



# Speed Clear

2.1 VOC

## Product Numbers:

3100-1 Speed Clear (3/4 gallon)

3101-4 Fast Activator (quart)

3102-4 Medium Activator (quart)

3103-4 Slow Activator (quart)

SPI's Speed Clear is the newest addition to our clearcoat line. This clear is designed for refinishing five panels or less and is limited to two coats. If air dried, this clear can be buffed in 90 minutes which is perfect for any painter who wants to get work out same day.

## Mixing: 3:1

Mix 3 parts Speed Clear to 1 part activator.

900-4 Polar Accelerator and 925-4 Urethane Retarder may be added but not recommended.

Small amounts of high quality and VOC appropriate urethane reducer may be used but is not recommended.

Pot Life of this product is 30 minutes at 75 degrees.

Speed Clear has excellent flexibility, so flex additives are never required.

## Spraying: Gun tip recommendation 1.3 – 1.5

This clear is designed for refinishing five panels or less and is limited to two coats. The two coats of clear will provide enough mils for wet sanding and buffing (only if needed).

Spray one wet coat, while not letting it flash, apply a second wet coat then move on to your next panel.

After the second coat, turn the booth fan off after overspray has been evacuated.

## Dry Times:

Speed Clear can be air dried or baked. Air dries as fast as 90 minutes



## **Baking:**

No Purge! Bake for 10 minutes up to 140 degrees.

## **Repairing:**

After 90 minutes 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:**

Buffing can be done after cooling down if baked or as fast as 90 minutes if air dried.

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

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

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

1. Never add any fisheye eliminators to this clear.
2. We do not recommend ceramic coatings over any SPI product due to the extensive range of available products and lack of long-term testing.
3. Bake at temperature and cycles **not higher** than 140 degrees for 10 minutes. **No purge time is needed** before bake cycles.
4. 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.
5. The mixed **pot life** will be about 30 minutes depending on the temperature in the shop.
6. 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.
7. Remove any internal gun strainers, filters, disposal cup screens.