

PRODUCT PROFILE

PRODUCT NAME: 6400 Simply Clear®

DESCRIPTION: 6400 Simply Clear® is an easy to use 4:1 mixing ratio Clear. It provides a high quality finish with excellent gloss, leveling, and flow characteristics. An excellent value without sacrificing quality.

INSTRUCTIONS

Applying Basecoat

- Apply in accordance with manufacturer's instructions
- Permit the basecoat to fully dry prior to applying clear
- Remove surface contaminants with tack cloth prior to applying clear

Mixing & Applying Clearcoat

- Thoroughly mix four parts of 6400 with one part of 641 series hardener
- Set gun pressures according to Gun Set-up directions
- Apply one medium coat followed by one full wet coat allowing 3 to 5 minute flash time between coats
- For best results, an additional full wet coat may be applied following a 5 minute flash time
- Keep spray gun 6 – 10 inches from surface, adjust speed of travel to apply wet coat with each pass, overlapping approximately 50%

Note: air may be entrapped if the distance between the gun and surface is too close or gun travel is too slow

Buffing

- Force dry - follow Bake directions before wet sanding/buffing.
- Air dry - for best results cure for at least two hours before buffing.
- 6400 can be wet sanded in as little as four hours at 75° F

Note: cure time may vary with film thickness and temperature

BASIC INFORMATION

GENERAL TECHNICAL DATA

Appearance	Clear Liquid
Viscosity, RTS	19 seconds #2 Zahn
Shelf Life	One Year (unopened)
RTS VOC	4.0 lbs/gal (480 g/L)
RTS Solids by Weight	27%
Pot Life	4 hours @ 75° F

Product size

Clearcoat	6400	Gallon or quart can
Hardeners	641 Fast	Quart or half pint can
	642 Medium	Quart or half pint can
	643 Slow	Quart or half pint can

BASECOATS/SUBSTRATES

6400 Clearcoat is compatible with most high quality basecoats.
Refer to basecoat manufacturing technical data sheets.
(If not sure of compatibility, test first in an inconspicuous area)
Recommended substrate temperature: 70° – 80° F (21° – 27° C)

GUN SET-UP

	TIP	Air Pressure	
HVLP	1.2 – 1.3	8 – 10 psi	(at aircap)
Conventional	1.3 – 1.4 mm	40 – 50 psi	(at gun)

FLASH & DRY TIMES

Flash Time between coats at 75°F 3 to 5 minutes
Dust Free Time at 75°F 30 minutes

BAKE

Allow five minute flash time before force drying
Bake for 30 minutes at 140° F
Cool for 2 hours after force drying before wet sanding

RECOATING

Recoat after 12 hours air dry at 75° F
or
Recoat after 2 hours cool down after force drying

GUN CLEAN-UP

Clean equipment with a high quality lacquer thinner immediately after spraying

ADDITIVES

FISH EYE – The use of fish eye eliminator discouraged because it can impact the flow and leveling of the clearcoat

ACCELERATOR – The use of additional catalysts is not recommended as it can cause solvent popping and/or loss of gloss

TECHNICAL INFO

For additional technical information call 314-605-1697 or 800-TCI-4999

TO PROTECT AGAINST HARMFUL VAPOR & SPRAY WEAR A POSITIVE - PRESSURE SUPPLIED AIR RESPIRATOR (NIOSH APPROVED), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING AND SPRAYING. FOLLOW MSDS FOR APPROPRIATE SAFETY AND HEALTH INSTRUCTIONS

DISCLAIMER: The information contained on this Technical Data Sheet is intended to assist you in product application. It is based on knowledge of general industry use, experience & research. Since conditions of storage, handling, and product use are not under our control, buyers must assume responsibility for suitability of the product for their specific purposes.

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