PAINT REFINISH FOR SCRATCH SHIELD

SERVICE INFORMATION

Scratch Shield is a new developed scratch-resistant clear coat which heal by itself when the vehicle gets the small scratch.

If the scratch reaches color base coat, it will not heal.

Image of small scratch is like a scratch that gets after going to washing machine.

Scratch Shield will be implemented for P53B model for the first time in US.

Authorized paint suppliers

Nissan is working with refinish paint vendors to develop approved materials and procedures for proper refinishing of vehicles with Scratch Shield.

To ensure proper color matching, adhesion, and long term wear characteristics, vehicles needing paint refinish work must be refinished with products that have been tested and approved by Nissan.

At the time of this publication, the following refinish paint manufacturers have provided materials and procedures, which meet Nissan requirements:

<table>
<thead>
<tr>
<th>Manufacture</th>
<th>Clear</th>
<th>Reducer</th>
<th>Hardener/Activator</th>
<th>Flex Additive</th>
</tr>
</thead>
<tbody>
<tr>
<td>DuPont</td>
<td>Chroma Premier Clear72500S</td>
<td>Chroma Premie 12375S Reducer</td>
<td>Chroma Premier 12303S Activator</td>
<td>Plas-Stick2350S Flexible Additive</td>
</tr>
<tr>
<td>Spies Hecker</td>
<td>Permasolid HS Diamond Clear Coat8450/HS Clear Coat8030</td>
<td>Permacron Reducer</td>
<td>Permasolid VHS Hardeners</td>
<td>Permasolid Elastic Additive 9050</td>
</tr>
<tr>
<td>Standox</td>
<td>Standocryl VOC Platinum Clear / 2KHS Clear</td>
<td>2K Thinners</td>
<td>Standox VOC Hardeners</td>
<td>Sandox 2K Plasticiser</td>
</tr>
<tr>
<td>PPG</td>
<td>D8126 CeramiClear™</td>
<td>—</td>
<td>D8226Hardner</td>
<td>—</td>
</tr>
<tr>
<td>Glasurit</td>
<td>923-45</td>
<td>352-91/-216</td>
<td>929-33/31</td>
<td>—</td>
</tr>
<tr>
<td>Sherwin Williams</td>
<td>SRC2 Clear coat R26,R28,US3-6 Reducers</td>
<td>—</td>
<td>UH20 Hardener</td>
<td>—</td>
</tr>
</tbody>
</table>
If your paint system supplier does not have Nissan-approved Scratch Shield refinish products, specific technical advice can be acquired from the local distributor of the paint suppliers listed on the previous page. If your paint supplier is not approved and you need to obtain refinish materials from one of the approved vendors, you will also need to purchase the necessary primers, reducers, hardeners and base coat from that distributor. Current refinish materials are designed to work as a system and products from different vendors should not be intermixed.

**SERVICE PROCEDURE**

When repairing a panel with the Scratch Shield refinish products, follow the guidelines below.

- Edge to edge refinish for clear coat is recommended.
- Acceptable blending could occur the area of sight (ex: rocker area); and the upper portion of the quarter panel sail area (junction of roof and quarter panel) as part of a full quarter panel refinish. And please conduct supplementary dry for the blending part before polishing.
- Please polish the refinished area by the recommended procedures of your paint supplier.

**Technical Information and Material Availability**

For specific technical advise, or if you have any difficulty obtaining refinish materials, the paint suppliers can be contacted directly at the following numbers.

<table>
<thead>
<tr>
<th>Refinish Vendor</th>
<th>Technical Assistance Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dupont</td>
<td>1·800·3DuPont</td>
</tr>
<tr>
<td>Dupont Canada</td>
<td>1·800·668·6945</td>
</tr>
<tr>
<td>Spies Hecker</td>
<td>1·800·44·SPIES</td>
</tr>
<tr>
<td>Standox</td>
<td>1·800·551·9296</td>
</tr>
<tr>
<td>PPG</td>
<td>1·800·647·6050</td>
</tr>
<tr>
<td>Glasurit</td>
<td>1·800·758·2273</td>
</tr>
<tr>
<td>Sherwin Williams</td>
<td>1·800·798·5872</td>
</tr>
</tbody>
</table>
I. DuPont Procedure

1. Substrate
   • Bare metal, sanded
   • Galvanised metal, sanded
   • Aluminum, sanded
   • Through-hardened sanded paintwork

2. Pretreatment/Cleaning
   • DuPont First Klean 3900S
     or Dupont Final Klean 3910S
     or Dupont Low VOC Final Klean 3909S
     or Dupont Pre-sol 3919S
     or Dupont 3939S
     or Dupont Kwik Clean 3949S
     or any Sontara Pre-Saturated cleaner wipes

3. Etch Primer
   • ChromaPremier 22860S Premier Etch Primer
     or ChromaPremier CF-22860S Premier Etch Primer

4. Primer Surfacer
   • ChromaPremier 32430S 2K Premier Primer

5. Topcoat
   • ChromaPremier Basecoat
     or Cromax Pro Basecoat
     with
     ChromaPremier Clear 72500S + 12.5% Plas-Stick 2350S
     Flexible Additive then 2:1 with ChromaPremier 12303S
     Activator + 10% ChromaPremier 12375S Reducer
II. Spies Hecker Procedure

1. Substrate
   - Bare metal, sanded
   - Galvanised metal, sanded
   - Aluminum, sanded
   - Through-hardened sanded paintwork

2. Pretreatment/ Cleaning
   
   For substrate preparation information
   Permaloid Silicone Remover 7799
   or Permaloid Silicone Remover 7010
   or Permaloid Silicone Remover 7080

3. Stopper
   - Raderal IR Premium Putty 2035

4. Primer
   - Priomat 1:1 Wash Primer 4075

5. Filler
   - Permasolid HS Premium Surfacer 5310

6. Topcoat
   - Permahyd Basecoat Series 280/285
   with
   Permasolid HS Diamond Clear Coat 8450 + 10% Permasolid Elastic Additive 9050, 2:1 with Permasolid VHS Hardeners
   or
   Permasolid HS Diamond Clear Coat 8030 + 15% Permasolid Elastic Additive 9050, 2:1 with Permasolid VHS Hardeners + 15% Permacron Reducer
III. Standox Procedure

1. Substrate
   - Bare metal, sanded
   - Galvanised metal, sanded
   - Aluminum, sanded
   - Through-hardened sanded paintwork

2. Pretreatment/ Cleaning
   For substrate preparation information
   Standox Silicone Remover or Standohyd Cleaner

3. Stopper
   - Standox PE Stopper
   - Standox PE Fine Stopper or
     Standox Spray Filler
   - For galvanised substrates use Stndox PE Soft Stopper or
     Standox PE Rapid Stopper

4. Primer
   - Standox Etching Adhesion Primer

5. Filler
   - Standox VOC System Filler

6. Topcoat
   - Standohyd Basecoat with
     Standocryl VOC Platinum Clear +10% Standox 2K Plasticiser
     2:1 with Standox VOC Hardeners
   or
   Standocryl 2K HS Clear +15% Standox 2K Plasticiser 2:1 with
   Standox VOC Hardeners +15% 2K Thinners
IV. PPG  PROCEDURES

D8126 CeramiClear™ is a mar and scratch resistant, high solid clear coat. This new clear is especially designed for the repair of Nissan Cars that have Scratch Shield clear coat. D8126’s excellent surface properties which minimize the visible marring caused by car washing and polishing.

D8126 CeramiClear™ was formulated to meet all current VOC limits and is suitable for use in Southern California Districts. D8126 was designed for use over Envirobos Basecoat color and BC Global Basecoat Color.

D8126 CeramiClear™ uses D8226 Hardener. No thinner is required.

<table>
<thead>
<tr>
<th>IV-1. Preparation of Substrate:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wash all surfaces to be painted with soap and water, then apply the appropriate Global cleaner. See refinish bulletin EU134 Global Cleaners for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.</td>
</tr>
<tr>
<td>Wet sand with U.S. 500-600 / European P800-1200 grade paper or dry sanding with U.S. 400-500 / European P600-800 grade paper.</td>
</tr>
<tr>
<td>Wash off residue and dry thoroughly before re-cleaning with appropriate Global substrate cleaner. The use of a tack rag is recommended.</td>
</tr>
<tr>
<td>Apply Global BC Color or Envirobos Basecoat Color over original baked finishes or over recommended Global Primers. See Data Sheet EU02 for Global Basecoat Color or EU130 Envirobos Basecoat Color for application details.</td>
</tr>
</tbody>
</table>
### IV-2. APPLICATION GUIDE:

#### Mixing Ratio:

<table>
<thead>
<tr>
<th>D8126 CeramiClear™</th>
<th>2vols</th>
</tr>
</thead>
<tbody>
<tr>
<td>D8226 Hardener</td>
<td>1vol</td>
</tr>
</tbody>
</table>

#### Potlife:

| @ 68ºF / 20ºC: | 1 hour |

#### Additives:

| None |

#### Spraygun set-up:

<table>
<thead>
<tr>
<th>Fluid Tip</th>
<th>1.3 - 1.5 mm or equivalent</th>
</tr>
</thead>
<tbody>
<tr>
<td>Spray Viscosity</td>
<td>19 to 21 seconds #2 Zahn @ 68°F (20°C)</td>
</tr>
</tbody>
</table>

#### Spray pressure:

<table>
<thead>
<tr>
<th>HVLP at air cap</th>
<th>10 PSI at the cap</th>
</tr>
</thead>
<tbody>
<tr>
<td>Conventional at spray gun</td>
<td>45 - 55 PSI at the gun</td>
</tr>
</tbody>
</table>

#### Number of coats:

<table>
<thead>
<tr>
<th>Apply 1 medium coat, then 1 full coat (2 coats)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Film build per wet coat</td>
</tr>
<tr>
<td>Dried film build per coat</td>
</tr>
</tbody>
</table>

#### Flash off at 20ºC / 68ºF:

<table>
<thead>
<tr>
<th>Betweencoats</th>
<th>5 minutes</th>
</tr>
</thead>
<tbody>
<tr>
<td>Before baking</td>
<td>0.5 minutes</td>
</tr>
</tbody>
</table>
Dust-free:  
68°F / 20°C  30 minutes  

Dry to handle:  
68°F / 20°C  4 hours minimum  
140°F / 60°C  30 minutes  

Tape Time:  
68°F / 20°C  5 – 6 hours  
140°F / 60°C  30 minutes + cool down*  

Through Dry:  
68°F / 20°C  8 hours  
140°F / 60°C  30 minutes + 2 hours @ room temperature*  

IR (infrared):  
Medium wave  15 minutes  
Short wave  8 minutes  

After 24 hours @ 70°F (21°C) D8126 Ceramiclear can be lightly de-nibbed with 2000 grit sandpaper and compounded. Use a foam pad with a minor cutting compound to remove any minor imperfections.  

- All force dry times are quoted for metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature.  

**Note:** For best results, D8126 should be used for full panel repairs.  

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**Overcoat/Recoat**  

<table>
<thead>
<tr>
<th>Overcoat/Recoat Time</th>
<th>10 hours at 68°F (20°C) or after force dry/cool down + 2 hours</th>
</tr>
</thead>
<tbody>
<tr>
<td>Grade wet</td>
<td>U.S. 500 – 600 / European P800 – 1200</td>
</tr>
<tr>
<td>Grade dry</td>
<td>U.S. 400 – 500 / European P600 - 800</td>
</tr>
</tbody>
</table>

**PPG would like to recommend the following 3M products:**  

**Remove Dust:**  
DA Sand with 3M 1500 grit to remove small imperfections  
DA Sand with interface pad and 3M P3000 Trizact with water lubricant  

**Polishing:**  
Compounds with 06060 Extra Cut Compound  
Followed by 06064 Swirl Mark Remover  
Followed by 06068 UltraFina SE
IV-3. **Technical Data:**

Total dry film build:

Minimum: 2.0 mils
Maximum: 2.5 mils

Recommended film build per wet coat: 2.1 – 3.1 mils
Recommended dried film build per coat: 1.0 – 1.5 mils

Theoretical coverage: 799 sq. ft./US gal

Theoretical coverage in sq.ft./US gal. Ready-to-spray (RTS), giving 1 mils dry film thickness.

Percent solids by volume RTS: 49.79

VOC Regulatory (less water less exempt): 2.00 lbs/gal (240 g/L)
VOC Actual: 1.40 lbs/gal (168 g/L)
Density: 8.96 lbs/gal (1074 g/L)

Volatile Weight %: 47.9 %
Water Weight %: 0.0 %
Exempt Weight %: 33.3 %
Water Volume %: 0.0 %
Exempt Volume %: 30.4 %
Solids Volume %: 49.8 %

Applicable Use Category: Clear Coating
IV-4. Health and Safety

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and MSDS's of all the components, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product MSDS and respirator manufacturer’s recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.
V. Glasurit Procedures

V-1. Remark

Edge to edge refinish is recommended.
When spot repair is carried out, use spot80X as blending agent.
Please conduct supplementary dry before polishing.
(Refer to “Spot Repair Method No.10”)
Please use instructed tool for polishing.


90 Line Waterborne basecoat
- Very good hiding power, high efficiency
- Metallic and solid colour basecoat.

923-45 Scratch Resistant 3.5 VOC HS clear
- High solid.
- Extremely scratch-resistant.
- Outstanding weathering and yellowing resistance.
- Excellent finish quality.
- Quickly ready for polishing and masking.

V-3. PROCESS

<table>
<thead>
<tr>
<th>Cleaning</th>
<th>Glasurit® Wax and Silicone Remover 541-5</th>
<th>1x</th>
<th>Wipe dry</th>
<th>Sand damaged areas down to the bare metal</th>
<th>P16-P150</th>
<th>Glasurit® Wax and Silicone Remover 541-5</th>
<th>1x</th>
<th>Wipe dry</th>
</tr>
</thead>
<tbody>
<tr>
<td>Body filling</td>
<td>Glasurit® Multi-Purpose Body Filler 839-20</td>
<td>+2.3%</td>
<td>20°C (68°F)</td>
<td>20-30 min.</td>
<td>3-5 min</td>
<td>Glasurit® Hardener Paste, red 948-36</td>
<td>P80/P150 coarse sanding</td>
<td>P240/P320 fine sanding</td>
</tr>
</tbody>
</table>
## Cleaning

| Glasurit® Wax and Silicone Remover 541-5 | 1x | Wipe dry |

## Primer (bare metal areas only)

<table>
<thead>
<tr>
<th>Glasurit® HS Thermo Primer Filler 283-155</th>
<th>Glasurit® Activator, fast 352-228</th>
<th>Glasurit® Reducer 352-1:1 +30% mixing stick</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>HVLP 0.7 bar (6-10 psi) at the cap 1.3 mm</td>
</tr>
<tr>
<td></td>
<td></td>
<td>10 min. 20°C (68°F)</td>
</tr>
</tbody>
</table>

## Filler

<table>
<thead>
<tr>
<th>Glasurit® Universal Primer Filler 285-60</th>
<th>Glasurit® HS Filler Hardener 929-</th>
<th>Glasurit® Reducer 352-4:1:1 mixing stick</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>HVLP 0.7 bar (6-10 psi) at the cap 1.9 mm</td>
</tr>
<tr>
<td></td>
<td></td>
<td>30 min. 60°C (140°F)</td>
</tr>
<tr>
<td></td>
<td></td>
<td>6 min. short wave</td>
</tr>
<tr>
<td></td>
<td></td>
<td>P800 P500</td>
</tr>
</tbody>
</table>

## Cleaning

<table>
<thead>
<tr>
<th>Glasurit® Wax and Silicone Remover 541-5</th>
<th>1x</th>
<th>Wipe dry</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>(when using water-based paints)</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Glasurit® Cleaner 700-1</td>
</tr>
<tr>
<td></td>
<td></td>
<td>1x</td>
</tr>
</tbody>
</table>
**Basecoat Mixing system (water-borne) 90 Line**

| Glasurit® Water-borne Mixing Base 90-M4 | Glasurit® Basecoat mixing bases 90-M+A acc. to mixing formula | Glasurit® Adjusting Base 93-E3 | 2:1 mixing stick | HVLP 0.7 bar (6-10 psi) at the cap 1.3 mm | 2 +½ Flash off until mat between spraycoats and before clear |

| Scratched-Resistant clear | Glasurit® Anti-Scratch Clear 923-45 | Glasurit® HS Hardener 929-33/-31 | Glasurit® Reducer 352-91/-216 | 2:1 + 10% mixing stick | HVLP 0.7 bar (6-10 psi) at the cap 1.3 mm | 2 30 min. 60°C (140°F) 8 min. short wave |

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**V-4. Spot repair method**

**Sanding**
1. Sanding damaged part with P1000.
2. Sanding fade-out part with Bufflex#3000.

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**Cleaning**
3. Cleaning with Glasurit Cleaner 700-1, dry with paper towel.
**Basecoat (Water borne)**

4. Spray 2+1/2 coat of Glasurit Waterborn 90 Line using HVLP spraygun.
5. Flash off until mat.

**Scratch resistant clear**

6. Spray 2 coat of Glasurit 923-45 with 50% Hardener 929-33/31 and 10% 352-91/216. (Clear A)
7. Spray fade-out zone Clear A with 100% SC880.
8. Spray fade-out zone Clear A with 500% Spot80X
9. Dry 60°C (140°F) for 30min.
10. Additional dry 80°C (176°F) for 60min using IR dryer.

**Polishing**

11. Polishing sanding area with Wool buff B and fine compound B.
12. Polishing sanding area with Wool buff B and ultra fine compound C.
13. Polishing sanding area with Waffled Sponge (3M 5725) and ultra fine compound C.
14. Polishing fade-out area with Waffled Sponge (3M 5725) and fine compound B.
15. Polishing fade-out area with Waffled Sponge (3M 5725) and ultra fine compound C.
V -5.“Edge to edge” for clear coat

Sanding
1. Sanding damaged part with P1000.
2. Sanding part on old clear coat with P2000 (attached with cushion pad)

Cleaning
3. Cleaning with Glasurit Cleaner 700-1, dry with paper towel.

Basecoat (Water borne)
4. Spray 2+1/2 coat of Glasurit Waterborn 90 Line using HVLP spraygun.
5. Flash off until mat.

Scratch resistant clear
6. Spray 2 coat of Glasurit 923-45 with 50% Hardener 929-33/31 and 10% 352-91/216 (Clear A)
7. Dry 60°C (140F) for 30 min.
VI. SHERWIN-WILLIAMS Procedure

VI-1. PRODUCT DESCRIPTION
ULTRA 7000® Scratch Resistant Clearcoat SRC2 is a premium quality, high solids, urethane clearcoat designed to deliver the maximum in appearance and productivity, and provides outstanding gloss hold out. SRC2 is low in VOC at 2.1 pounds per sprayable gallon, making it compliant for use in all VOC regulated areas.

VI-2. SURFACE PREPARATION
SRC2 Scratch Resistant Clearcoat is designed for use over AWX™ and ULTRA 7000® basecoat colors, and properly prepared OE clearcoat in the case of blending.
- Allow basecoat color to flash 10-20 minutes (ULTRA 7000®) or minimum 10-20 minutes (AWX™) before applying clearcoat.

Preparation for Blending Panels
1. Clean with appropriate Sherwin-Williams surface cleaner and wipe dry with a clean cloth.
2. Blend panel should be sanded with P 800 grit or finer paper, or scuff sand with a gray scuff pad and USP90 ULTRA SCUFFING PASTE and water. Rinse thoroughly and dry with a clean cloth.
3. Repeat step one, and then thoroughly tack surfaces to be painted with a clean tack cloth.

VI-3. APPLICATION TECHNIQUES
WET-ON-WET/LIMITED FLASH APPLICATION - Please consult your technical representative for training on the Wet-on-Wet, single application (limited flash) technique. This technique is preferred and enhances shop productivity once the technician has been trained. Desired film build is 2.0 – 2.5 mils (dry).

FOR SINGLE OR TWO-PANEL REPAIR - Apply an even medium to light first coat to entire surface with a gun distance of 4 - 6 inches. Flash for 2 to 5 minutes before second coat.

FOR MULTI-PANEL REPAIR (3 OR MORE PANELS) - Follow first coat immediately with second coat. First coat should be even without missed areas but not heavy and wet. Flash time between coats is not necessary. Check for proper atomization.

TO BLEND CLEARCOAT EDGE - Use BS10 Ure-Blend™ aerosol, or BS10 in second gun at low-pressure 20 – 25 psi conventional and 5 psi HVLP cap pressure. Apply only enough blending solvent necessary to melt blend edge.
BUFFING:
If buffing SRC2 is needed due to dirt:

1. Allow clearcoat to cure according to drying schedule before sanding and buffing.
   NOTE: Drying schedule is based on 50% relative humidity. Variances in film build, temperature, humidity and application may speed up or slow down the actual time that SRC2 is ready to buff.

2. Sand (wet or dry) with 1500 to 2000 grit sandpaper followed by wet sanding (cross-sanding) with 2500 to 3000 grit sandpaper, checking frequently to ensure that the 1500 – 2000 scratches are being removed.

3. Buff by machine with 3M SRC compound #05927 (or like quality) using a wool pad, followed by a foam pad.

VI-4. REGULATORY DATA

<table>
<thead>
<tr>
<th></th>
<th>As Packaged</th>
<th></th>
<th>As Applied</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>G/L</td>
<td>Lbs/Gal</td>
<td>G/L</td>
<td>Lbs/Gal</td>
</tr>
<tr>
<td>VOC Total</td>
<td>473.2</td>
<td>3.95</td>
<td>485.5</td>
<td>4.05</td>
</tr>
<tr>
<td>VOC Less Exempt</td>
<td>117.6</td>
<td>0.98</td>
<td>224.7</td>
<td>2.04</td>
</tr>
<tr>
<td></td>
<td>Lbs/Gal Solids</td>
<td>Lbs/Lbs Solids</td>
<td>Lbs/Gal Solids</td>
<td>Lbs/Lbs Solids</td>
</tr>
<tr>
<td>HAPs</td>
<td>0.00</td>
<td>0.00</td>
<td>0.00</td>
<td>0.00</td>
</tr>
<tr>
<td></td>
<td>Wt.%</td>
<td>Vol.%</td>
<td>Wt.%</td>
<td>Vol.%</td>
</tr>
<tr>
<td>Volatiles</td>
<td>45.4</td>
<td>48.0</td>
<td>47.1</td>
<td>51.4</td>
</tr>
<tr>
<td>Water</td>
<td>NA</td>
<td>NA</td>
<td>NA</td>
<td>NA</td>
</tr>
<tr>
<td>Exempt Compounds</td>
<td>NA</td>
<td>NA</td>
<td>NA</td>
<td>NA</td>
</tr>
<tr>
<td></td>
<td>G/L</td>
<td>Lbs/Gal</td>
<td>G/L</td>
<td>Lbs/Gal</td>
</tr>
<tr>
<td>Density</td>
<td>1042.7</td>
<td>8.70</td>
<td>1030.2</td>
<td>8.60</td>
</tr>
</tbody>
</table>
SUITABLE SUBSTRATES
• OEM Topcoats • Ultra 7000® Basecoat Colors
• Aged Refinishes • AWX™ Basecoat Colors

MIXING

\[
\begin{align*}
\text{SRC2} & \quad + \quad \text{UH20} & \quad + \quad \text{R26, R28 or US3-6 Reducers}
\end{align*}
\]

APPLICATION
• Apply 2 wet coats using a limited flash, Wet-On-Wet application method, or allow each coat to flash hand slick.
• 8-10 psi HVLP/ 45-50 psi Conventional gravity feed.
• See reverse for complete list of application techniques

<table>
<thead>
<tr>
<th>Reducer Selection Chart</th>
</tr>
</thead>
<tbody>
<tr>
<td>R26 50° F-75° F</td>
</tr>
<tr>
<td>R28 70° F-115° F</td>
</tr>
<tr>
<td>US3 50° F-70° F</td>
</tr>
<tr>
<td>US4 70° F-90° F</td>
</tr>
<tr>
<td>US5 80° F-100° F</td>
</tr>
<tr>
<td>US5 100° F-115° F</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Air dry</th>
<th>Out of Dust</th>
<th>35 – 45 minutes</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>To Deliver</td>
<td>8 hours</td>
</tr>
<tr>
<td>Force Dry</td>
<td>20-30 minutes at 140° F surface temperature</td>
<td></td>
</tr>
<tr>
<td>Buffing Times</td>
<td>Air Dry</td>
<td>4-5 hours</td>
</tr>
<tr>
<td></td>
<td>Force Dry</td>
<td>30 minutes after cool down</td>
</tr>
</tbody>
</table>

NOTES
• Reccoat basecoat color with SCR2.
• Reccoat basecoat colors before 7 days or remove basecoat color.
• Do not add accelerator to this clearcoat.
• If fisheyes are a problem, add ½ ounce of V3K780 Fisheye eliminator

PERSONAL PROTECTION
• For use by trained professionals only.
• Read label, directions, and MSDS before use.
• Use appropriate Personal Protective Equipment while mixing and spraying.