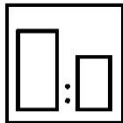
	North America	Technical Data Sheet	
	<h1>4.0 Select Clearcoat</h1>		Clearcoat
			12/12/2016
FOR PROFESSIONAL USE ONLY			

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 lbs/gal.



Use suitable respiratory protection
AkzoNobel recommends the use of a fresh air supply respirator



4	4.0 Select Clearcoat
1	4.0 Select Activator - Fast, Medium or Slow



Use AkzoNobel Measuring Stick

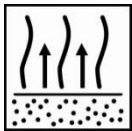
109



Spray gun setup:		Check gun manufacture specification	
RP – Pressure Feed	0.8 – 1.4mm	30 – 36psi	12 – 16 oz/min
RP – Gravity Feed	1.3 – 1.4mm	30 – 35psi	
HVLP – Pressure	1.0 – 1.2mm	Max 10psi (cap)	12 – 16 oz/min
HVLP – Gravity Feed	1.4 – 1.5mm	Max 10psi (cap)	



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




Between coats
5 minutes at 70°F (21°C)

Final flash before bake
5 minutes at 70°F (21°C)



Dust free	70°F (21°C)	140°F (60°C)
Dry to handle	45 min	N.A.
	15 hrs	45 min

Read complete TDS for detailed product information

	North America	Technical Data Sheet
	<h1>4.0 Select Clearcoat</h1>	
FOR PROFESSIONAL USE ONLY		

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 lbs/gal.

Suitable Surfaces

Existing finishes in the case of spot or blend repair, degrease and sand with #P800 to #P1000 DA Properly degrease substrate prior to sanding with either AutoPrep Ultra Prep or R859 wax and grease remover.

Product and Additives

Product	4.0 Select Clearcoat	Item #399115		
Hardener	4.0 Select Fast Activator	Item #399097	Spot and panel repair. Edging in parts	Up to 85°F (30°C)
	4.0 Select Medium Activator	Item #399098	Large areas and overall refinishing	70°F (21°C) - 85°F (30°C)
	4.0 Select Slow Activator	Item #399099	Large areas and overall refinishing	80°F (27°C) - 95°F (35°C)
Additives	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 substrate application	
	B91 Reducer SRA	Item #510324	Special solvent to dissolve fade out areas of spot repairs	

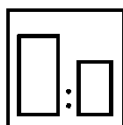
Basic Raw Material

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

Product Characteristics

WPG (a-component)	8.0 +/- 0.2 lbs/gal	Gloss	High
Volume Solids (RTS)	45 +/- 2%	Color	Clear
Theoretical Coverage	720 ft ² /gal @ 1mil – 100%TE		
Pot Life @ 70°F (21°C)	No additives	998 Accelerator	
Fast Activator	2 hrs	1 hr	
Medium Activator	3 hrs	1 ½ hrs	
Slow Activator	3 hrs	2 hrs	

Mixing



Standard mix ratio (by volume)
 4 4.0 Select Clearcoat
 1 4.0 Select Activator – Fast, Medium or Slow

Flexible Plastic Parts mix ratio (by volume)
 100 4.0 Select Clearcoat
 15 LV Flex Additive

Then mix (by volume)

- 4 4.0 Select Clearcoat (Flexed)
- 1 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 to speed up cure times

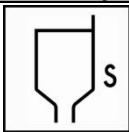
4.0 Select Clear Flexed should be used in combination with flexed primers, sealers and topcoats

T890 Flattening agent can be used to reduce the gloss units (GU) of the 4.0 Select Clearcoat. Add T890 after activating the 4.0 Select Clearcoat using the below table to achieve the desired gloss level. A spray out should be done first to determine desired gloss.

Gloss Level	% of T890 Flattening
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%

Use AkzoNobel Measuring Stick #109. Mix thoroughly.

Viscosity



4.0 Select Clearcoat	23 – 32 sec	EZ ZAHN #2 at 70°F (21°C)
	14 – 20 sec	DIN #4 at 70°F (21°C)

Viscosities are reported as Ready to Spray

Spray gun set-up / application pressure



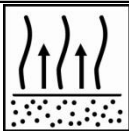
RP – Pressure Feed	0.8 – 1.4mm	30 – 36psi	12 – 16 oz/min
RP – Gravity Feed	1.3 – 1.4mm	30 – 35psi	
HVLP – Pressure	1.0 – 1.2mm	Max 10psi (caps)	12 – 16 oz/min
HVLP – Gravity Feed	1.4 – 1.5mm	Max 10psi (caps)	

Application



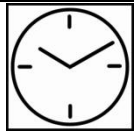
Apply two (2) to three (3) wet flowing coats

Flash off



- 5 minutes at 70°F (21°C) between coats
- 5 minutes at 70°F (21°C) final flash before bake

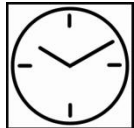
Dry times



4.0 Select Activator Fast

Dust Free
Dry to handle

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



4.0 Select Activator Med

Dust Free
Dry to handle

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



4.0 Select Activator Slow

Dust Free
Dry to handle

No Additives		½ oz 998 Accelerator per gal	
		70°F (21°C)	140°F (60°C)
2 hrs	N.A.	12 min	N.A.
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

Dry Film Thickness

2.0 – 2.5 mils

Apply 1.2 - 1.4 mils per coat

Polishing



Dust and minor damage can be polished out after stated dry times. If baking, allow cool down of the object to ambient temperature.
 - Carefully de-nib out dust particles with #P1500 then #P2000 grit paper. Clean and dry the surface to be polished
 - Mechanically polish area using quality rubbing compounds followed by polishing glaze

Recoatability


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

Striping or lettering on 4.0 Select Clearcoat must be applied within 24 hours for good adhesion. Sanding becomes necessary after 24 hours.

Decals can be applied after 48 hours 70°F (21°C)

Cleaning of equipment

Clean equipment with extra strong cleaning solvents

	North America	Technical Data Sheet	
	4.0 Select Clearcoat		Clearcoat
			12/12/2016
	FOR PROFESSIONAL USE ONLY		

VOC		
4.0 Select Clearcoat	4.0 lb/gal	476 g/l
VOC is ready to spray at a mix ratio of 4:1		

Product Storage and Shelf Life	
Store products unopened and used products with closed lids. Store products between 70°F-95°F (21°C-35°C). Optimal storage temperature is 77°F (25°C). Avoid extreme temperature fluctuation when storing.	
4.0 Select Clearcoat	2 years
4.0 Select Activator – Fast, Medium or Slow	1 year
998 Accelerator	1 year
LV Flex Additive	1 year
T890 Flattening Agent	2 year

FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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