



# Tech Data

## 3800 Euro Clear

3800 Euro Clear is an easy to spray; water white low VOC high quality clearcoat designed for panel repairs and complete refinishing over most aftermarket acrylic enamel, acrylic and urethane basecoat systems. 3800 can also be integrated into most acrylic enamel and urethane single stage systems for improved gloss and durability. 3800 dries fast and retains high gloss and DOI. 3800 provides excellent durability and is resistant to environmental conditions such as sunlight and acid rain. 3800 can be buffed to match the original finish after 8-12 hours air dry and can be buffed for several days. When mixed 2/1 with 3801, 3802 or 3803 series hardeners, the 3800 clear has a sprayable VOC of just 4.2 lbs/gal making it one of the lowest VOC painter friendly clearcoats in the industry.

### Products

<b>3800</b>	Euro Clear
<b>3801</b>	Fast Euro Catalyst
<b>3802</b>	Medium Euro Catalyst
<b>3803</b>	Slow Euro Catalyst

### Application

#### Surface Preparation, Bare Substrates

Solvent wash surface with a good grade wax and grease remover and wipe dry with a clean cloth. Apply three single wet coats of Velocity Epoxy Primer according to instructions on data sheet. Follow with two to three coats of 3600 Gray Urethane Primer.

#### Surface Preparation, Prepainted Substrates

Wash surfaces with a mild detergent and hot water. Rinse with clean water and wipe dry with a clean cloth. Solvent clean with a good grade wax and grease remover. Wipe dry with a clean cloth. Sand original paint and repair damaged areas with a good quality non-staining body filler. Apply 2-3 wet coats of 3600 Gray Urethane Primer as needed to fill voids and block sand with 180 to 280 grit treated sandpaper. Finish sand repaired area with 320 grit sandpaper using a DA Sander. For spot repairs, scuff sand area where basecoat and clearcoat will be blended with 320 to 600 grit sandpaper or nylon scuff pad. For overall refinishing, scuff sand the entire car with 320 grit sandpaper or fine scuff pad.

#### Sealer

Apply appropriate Velocity 2k Sealer according to manufacturer's instructions. Allow sufficient flash times to allow the solvents to escape film. Insufficient flash times will lead to retarded hardness development of the total system.

#### Basecoat

For best results, follow flash times and film thickness recommendations of the basecoat supplier. Note: flash times vary between basecoats and are dependent on the shop temperature and air movement. Insufficient basecoat flash time may lead to movement of the basecoat metallic pigments and loss of clearcoat gloss.

#### Mixing Directions

2 Parts 3800	Euro-Gloss Clear
1 Part 3801, 3802 or 3803	Euro Catalyst

Once catalyzed, 3800 is ready to spray. However, for specific shop conditions, 3800 can be reduced or retarded with up to 10% urethane grade reducer or retarder. In cold weather, the use of 3801 is recommended, however, in place of 3801, the addition of a urethane cure accelerator will speed overnight cure. CAUTION: care should be exercised in the addition of cure accelerators to urethane products. A significant reduction in potlife and a loss of clearcoat gloss can occur if over accelerated.

## Application

Adjust air pressure at the gun to 45-50 psi for siphon feed guns or 6-10 psi when using a HVLP. Use less pressure to minimize over spray on small jobs. Apply 2-3 wet coats at a gun distance of 8-12 inches allowing each coat to become hand slick before applying the next coat. Recoat times will vary with temperature and air movement between 10 and 30 minutes. Apply each coat of clear within 30 minutes flash of the previous coat to prevent possible recoat lift. Recommended dry film thickness is 1.8 to 2.5 mils.

## Blending Procedure

Before blending the Panel with clear, the blended area must be washed and scuff sanded thoroughly with a good quality wax and grease remover. Apply wet coats of clear to cover the repaired area and slightly beyond. Allow recommended flash times between coats. Extend the second coat 4 to 8 inches beyond the first coat. Begin application of the final coat 4 to 8 inches beyond the second coat and spray into the center of the painted area. Best results can be achieved by the addition of 10% to 50% of a urethane grade reducer in the last coat. Any dry edges remaining can be melted in immediately by misting with a second gun containing a medium temperature urethane reducer or blending solvent.

## Drying Schedule

Dry times are based on recommended film thickness and are dependent on ambient temperature. Excessive film thicknesses, low temperature and poor air movement will retard dry times.

		<u>Air Dry</u>	
Dust Free	10-15 min	Buffable	8-12 hours
Tack Free	20-30 min	To Deliver	8-12 hours

## Force Dry Times

Allow 10-15 minutes flash time of final coat of clear when using infrared or radiant heat.

<u>Temperature</u>		<u>3802</u>	<u>3803</u>
110°F	45 min	120°F 45 min	140°F 30 min

## Buffing

If buffing is needed to remove dirt, allow the clearcoat to dry the recommended time then wet sand with 800-1000 grit sandpaper followed by 1500 grit sandpaper. When all 800-1000 scratches are removed, buff with a fine grade liquid rubbing compound followed by a polish or glaze compound applied by hand or machine.

## Technical Data

Weight Solids		Mixing Ratio	2:1
Package	47.0%	Air Pressure @ Gun	35-50 psi
Ready to spray 2/1	45.0%	Recommended Film Thickness	1.8 - 2.5 mil
		Flash Point	72 °F TCC
Volume Solids		Gloss	90+
Package	40.0%	DOI	Excellent
Ready to spray 2/1	38.0%	Pot Life	6 to 10 hours
		Coverage Ready to Spray 2/1	619 sq ft
VOC @ Gun 2/1	4.2 lbs/gal	Viscosity @ Gun	16-19 #2Zahn

## Performance Data

Flexibility	Excellent	Direct Impact	Excellent	Chip Resistance	Excellent
Salt Resistance	Excellent	Humidity Resistance	Excellent	Hardness	3H