



Production Clear

2.1 VOC

Product Numbers:

2100-1 Production Clear (gallon)

2100-4 Production Clear (quart)

2101-4 Fast Activator (quart)

2102-6 Medium Activator (half pint)

2102-4 Medium Activator (quart)

2103-4 Slow Activator (quart)

2104-4 Very Slow Activator (quart)

Our 2.1 VOC Production Clear has excellent long-term UV holdout with high gloss and its new resin system requires only low temperature, low time baking cycles which can lower your energy costs. Is water-like in color so will not affect white blend jobs and may be used for spot repairs and all-overs alike. May be used over any basecoat after proper flash times. May be used over catalyzed enamels or polyurethane coatings after a minimum of 8 hours but preferably overnight.

Mixing: 4:1

Mix 4 parts Production Clear to 1 part activator.

900-4 Polar Accelerator may be added at 1-2oz per mixed quart of clear.

925-4 Urethane Retarder may be added at 1-3oz per mixed quart of clear. Up to 50 % can be added for the last coat or flow coat.

Spraying: Gun tip recommendation 1.3 – 1.5

The best way to spray this clear is to adjust your gun so you lay the clear the way you want it to look. **Spray one wet coat.** If you are doing an all-over and it's hot you may spray 2 wet coats back-to-back if you desire. If you are spraying only a couple panels, spray your first coat then wait 10-30 minutes before applying your second coat.

Flash Times:

Our Production Clear is 2 clears in 1 can. With the slow activator the first coat will flash in 5-10 minutes depending on air and substrate temperature. Medium activator makes this clear dry like an MS clear for those smaller jobs. Regardless of activator it maintains its 2.1 VOC properties and solids, so you have the best of both worlds. Fast activator is perfect below 70 degrees.

Baking: Low Temperature Baking Clear



No Purge! Bake for 10-15 minutes at 110-120 degrees. This obviously depends on air temperature and activator used. **Never bake this clear over 120 degrees!**

Repairing:

After 4 hours at 70 degrees or better you should be able to make repairs without any problems. If the clear was baked, repairs should be made 60 minutes after the vehicle has cooled to room temperature.

Buffing:

Always let it set overnight before buffing. Production Clear will buff best in the first 3 days but will still buff good for the next 7 days.

Spraying in Non-Baking Paint Booths:

The booth fan **MUST** be shut off within one minute after the overspray is gone!

DO NOT spray this clear until all precautions have been read!

1. Never add any fisheye eliminators to this clear.
2. Clear can be accelerated but **only** with **SPI 900-4**.
3. We do not recommend ceramic coatings over any SPI product due to the extensive range of available products and lack of long-term testing.
4. Bake at temperature and cycles **not higher** than 120 degrees for 10 minutes or 110 degrees for 15 minutes. **No purge time is needed** before bake cycles.
5. If allowing to air dry the **fan must be shut** off within one minute after the overspray has been evacuated from the last coat of clear.
6. The mixed **pot life** will be about 2-3 hours depending on the temperature in the shop.
7. **First coat must be sprayed** how you want the clear to look the next day therefore **never** spray a tack/dust/drop coat. The exception is over unstable metallics, then the first coat should be a drop coat/tack coat.
8. Reduce the clear however it works best for you but if you choose to add excess reducer to the mixed product it is very important there is **at least 2 mils of clear** left after buffing is complete (assuming buffing is needed) for maximum UV protection. Testing is recommended.



9. Use only a pure carnauba wax or a fresh paint safe hand glaze. Only after 90 days of sunlight can a traditional wax be used.
10. If more than 2 coats are to be applied, **wait 30 minutes** between every coat of clear.
11. Remove any internal gun strainers, filters, disposal cup screens.