



EXCEL AUTOBODY PRODUCTS TECHNICAL DATA SHEET

84000-5
EURO 221 URETHANE CLEARCOAT
NATIONAL RULE

#84000-5 (5 LITERS) #84001-25 - FAST ACTIVATOR (2.5 LITERS)

#84002-25 - MEDIUM ACTIVATOR (2.5 LITERS) #84003-25 - SLOW ACTIVATOR (2.5 LITERS)

84000-5 is a high quality clear coat formulated with the latest European acrylic resin technology to give Superior gloss, flow, and durability compared to other Production Clearcoat. This clear coat has been formulated for use in the demanding conditions of today's production shops. Easy to use, great results all at an economical price.

- Exceptional Clarity for Better Color Match
- Superior Flow / Leveling
- High Gloss and DOI
- Ease Of Application
- Long Term Durability
- Economical

FEATURES:

- Exceptional clarity for better color match
- High gloss and DOI
- Thoroughly tested for long term durability

- Excellent flow and leveling
- Ease of application
- Easy buffing within 8-12 hours

RECOMMENDED SUBSTRATES:

- All basecoat systems
- Acrylic urethane enamel (after 8 hour dry)

- Polyurethane enamel (after 8 hour dry)
- Gel coat (must be properly prepared)

MIXING INSTRUCTIONS:

2 parts 84000-5 Clear to 1 part Activator

ACTIVATOR OPTIONS:

84001-25 Low Temp 84002-25 Medium Temp
84003-25 High Temp

APPLICATION INSTRUCTIONS:

1. Apply basecoat color per manufacturer's recommended procedures. Note: Allow polyurethane and acrylic enamel basecoat to dry at least 8 hours before applying clear.
2. Apply two wet coats of clear using 50-60 PSI at gun, conventional spray 6-10 PSI at gun, HVLP.
3. Mix 84000-5 Clearcoat with appropriate activator as per instructions.
4. Allow 10-15 minutes flash between coats. Optional: On small jobs (i.e. fenders & doors) one tack coat can be applied, followed by one full wet coat with no flash between coats. Tack coat must be applied evenly.
5. Dry times:
 - Dust Free: 5-15 minutes depending on temperature and activator selection
 - Tack Free: 20-40 minutes depending on activator speed
 - Buff Time: Minimum 8-12 hours air dry
 - Force Dry: 10 minutes flash bake 30 minutes at 140 deg F
 - Delivery: 8-12 hours
6. Pot Life: Three Hours. Note: By using one ounce per paint cup of Accelerator, buff time and delivery time can be substantially reduced. Accelerator should not be used when air temperature is above 80 deg F.

BUFFABILITY: 84000-5 Clearcoat can be wet sanded and buffed after 8-12 hours. 84000-5 should be buffed within 36 hours for best results. Film thickness, flash times, and temperature will effect buffing times.

CLEANING: Use good quality lacquer thinner to thoroughly clean all equipment. Do not leave catalyzed clear in gun longer than 3 hours. Clean equipment immediately when using Accelerator.

TECHNICAL DATA:

Color: Water Clear
Pot Life: 3 hours @ 75 deg F
Coverage 1 mil.: 620 sq. ft.
Mix Ratio: 2:1 (4.2 V.O.C.)
Sprayable Viscosity: 17-19 sec. #2 Zahn

Flash Point : < 0 deg F TCC
Recommended Film Build: 2 – 2.5 mil DFT
Gloss: 96 Plus
Weight Solids: 39%
V.O.C.: RTS < 4.2 lbs./gal.

