



Technical Data Sheet

KEY740 KEY EURO CLEAR

DESCRIPTION:

Key Euro Clear is an economical 2:1 mix acrylic urethane clearcoat designed for universal use. This clear is a mid-solids clear that works well in air dry or baking applications. Excellent gloss and durability.

TECHNICAL PRODUCT INFORMATION:

- Key Euro Clear – (solids = 49%)
 - Fast Activator – KEY746 (solids = 53%)
 - Medium Activator – KEY747 (solids = 52.6%)
 - Slow Activator – KEY748 (solids = 54%)
 - Ex-Slow Activator – KEY749 (solids = 55%)
 - Pot Life: 5 hours @ 75°F
 - Shelf Life: One Year (unopened)
 - V.O.C.: 4.02 Lb/gal (482 g/l)
- (Refer to MSDS for proper handling of products listed on this product sheet)*

MIX RATIO

- 2 Parts - KEY EURO CLEAR
- 1 Part - CLEARCOAT ACTIVATOR
- 10 % - URETHANE GRADE REDUCER (optional)

BASECOAT

All Acrylic and Polyester Basecoat Color Systems

GUN SETUP

- Conventional Gravity - 1.3mm-1.6mm 45-50 psi @ spray gun
- Siphon - 1.4mm-1.8mm 45-50 psi @ spray gun
- HVLP - 1.3mm-1.6mm 8-10 psi @ spray gun

APPLICATION

Apply 2 full wet coats

DRY TIMES

AIR DRY

Flash between coats:	5 – 10 minutes	@ 70°F
Dust free:	10 minutes	@ 70°F
Air dry:	6 – 10 hours	@ 70°F

EXPRESS DRY

Flash Between Coats:	5-10 minutes	
Flash Before Force Dry:	5 minutes	
Cycle Time:	15-20 minutes	@ 140° F

BLENDING

- Carefully taper second coat of clear beyond the first.
- After the final coat of clear, step out the coating by mixing 1 part KEY80/81/82/or 83 to 1 part of remaining clear and taper the blend with the resulting mixture.
- After the final coat of clear has been blended with the mixture of Reducer and Clear, use straight reducer of choice to finish blending the area (fast is usually the best choice).

RECOATABILITY / REPAIR

Clearcoat may be recoated for repair. After cool down when baked. Air dry repair next day. If recoating after 24 hours scuff with 1200-1500 grit paper.

SANDING, COMPOUNDING, POLISHING

- **OPTIMUM TIMES**
Express Dry: 3-4 hours
Air Dry: 6-8 hours
- **SANDING**
For dirt removal, lightly nib sand with 1500 grit wet paper and compound. For best results compound within 24 hours of application.
- **COMPOUNDING**
Using a finishing compound apply a thin ribbon of material to area to be polished. Use a foam polishing pad. Maintain buffer speed at 1800-3000 rpm. Remove excess compound with clean soft cloth before applying polish.
- **POLISHING**
Using a finishing polish and foam polishing pad apply a ribbon of material to work a 2-3 foot square area. Maintain buffer speed at 1200-1800 rpm. Keep buffer moving at all times overlapping approximately 50% each pass. Wipe off excess polish with clean soft cloth. Hand buff with clean soft cloth as a finishing touch.