

## 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

<b>Appearance</b>	Clear Liquid
<b>Viscosity, RTS</b>	19 seconds #2 Zahn
<b>Shelf Life</b>	One Year (unopened)
<b>RTS VOC</b>	4.0 lbs/gal (480 g/L)
<b>RTS Solids by Weight</b>	27%
<b>Pot Life</b>	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**

	<b>TIP</b>	<b>Air Pressure</b>	
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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