

Super Express Clearcoat 2.1 V.O.C. PF 640C, PF 640-2C

Medium solids acrylic urethane clearcoat for higher shop production. This product is an excellent choice when speed and production are required without sacrificing gloss and premium finish. It provides excellent flow, leveling and UV protective properties. Can be sprayed in 1 heavy coat or 2 regular coats and polished in 1 hour. Will perform with water based and solvent based basecoat systems.

CLEAR

PF 640C Clear U.S. Gallon (3.79 L)

PF 640-2C Clear U.S. Quart (946 ml)

ACTIVATOR:

PF 641C U.S. Quart (946 ml)

PF 641CS Slow U.S. Quart (946 ml)

PF 641-2C 0.5 U.S. Pint (236 ml)

PF 641-2CS Slow 0.5 U.S. Pint (236 ml)

**ALWAYS REFER TO MSDS PRIOR TO USING THIS PRODUCT
AND TAKE PROTECTIVE MEASURES TO ENSURE SAFE USE**

COMPATIBLE PREPARED SUBSTRATES:

- Automotive refinish basecoats (water and solvent based).
- Automotive refinish single stage (except acrylic lacquer).
- Existing finishes that have been sanded and cleaned.

Note: Clearcoat should not be applied over acrylic lacquers, or unsanded existing finishes.

SURFACE PREPARATION:

1. Apply basecoat per manufacturers' mixing and application instructions.
2. Allow sufficient flash time before applying clear. Inadequate flash time will affect the performance of this product.
3. Use a tack cloth to remove any surface contaminants that may have settled on the basecoat.
4. Apply clearcoat

- Please Note: Basecoat flash times could vary between basecoats. Inadequate flash times will affect the performance of the clear.

MIXING DIRECTIONS:**Clearcoat**

PF 640C

PF 640-2C

4 parts

Activator

PF 641C, PF 641-CS

PF 641-2C, PF 641-2CS

1 part

Stir thoroughly between each addition. Strain before spraying material.

Reduction: For best results, do not reduce.

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APPLICATION:

Apply 2 regular full wet coats or 1 heavy full wet coat to a maximum of 6 mils wet. Recommended film build is 1.0 to 1.5 mils per full dry coat. Do not apply over non catalyzed acrylic or synthetic enamels or acrylic lacquer finishes.

- Always keep containers tightly closed to prevent moisture contamination.

Caution: It is important to test the compatibility of this product with your paint system.

This product is not recommended for use in temperatures below 16°C (60°F). The use below these temperatures will affect dry times and performance.

SPRAY GUN AND PRESSURE:



GUN TYPE

Siphon Feed
Gravity Feed
HVLP

FLUID TIP

1.4-1.6mm
1.2-1.6mm
1.2-1.6mm

AIR PRESSURE

35-45 psi
25-40 psi
10 psi

POT LIFE:



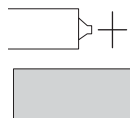
Activator

PF 641C, PF 641-2C
PF 641CS, PF 641-2CS

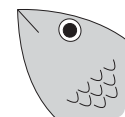
Time

25-35 minutes
30-45 minutes

ADDITIVES:



Accelerator: DO NOT USE!



Fish Eye: The use of fish eye eliminator is not recommended.

DRY & FLASH TIME @ 24°C (75°F):



	PF 641C/PF 641-2CPF	641CS/PF 641-2CS
Flash time	10-15 minutes	20-25 minutes
To sand	1-1.5 hours	2-2.5 hours
Buffing	1-1.5 hours	2-2.5 hours
To deliver	1-1.5 hours	2-2.5 hours
Tack free:	10-15 minutes	15-20 minutes

All drying times refer to shop temperature of 24°C (75°F) / 50% humidity. Allow additional drying time when optimal conditions are not reached.

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Force Drying At 60°C (140°F)

Purge Time 20 minutes

Bake Time at 60°C 20 minutes

Clearcoat may be wet sanded and buffed after 1 hour cool down time. Baking will increase gloss.

REPAIRING & RECOATING:

May be recoated anytime up to 24 hours. After 24 hours, clear must be sanded with 1200 to 1500 grit abrasive prior to recoating.

CLEAN UP

Clean with Gun Wash or PF 686C Acrylic Lacquer Thinner.

TECHNICAL DATA:

APPEARANCE:	Clear
RESIN TYPE:	Acrylic Urethane
FLASHPOINT:	-18°C (0°F)
REDUCTION:	Do not reduce
FLEX ADDITIVE:	Not required
VISCOSITY:	16 - 17 seconds #2 Zahn mixed
FILM BUILD:	maximum 6 mils wet 2-2.5 mils dry

PF 640C/PF 640-2C Clear	PF 641C/PF 641-2C	PF 641CS/PF641-2CS (Slow)
VOLUME SOLIDS (R.T.S.)	38.68%	37.60%
WEIGHT SOLIDS (R.T.S.)	47.00%	44.97%
COVERAGE @ 1 mil WET	620.36 sq ft	603.04 sq ft

V.O.C. (RTS):

	Regulatory VOC in lbs/gal	Regulatory VOC in G/L	Material VOC in LBS/GAL	Material VOC in G/L
PF 641C/PF 641-2C	2.1	250	2.03	243.25
PF 641CS/PF 641-2CS (Slow)	2.1	250	2.05	245.65

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PRECAUTIONARY INFORMATION

Refer to product label and Safety Data Sheet for health and safety information before using this product.

SAFETY CONSIDERATION

Safety Data Sheets are available at www.proformproducts.com or upon request at info@proformproducts.com. These are provided to help our customers satisfy their own handling, safety and disposal needs, and those required by local applicable health and safety regulations. Our Safety data sheets are updated regularly, therefore, please review the most current Safety Data Sheet before handling or using any product.

TECHNICAL INFORMATION:

The technical information, recommendations and other statements contained in this document are based upon tests or experience that Pro Form believes are reliable, but the accuracy or completeness of such information is not guaranteed.

PRODUCT USE:

Many factors beyond Pro Form's control and uniquely within user's knowledge and control can affect the use and performance of a Pro Form product in a particular application. Given the variety of factors that can affect the use and performance of a Pro Form product, user is solely responsible for evaluating the Pro Form product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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