

535
4.4 VOC



#535 PRODUCTION CLEARCOAT & ACTIVATORS (FAST/MED/SLOW) - 4.4 VOC

PRODUCT DESCRIPTION:

ADVANTAGE #535 is a medium solids clearcoat that is easy to spray providing excellent flowout, gloss, and DOI. With three activators to choose from it offers versatility in most shop conditions and temperatures. #535 can be used for partial or complete paint jobs in need of a high quality, durable finish.

PRODUCTS:

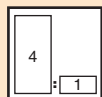
535-1 Clearcoat 4.4 VOC - Gallon **536-4** Activator 4.4 VOC Fast - Quart **537-4** Activator 4.4 VOC Med - Quart
538-4 Activator 4.4 VOC Slow - Quart

SURFACE PREPARATION:



Apply Undercoats and Basecoat per manufacturer's instruction. Over OEM or completely cured previously painted substrates scuff with a gray scuff pad or 600 grit then wipe clean with Final Wipe - Wax & Grease Remover. Allow basecoat adequate flash time (follow manufacturer's recommendation) Follow basecoat manufacturer's recommendation for recoat intervals.

MIXING DIRECTIONS:



Mix 4 parts #535 clear with 1 part #536, #537, or #538 activator by volume. Activator selection should be based on the size of the part to be painted and the temperature of both the air and part at time of painting.

APPLICATION DIRECTIONS:



Number of Coats: 3-4
Application Density: Medium-wet to wet
Overlap: 50%
Flash: Follow recommendations in "Dry Time" section
Application Conditions: Minimum Temp - 50°F (Substrate Temp.)
Max Temp - 100°F (Substrate Temp.)
Ambient Humidity - Less than 80% preferred



ADDITIVES:

ACCELERATOR: N/A
FLEX ADDITIVE: Not required

FISHEYE: N/A
Note: Do not spray when surface temperature is below 50°F.

SUBSTRATES:

Commercially available acrylic/cab basecoats with a VOC less than 6.6 lbs/gal.
Properly prepared previously painted substrates

GUN SETUPS:

AIR PRESSURES

CONVENTIONAL

Gravity Feed: 1.3 mm - 1.5 mm
Siphon Feed: 1.6 mm - 1.8 mm
HVLP: 1.3 mm - 1.6 mm

CONVENTIONAL @ Gun

Gravity Feed:
Siphon Feed:
HVLP @ Cap:



PANEL

35-40 psi
35-45 psi
6-8 psi

OVERALL

45 psi
45-50 psi
9-10 psi





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FLASH/DRY TIMES:

	536 @ or above 77°F	537 @ or above 85°F	538 @ or above 95°F
Flash Between Coats	5-10 min	5-10 min	5-10 min
Dust Free	10-15 min	10-15 min	10-15 min
Sand/Polish	4-6 hours	6-8 hours	8-10 hours
Force Dry (Convection Heat)	#536	#537	#538
Purge time before applying heat	20 min	20 min	20 min
Force Dry Time	20 min @ 165°F	25 min @ 165°F	30 min @ 165°F
Sand and Buff	After Cool Down	After Cool Down	After Cool Down

CLEAN-UP & STORAGE:

Clean spray equipment immediately after use with Acrylic Lacquer Thinner or Urethane Reducer. Do not leave material in spray gun.

PRODUCT PHOTO & TECHNICAL DATA:



Mix Ratio:	4 parts clearcoat: 1 part activator
Viscosity (RTS):	17-19 seconds #2 Zahn
Volume Solids (RTS):	29%
Film Build:	0.8 - 1.0 mils per full wet coat
Coverage:	465 sq. ft. per gallon @ 1 dry mil
Disposal/Safety:	See MSDS for this product
Humidity Resistance:	Excellent
Salt Spray Resistance:	Excellent



SAFETY INFORMATION - FOR PROFESSIONAL/INDUSTRY USE ONLY:

DANGER! DANGER! FLAMMABLE! HARMFUL IF INHALED - MAY AFFECT THE BRAIN OR NERVOUS SYSTEM, CAUSING DIZZINESS, HEADACHE OR NAUSEA. IRRITATES EYES, SKIN AND RESPIRATORY TRACT. Contents are FLAMMABLE. Vapors may cause flash fires. Keep away from heat, sparks, and open flame. During use and until all vapors are gone: Keep area ventilated - Do not smoke - Extinguish all flames, pilot lights, and heaters - Turn off stoves, electric tools and appliances, and any other sources of ignition. SEE CONTENTS STATEMENT ELSEWHERE ON LABEL. VAPOR HARMFUL. Use only with adequate ventilation. This product must be used with an appropriate catalyst. Follow the respirator requirement and instructions on the catalyst. Avoid contact with eyes and skin. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage. **FIRST AID: If INHALED:** If affected, remove from exposure. Restore breathing, Keep warm and quiet. If on SKIN: Wash affected area thoroughly with soap and water. Remove contaminated clothing. Launder before re-use. If in EYES: Flush eyes with large amounts of water for 15 minutes. Get medical attention. If SWALLOWED: Get medical attention immediately. **DELAYED EFFECTS FROM LONG TERM OVEREXPOSURE.** Contains solvents which can cause permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal. This product must be mixed with other components before use. Before opening the packages, **READ AND FOLLOW WARNING LABELS ON ALL COMPONENTS. DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN. FOR PROFESSIONAL USE ONLY. SEE MATERIAL SAFETY DATA SHEET.** Prop 65 Statement: **WARNING:** This product contains a chemical known to the state of California to cause cancer, birth defects or other reproductive harm. Contents: acrylic polyol/polymer/resin (Trade Secret), ACETONE 67-64-1, methyl n-amyl ketone 110-43-0, XYLENES 1330-20-7, n-BUTYL ACETATE 123-86-4, ETHYL BENZENE 100-41-4, STYRENE MONOMER 100-42-5, 2-(2-hydroxy-3,5-di-(tert)-amylphenyl)benzotriazole 25973-55-1. **Manufacturer's Exclusive Limited Warranty:** For Industrial use only by professional, trained personal using proper safety protective equipment. Not for sale to, or use by, the general public. Manufacturer warrants that its products are free from defect in material and workmanship at the time of sale. In the event that any product is proved by objective testing and analysis to have been defective at the time of sale, upon the return of the defective product, the manufacturer shall replace the product at no cost, excluding the shipping costs, as the exclusive remedy. This warranty does not cover damage caused by accident, misuse, improper application, improper combination of products or tampering. **ALL IMPLIED WARRANTIES WHETHER IT BE OF MERCHANTABILITY AND/OR FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. THIS WARRANTY EXCLUDES ALL INCIDENTAL AND CONSEQUENTIAL DAMAGES.**

KEEP OUT OF REACH OF CHILDREN. REFER TO MATERIAL SAFETY DATA SHEET. EMERGENCY MEDICAL & SPILL CONTROL CHEMTREC (800) 424-9300

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