

DIAMOND FLEET COATING SYSTEMS

1:1 CLEAR URETHANE CLEARCOAT TECHNICAL DATA SHEET



PRODUCT FEATURES

- User friendly 1:1 mix ratio
- Exceptional flow and leveling
- High Gloss with excellent Distinction of Image (DOI)
- Outstanding hardness and durability

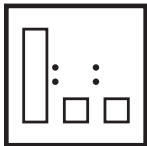
DESCRIPTION

Diamond Fleet 1:1 Clear is a high quality urethane clear with a very user friendly 1:1 mix ratio. It has wonderful long term durability, exceptional flow and leveling, and high gloss with excellent Distinction of Image (DOI). It is well suited to spot, panel or overall applications. Diamond Fleet 1:1 Clear can be applied wet on wet giving you increased cycle times and profitability.

AVAILABILITY

Clear (Part A)		Unit	Per Case
DF-650-2L	1:1 Clear	2.5L	6
Activator (Part B)		Unit	Per Case
DF-657-2L	1:1 CLEAR FAST ACTIVATOR	2.5L	6
DF-658-2L	1:1 CLEAR MED ACTIVATOR	2.5L	6
DF-659-2L	1:1 CLEAR SLOW ACTIVATOR	2.5L	6

MIX RATIO 1:1



1 Part DF-650-2L 1:1 Clear
 1 Part DF-657-2L 1:1 Clear Fast activator
 or DF-658-2L 1:1 Clear Med activator
 or DF-659-2L 1:1 Clear Slow activator

SURFACE PREPARATION



For use with Diamond Fleet Basecoats, allow basecoat to dry 30 to 45 minutes before clear coating. (Dry times are dependent of shop temperature and humidity). When using Diamond Fleet 1:1 Clear on other basecoats,

follow all procedures from your basecoat manufacturer for surface preparation, dry and recoat times. **DO NOT DEVIATE FROM THESE RECOMMENDATIONS.**

COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure.

SPRAY GUN SETUP



Follow the spray gun manufacturers recommendation for proper setup.

APPLICATION



Apply 2 to 3 full wet coats from a distance of 6 to 8 inches; allow coats to become hand slick (approx. 5 to 10 min) before applying the next coat. A Wet on Wet "Limited Flash" application can be used allowing 2-5 minutes flash between coats. Apply all coats within 1½ hours. If sanding and buffing, three coats of clear must be applied for long-term durability.

DRY TIMES AT 70°F



Pot Life:

4 Hours

Flash:

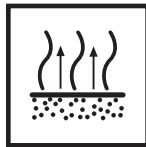
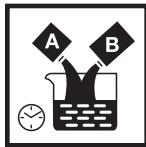
5-10 Minutes

Dust Free Time:

15 Minutes

Sand and Buff:

Overnight



FORCE DRY



Bake @ 140°F for 30 minutes. Use only the slow activator when force drying. Allow surface to cool down to room temperature before sanding and buffing.

TECHNICAL DATA

Weight Solids:	42%
Sprayable Viscosity:	14" to 16" #2 Zahn Cup
EPA VOC (RTS):	≤4.7 (lb/gal)
Actual VOC (RTS):	≤4.4 (lb/gal)
Dry Film Build:	2.2 to 2.5 mils
Gloss Units 20°/60°:	80+GU/90+GU
Theoretical Coverage:	576.7 sq ft @ 1mil (A+B)
Flash Point:	1° F
Humidity Resistance:	Excellent

GENERAL INFORMATION

- Always consider the following when choosing an activator: the size of the vehicle (is it a bus or a fender?), the temperature, humidity and air movement.
- Do not combine slow reducers with fast activators; this combination may cause solvent pop.

EQUIPMENT CLEANING

Clean equipment with an appropriate solvent. Refer to applicable Air Quality Management District requirements for proper use of equipment and solvents.

PRODUCT SAFETY INFORMATION



Before using any Axis product, be sure to read all safety directions and warnings. Wear properly fitted air purifying respirator, eye protection, gloves, and protective clothing during application and until all vapors and spray mists are exhausted. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. **FOR USE ONLY BY TRAINED PROFESSIONALS.** Not for sale to or use by the general public. For more information CONSULT SAFETY DATA SHEET.

OTHER INFORMATION

Moisture and humidity adversely affects clear coat products. Equipment should be clean and dry before use. Close containers immediately after use. Keep containers tightly sealed.