

# TECH DATA SHEET

## OSP-6400 SIMPLY CLEAR

### PRODUCT PROFILE

**PRODUCT NAME:** OSP-6400 Simply Clear®

**DESCRIPTION:** Easy to use 4:1 mixing ratio Clear. It provides a high quality finish with excellent gloss, leveling, and flow characteristics. An excellent value without sacrificing quality.

### INSTRUCTIONS

#### Applying Basecoat

- Apply in accordance with manufacturer's instructions
- Permit the basecoat to fully dry prior to applying clear
- Remove surface contaminants with tack cloth prior to applying clear

#### Mixing & Applying Clearcoat

- Thoroughly mix four parts of OSP-6400 with one part of OSP-641 series hardener
- Set gun pressures according to Gun Set-up directions
- Apply one full coat followed by one medium coat allowing 3 to 5 minute flash time between coats
- When applying an overall coat in hot weather, the second coat should be applied lightly.
- Keep spray gun 6 – 10 inches from surface, adjust speed of travel to apply wet coat with each pass, overlapping approximately 50%

Note: air may be entrapped if the distance between the gun and surface is too close or gun travel is too slow

#### Buffing

- Force dry - follow Bake directions before wet sanding/buffing.
- Air dry - for best results cure for at least two hours before buffing.
- OSP-6400 can be wet sanded in as little as four hours at 75° F

Note: cure time may vary with film thickness and temperature

### BASIC INFORMATION

#### GENERAL TECHNICAL DATA

<b>Appearance</b>	Clear Liquid	
<b>Viscosity, RTS</b>	19 seconds #2 Zahn	
<b>Shelf Life</b>	One Year (unopened)	
<b>RTS VOC</b>	2.7 lbs/gal (319 g/L) Actual 3.8 lbs/gal (457 g/L) Regulatory	
<b>RTS Solids</b>	34% by weight 30% by volume	
<b>Pot Life</b>	4 hours @ 75° F	
<b>Product size</b>		
Clearcoat	OSP-6400	Gallon
Hardeners	OSP-641 Fast	Quart
	OSP-642 Medium	Quart
	OSP-643 Slow	Quart

## VOC

### OSP-6400

Clear Coating  
Actual VOC 282 g/L

### OSP-641, 642, 643

Regulatory VOC 454 g/L  
Automotive Coating Component  
Actual VOC 586 g/L  
Regulatory VOC 568 g/L

## BASECOATS/SUBSTRATES

OSP-6400 Clearcoat is compatible with most high quality basecoats.  
Refer to basecoat manufacturing technical data sheets.  
(If not sure of compatibility, test first in an inconspicuous area)  
Recommended substrate temperature: 70° – 80° F (21° – 27° C)

## GUN SET-UP

	TIP	Air Pressure	
HVLP	1.2 – 1.3	8 – 10 psi	(at aircap)
Conventional	1.3 – 1.4 mm	40 – 50 psi	(at gun)

## FLASH & DRY TIMES

Flash Time between coats at 75°F 3 to 5 minutes  
Dust Free Time at 75°F 30 minutes

## BAKE

Allow five minute flash time before force drying  
Bake for 30 minutes at 140° F  
Cool for 2 hours after force drying before wet sanding

## RECOATING

Recoat after 12 hours air dry at 75° F  
**or**  
Recoat after 2 hours cool down after force drying

## GUN CLEAN-UP

Clean equipment with a high quality lacquer thinner immediately after spraying

## ADDITIVES

FISH EYE – The use of fish eye eliminator discouraged because it can impact the flow and leveling of the clearcoat

ACCELERATOR – The use of additional catalysts is not recommended as it can cause solvent popping and/or loss of gloss

TO PROTECT AGAINST HARMFUL VAPOR & SPRAY WEAR A POSITIVE - PRESSURE SUPPLIED AIR RESPIRATOR (NIOSH APPROVED), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING AND SPRAYING. FOLLOW MSDS FOR APPROPRIATE SAFETY AND HEALTH INSTRUCTIONS

DISCLAIMER: The information contained on this Technical Data Sheet is intended to assist you in product application. It is based on knowledge of general industry use, experience & research. Since conditions of storage, handling, and product use are not under our control, buyers must assume responsibility for suitability of the product for their specific purposes.

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