage temperature is approximately 70°F (21°C). Avoid too much temperature fluctuation. The maximum temperature range for storage is 40°F – 95°F (5°C – 35°C).

- 4.0 Select Clearcoat – 2 Years
- 4.0 Select Activator – Fast, Medium, or Slow – 1 Year
- 997 Enhancer – 1 Year
- 998 Accelerator – 1 Year
- LV Flex Additive – 1 Year
- T890 Flattening Agent – 2 Years

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