



# Euro Clear 2020

## **Product Numbers:**

5000-1 Euro Clear (gallon)

5001-4 Fast Activator (quart)

5002-4 Medium Activator (quart)

5003-4 Slow Activator (quart)

This very high-grade clear can be made to do about anything the painter desires with a little creativity in choosing mixing ratios and proper grade reducers. With a little experimenting this clear can suit the needs of any collision shop doing anything from used car work to insurance work on a new Mercedes.

## **Mixing: 4:1:1 to 4:1:3**

Mix 4 parts Euro Clear to 1 part activator to 1 part reducer up to 3 parts SPI Reducer.

Though the ratio in which urethane reducer is added to this clear, the painter has complete control to create their own personalized clear based on what you want the solid contents to be, how you want the clear to spray and the speed in which you want the clear to dry.

Painters doing low end or used car work have the option to take the clear used for everyday production and reduce it up to 4:1:3 to significantly cut costs for that job without using a low grade clear.

900-4 Polar Accelerator may be added at 1-2oz per mixed quart of clear.

925-4 Urethane Retarder may be added at 1-3oz per mixed quart of clear. Up to 50 % can be added for the last coat or flow coat.

## **Spraying:** Gun tip recommendation 1.3 – 1.5

Use a gun with a 1.4 tip to spray the first wet coat, let it dry until you can lightly touch the clear then spray the second coat wet. Flash time is 10 minutes with 2 coats but if doing more than 2 coats allow 30 minutes flash time between coats.

## **Baking: Low temperature baking clear**

No Purge! Bake for 10-15 minutes at 110-120 degrees. This obviously depends on air temperature and activator used. This clear is water spot free after one hour when air dried at 75 degrees.

**Never bake this clear over 120 degrees!**



## **Spraying in Non-Baking Paint Booths:**

The booth fan **MUST** be shut off within one minute after the overspray is gone!

## **Repairing:**

After one hour of air drying, you should be able to make minor repairs without any problems. Keep in mind the type of base you use plays a big part in the curing of the clear and to be safe you should wait at least 4 hours to repair.

## **Buffing:**

Depending on the mix ratio and speed of reducer, buffing can be done in 2 hours to overnight. This clear should be buffed within 10 days when 70 degrees or higher for best results.

## **Reducing:**

Most high-grade urethane reducers will work fine in this clear, but SPI Reducers are recommended. **We strongly advise you to avoid using low-grade reducers in this clear.**

## **DO NOT spray this clear until all precautions have been read!**

1. Never add any fisheye eliminators to this clear.
2. Clear can be accelerated but **only** with **SPI 900-4**.
3. We do not recommend ceramic coatings over any SPI product due to the extensive range of available products and lack of long-term testing.
4. Bake at temperature and cycles **not higher** than 120 degrees for 10 minutes or 110 degrees for 15 minutes. **No purge time is needed** before bake cycles.
5. If allowing to air dry the **fan must be shut** off within one minute after the overspray has been evacuated from the last coat of clear.
6. The mixed **pot life** will be about 2-3 hours depending on the temperature in the shop.
7. **First coat must be sprayed** how you want the clear to look the next day therefore **never** spray a tack/dust/drop coat. The exception is over unstable metallics, then the first coat should be a drop coat/tack coat.
8. Reduce the clear however it works best for you but if you choose to add excess reducer to the mixed product it is very important there is **at least 2 mils of clear** left after buffing is complete (assuming buffing is needed) for maximum UV protection. Test is recommended.



9. Use only a pure carnauba wax or a fresh paint safe hand glaze. Only after 90 days of sunlight can a traditional wax be used.
10. If more than 2 coats are to be applied, **wait 30 minutes** between every coat of clear.
11. Remove any internal gun strainers, filters, disposal cup screens.