

# Excel Crystal Clearcoat 820

## Surface Preparation

Mask all adjacent areas to prevent overspray problems. Allow basecoat sufficient dry times. Over OEM use a gray scuff pad.

## Mixing Ratio

Mix the components in the order and ratio indicated

**4 : 1**

## Mixing Ratio

Excel Crystal Clearcoat	4 Parts
Activator (811/812/813/814)	1 Part
Mixed VOC Ready to Spray	3.5 lb/gal

## Pot Life

Pot Life of activated clear is approximately 4-6 hours at 72° F mixed 4:1

## Basecoats

Various basecoat color systems. Be sure to allow correct flash times for best results.

## Gun Set-Up

1.3mm-1.5mm for conventional and HVLP guns.  
50-60 psi at the gun for Conventional guns.  
Use mfr. recommended pressure with HVLP.

## Clean Up

Clean equipment immediately after use with Excel Urethane Grade reducer or Excel 99/100 Virgin Lacquer Thinner. Do not leave activated material in the spray gun longer than 3 hours.

## Safety & Handling

Read all directions and warnings before using this product.

## Application & Dry Times

Can be reduced up to 25% with urethane grade reducer (161/162/163). Some reduction may be necessary when using HVLP spray equipment. Only in 434 VOC National Rule Areas. Apply 2 full wet coats using recommended gun setup (see Gun-Set Up section). Note; clear will atomize better and lay flatter when using a gun with smaller fluid nozzle. Allow 15-20 minutes flash between coats. Blending: When blending be sure area is prepared with a gray scuff pad for blending clears or compounds for single stage colors and thoroughly cleaned with pre-cleaner (901), compound must be removed. Apply wet coat of clear several inches beyond painted area. Let flash 5 minutes. Apply second wet coat several inches beyond first coat. Reduce remainder of clear 100% with urethane grade reducer (161/162/163) Reverse blend reduced clear back into repaired area. Spray very lightly on clear edge only. Allow booth to purge 5 minutes after final coat. Bake at 140°F for 40 minutes. Allow at least one hour cool down before wet sanding. Using 813 or 814 activator will increase gloss level when baking (due to slower solvents of these activators). Wet sand with 1200 grit or finer. Sanding and buffing is much easier when done within 48 hours. Buff according to desired appearance after 10-12 hours dry.

