



Technical Data Sheet

12-24-KEY730 "3 MINUTE" HIGH PRODUCTION CLEARCOAT

PRODUCT DESCRIPTION:

KEY730 is an extremely fast drying low V.O.C. Acrylic Urethane Clearcoat that works well over all urethane color systems. KEY730 works excellent in shops where airborne dirt and overspray may be a problem. This clear is an excellent choice for a production enhancer.

FEATURES:

1. Super fast dust free time
2. Excellent for increased production
3. For use as cut-in clear or for panel/multi-panel application
4. Excellent gloss retention and D.O.I.
5. European resin system produces a top quality, long lasting finish
6. Thoroughly tested for long term durability
7. Fast buff time for better production

RECOMMENDED SUBSTRATES:

1. Various basecoat color systems
2. Polyurethane enamel (after 8 hour dry)
3. Acrylic urethane enamel (after 8 hour dry)
4. Gel coat (must be properly prepared)

MIXING INSTRUCTIONS:

Clear = 4 parts KEY730

Activator/Reducer = 1 part KEY760/775/785/795

ACTIVATORS:

KEY760 = Fast 55 to 65 F

KEY775 = Medium 65 to 80 F

KEY785 = Slow 80 F - 90 F

KEY795 = Ex-Slow 90 F - up

APPLICATION INSTRUCTIONS:

1. Apply basecoat color per recommended procedures Note: Allow polyurethane and acrylic enamel basecoat to dry at least 8 hours before applying clear.
2. Mix KEY730 Clear with appropriate activator per above instructions and shop conditions.
3. Apply 2-3 wet coats of Clear using 50-60 P.S.I. at the gun.
4. Allow 10 minutes flash between coats.
5. Dry times: Dust Free 3 minutes depending on temperature and activator selection. Tack Free 20 minutes depending on activator speed Buff Time 6-8 hours air dry @ 72 F Force Dry 10 minute flash; bake 30 minutes at 140 F
6. Pot Life: 3 hours @ 72 F

Note: By using one ounce per sprayable quart of KEY950 Universal Accelerator, buff time and delivery time can be substantially reduced.

BUFFABILITY:

KEY730 Clear can be wet sanded and buffed within 6-8 hours when kept at 72 F. KEY730 is very easy to buff however, it is designed to gain hardness after 72 hours and will become more difficult to buff.

CLEANING:

Use good quality lacquer thinner (KEY5/10/15/20/25) or urethane reducer (KEY80/81/82/83) to thoroughly clean all equipment. Do not leave activated clear in gun longer than 3 hours.

TECHNICAL DATA:

Color:	Clear
Pot Life:	3 hours @ 72 F
Coverage:	1 mil 567 sq. ft.
Mix Ratio:	4:1
Sprayable Viscosity:	18 sec. #2 Zahn
Flash Point:	-20 F
Recommended Film Build:	2 mil DFT
Gloss:	95
Weight Solids (sprayable):	39.7%
V.O.C w/KEY760, 775, 785, 795	3.5 lbs/gal (420 g/l) Ready To Spray