



TECHNICAL DATASHEET

BULLET CLEAR 4:1 (2.1 VOC)

ART. NO: # 190.101 (1G) & # 190.102 (1Qt.)

BULLET CLEAR 4:1 (2.1 VOC) is a high production clear coat system developed for spot repair and one panel repair. This 4:1 mix clear coat is a 3 coat system that can be sanded and buffed in one hour and air dried or baked dry in only 15 minutes at 140°F (60°C).

FEATURES

- ✓ Super fast dry-to-sand time
- ✓ Excellent for spot repairs
- ✓ Superb blending
- ✓ Fast bake cycle with no purge time
- ✓ Saves fuel cost
- ✓ Excellent gloss
- ✓ Can be applied to flexible parts
- ✓ Excellent system for jams and cut-it parts
- ✓ Guaranteed performance

COMPATIBLE SURFACES

- ✓ Water & Solvent base coats
- ✓ Activated polyurethane enamel (must be cured at least 8 hours)
- ✓ Activated acrylic urethane enamel (must be cured at least 8 hours)
- ✓ OEM clear coats (must be sanded with P800)

CONDITIONS OF USE AND CONFORMITY

The before mentioned technical data and information, especially the recommendations for applying and using our products, are based on our current knowledge and experience when applied under normal conditions. In practice, the materials, surfaces or site conditions are so different that no warranty regarding the working results or liability, arising out of any relationship, can be inferred neither from this information nor from a verbal consultation, except we are charged with intent or gross negligence. In this case the user is obliged to prove that he has informed us about all points required for a proper and promising judgment in writing, in time and completely. Patent rights of any third party are to be observed. Furthermore, our general sales and delivery Terms and Conditions and the latest Technical Data Sheet, which should be demanded, apply.

HEALTH & SAFETY

See Safety Data Sheet and labels for additional safety information and handling instructions. Directions for handling and waste disposal are in our Material Safety Data Sheet and the specifications of the Employers Liability Insurance Association for the chemical industry. Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS. Always observe all applicable precautions and follow good safety and hygiene practices.

Product (Part A) VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
	g/L	LBS/GAL
Actual VOC	120.10	1.00
Regulatory VOC <small>(less water & exempt solvents)</small>	297.17	2.48
Density	1018	8.50
	WEIGHT %	VOLUME %
Total Solid Content	30%	29%
Total Volatile Content	70%	71%
Water	0%	0%
Exempt Compound Content	58%	59%

Hardener (Part B) VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
	g/L	LBS/GAL
Actual VOC	63.34	0.53
Regulatory VOC <small>(less water & exempt solvents)</small>	110.38	0.92
Density	1162	9.70
	WEIGHT %	VOLUME %
Total Solid Content	46%	50%
Total Volatile Content	54%	50%
Water	0%	0%
Exempt Compound Content	49%	43%

RTS VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
Coating Category	Clear Coating	
Mixing Ratio	4:1	
	g/L	LBS/GAL
Actual VOC	108.75	0.91
Regulatory VOC <small>(less water & exempt solvents)</small>	249.00	2.08
Density	1046.80	8.74
	WEIGHT %	VOLUME %
Total Solid Content	33%	33.2%
Total Volatile Content	67%	67%
Water	0%	0%
Exempt Compound Content	56%	56%

PRODUCT DATA

Dry Film Thickness / coat (DFT): 1.0

Coverage: 450 Sq. Ft. / gal @ 1 mil*

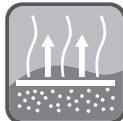
Shelf Life: 24 months

Package: 1 Gallon or 1 Quart

Number per case: 4(G) or 12(QT)

Safety Data Sheet (SDS) is available on our website

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HANDLING

MIXING

Make sure product is at room temperature 70°F (20°C) before mixing

4 Parts Clear: # 190.101 (1G)
190.102 (1QT)

1 Part Activator: # 191.101 (1QT)

POT LIFE

30 - 45 minutes

GUN SETUP

Conventional Gravity: 1.3mm - 1.4mm 40 - 45 psi @ gun

Siphon: 1.3mm - 1.4mm 40 - 45 psi @ gun

HVLP Gravity: 1.3mm - 1.4mm 8 - 10 psi @ gun

Mini-Jet Gravity Fed: 1.0mm -1.3mm 8 - 10 psi @ gun

Fluid Adjustment for 1.3 mm nozzle: Turn out 3 full turns

Fluid Adjustment for 1.4 mm nozzle: Turn out 2 ½ turns

APPLICATION

1. Apply basecoat color per recommended procedures
2. Apply 3 medium wet coats wet-on-wet with no flash time

N.B. It is recommended to clean out the spray gun immediately after use

BLENDING

1. Apply first coat of clear coat
2. Extend second coat of clear past first coat
3. Extend third coat of clear past second coat
4. After the final coat of clear melt in the edge by applying a blending solvent

FLASH TIME

Between coats: Wet-on-wet

Before force dry: 5 minutes

DRY TIMES

Dust Free: 2 minutes depending on temperature and activator selection

Force Dry: 15 minutes @ 140°F (60°C)

Air Dry: 1 hour @ 90°F or 2 hours @ 70°F

Time to decal: 24 hours

Time to deliver: 1 hour air dry or after cool down when forced dry

SANDING & BUFFING

Optimum Times: **Force Dry:** After cool down

Air Dry: 1 hour

Sanding:

Use 1500 grit or finer wet sandpaper or use a foam interface pad with P1500 grit or finer DA paper.

Polishing:

Using polishing foam pad apply a ribbon of material to work a 2-3 foot square area. Maintain buffer speed at 1500-2200 rpm. Keep buffer moving at all times overlapping approximately 50% each pass. Wipe off excess compound with clean soft cloth. Hand buff with clean soft cloth as a finishing touch.