

# HS Clear

**3:1**

## **Product Numbers:**

#3000-1 HS Clear – ¾ Gallon

#3001-4 Activator Normal – Quart

**Gun Tip: 1.4 or 1.5**

## **Mixing:**

3:1

Mix 3 parts of #3000 to 1 part of activator

## **Uses:**

SPI's HS is water-like in color so it will not affect white blend job and it can be used over any quality base coat system when proper flash times are followed. It can also be used over catalyzed enamels and polyurethanes that have been allowed to cure at least 4 hours. HS clear with its two activators is suitable for panel, multi panel, all-overs and custom work.

HS Clear has excellent UV holdout and HS Clear may be sprayed over catalyzed enamels or polyurethanes after a minimum of four hours or overnight. Note: it is always best to let it dry over night to be safe.

## **Drying Times:**

The first coat will flash in 5-15 minutes depending on temperature.

## **Cutting in parts:**

If cutting in underside of hoods, deck lids or doors we recommend adding 2-4oz of SPI **Polar Accelerator** year around so when panel is flipped to be worked on marks are not left in clear

## **Spraying:**

Option #1: The best way to spray this clear is adjust the paint gun so you can lay the clear how you want it to look. Spray one wet coat. Then after waiting 15-30 minutes apply your second coat. Wait 30 minutes for each additional coat.

**Always spray with a 1.4 tip or 1.5! Never use a 1.3.**

**Custom Painting:**

Spray two or three coats of clear and let it dry over night. Wet sand any imperfections with 600 grit or finer or 800 grit DA. If the rest of the job does not need to be sanded, wash with #700-1 wax and grease remover then tack off and shoot two more coats of clear. On customs jobs like this it is always better to use a waterborne wax and grease remover than a mineral sprit wax and grease remover. You are less likely to see sand scratch swelling by using the waterborne wax and grease remover. **Always spray with a 1.4 tip or 1.5! Never use a 1.3**

**Baking: Low temperature Baking Clear!**

No purge. Bake up to 110-120° for 10-20 minutes depending on activator. **NEVER bake higher than 120 degrees!**

**Hot Weather:**

For large allovers during high heat/humidity we recommend adding 2-4 oz of SPI's 885 or 895 Reducer in the last coat if the clear is drying too fast. If you add 885 or 895 to first coat you must allow extra flash time of 15-30 minutes in between coats.

**Cold Weather:**

Polar Accelerator #900-4 can be added at 1-2oz per quart in cool shops.

**Non-Baking Paint Booths:**

Shut off the booth fan as soon as the overspray clears after the last coat is applied.

**Repairing:**

After four hours at 70°, you should be able to make repairs with no problems. If the clear was baked, repairs can be done after 60 minutes of cooling.

**Buffing:**

Always let it set overnight. HS Clear will buff best in the first three days but still buffs good for next thirty days. Hint: First thing the next morning after spraying the car, wet sand with 1500 grit paper and pull it out in sun for a couple of hours. Pull the car back in the shop and let it set until the paint has cooled to room temperature.