PRO FORM®

Product Data Sheet

Clear 4:1 2.1 V.O.C.

PF 688C, PF 697C

An economical, high gloss, medium solid, urethane clear formulated for spot, panel and overall repair. Easy to spray and apply, with great flowout, levelling and anti sagging properties. Will produce a high gloss, fast dry finish with easy buffing that will perform with water based and solvent based basecoat systems.

CLEAR	ACTIVATOR:	
PF 688C 3.79 L (1 U.S. Gallon)	PF 690C (Fast)	946 ml (1 U.S Quart)
	PF 689C (Medium)	946 ml (1 U.S Quart)
	PF 667C (Slow)	946 ml (1 U.S Quart)
	PF 667CXS (Super Slow)	946 ml (1 U.S Quart)
PF 697C 946 ml (1 U.S Quart)	PF 698C (Medium)	236 ml (0.5 Pint)

ALWAYS REFER TO MSDS PRIOR TO USING THIS PRODUCT AND TAKE PROTECTIVE MEASURES TO ENSURE SAFE USE

COMPATIBLE PREPARED SUBSTRATES:

- Automotive refinish basecoats (water and solvent based).
- Automotive refinish single stage (except acrylic lacquer).

Note: Clearcoat should not be applied over acrylic lacquers, or unsanded existing finishes.

SURFACE PREPARATION:



1. Apply basecoat per manufacturers' mixing and application instructions.
2. Allow the final coat of basecoat to dry in accordance with manufacturers directions.
3. Use a tack cloth to remove any surface contaminates that may have settled on the basecoat.

Please Note: Basecoat flash times could vary between basecoats. Inadequate flash times will affect the performance of the clear.

MIXING DIRECTIONS:



Clearcoat	Activator
PF 688C PF 697C	PF 690C, PF 689C, PF 667C, PF 667CXS PF 698C
4 parts	1 part

Stir thoroughly between each addition. Strain before spraying material.

Reduction: For best results do not reduce.

However, up to a maximum of 10% of Pro Form Urethane Grade Reducer can be added.
PF 682-1C (Slow), PF 683-1C (Medium) or PF 684-1C (Fast)

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APPLICATION:

For best results, use when temperature of the can and surface is at 24°C (75°F).

1. Allow the final coat of basecoat to dry in accordance with manufacturers directions.
2. Use a tack cloth to remove any surface contaminates that may have settled on the basecoat.
3. Apply two full wet coats allowing 10 to 15 minutes flash time between coats or as conditions dictate.

Do not apply over non catalyzed acrylic or synthetic enamels or acrylic lacquer finishes. Always keep containers tightly closed to prevent moisture contamination.

Caution: It is important to test the compatibility of this product with your paint system. This product is not recommended for use in temperatures below 16°C (60°F). The use below these temperatures will affect dry times and performance.

SPRAY GUN AND PRESSURE:



GUN TYPE	FLUID TIP	AIR PRESSURE
Siphon Feed	1.4-1.6mm	35-45 psi
Gravity Feed	1.2-1.6mm	25-35 psi
HVLP	1.2-1.6mm	10 psi

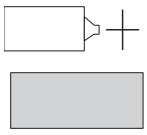
POT LIFE:



Activator	Time
PF 690C Fast	45 minutes
PF 688C/PF 697C Medium	1.5 hours
PF 667C Slow	2.5 hours
PF 667CXS Super Slow	3-4 hours

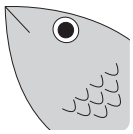
NOTE: Pot Life will shorten as temperatures increase. Products are not recommended for use in temperatures below 16°C (60°F).

ADDITIVES:



Accelerator:

Use up to a maximum of 1/2 fluid ounce of PF 655 Super Kick Accelerator per sprayable quart. The addition of Accelerator will reduce cure times and pot life by 50%, and slightly reduce the gloss.



Fish Eye:

The use of fish eye eliminator is not recommended.

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DRY & FLASH TIME:



Dry times at 24°C (75°F)

	PF 690C Fast	PF 689C/PF 698C Medium	PF 667C Slow	PF 667CXS XSlow
Flash time	3-6 minutes	8-10 minutes	10-15 minutes	15-20 minutes
To sand	2-4 hours	2-4 hours	4-8 hours	4-8 hours
Buffing	2-4 hours	2-4 hours	4-8 hours	4-8 hours
To deliver	2-4 hours	2-4 hours	4-8 hours	4-8 hours
Tack free:	10 minutes	15 minutes	20 minutes	35 minutes

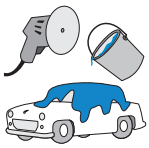
All drying times refer to shop temperature of 24°C (75°F) / 50% humidity. Allow additional drying time when optimal conditions are not reached.

Force Drying At 60°C (140°F)



Purge Time 40 minutes
Bake Time at 60°C 40 minutes
Clearcoat may be wet sanded and buffed after 1 hour cool down time. Baking will increase gloss.

REPAIRING & RECOATING:



Clearcoat may be recoated after an 8 hour dry or upon cool down after force drying at 60°C (140°F) for 40 minutes. After 24 hours, clear must be sanded with 1200 to 1500 grit abrasive before recoating.

CLEAN UP



Clean with Gun Wash or PF 686C Acrylic Lacquer Thinner.

TECHNICAL DATA:

APPEARANCE:	Clear
RESIN TYPE:	Acrylic Urethane
FLASHPOINT:	-18°C (0°F)
REDUCTION:	Up to maximum 10% Urethane Reducer
FLEX ADDITIVE:	Not required
VISCOSITY:	13 - 14 seconds #2 Zahn mixed
FILM BUILD:	maximum 6 mils wet 2-2.5 mils dry

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PF 688C / PF 697C	PF 690C Fast	PF 689C/PF 698C Med	PF 667C Slow	PF 667CXS Super Slow
VOLUME SOLIDS (R.T.S.)	31.41%	31.37%	32.19%	32.57%
WEIGHT SOLIDS (R.T.S.)	38.50%	38.50%	38.50%	38.23%
COVERAGE @ 1 mil WET	503.7 sq ft	503.2 sq ft	516.3 sq ft	522.4 sq ft

V.O.C. (RTS):

	Regulatory VOC in lbs/gal	Regulatory VOC in g/L	Material VOC in lbs/gal	Material VOC in g/L
PF 690C (Fast)	2.1	250	2.01	240.9
PF 689C/PF 698C (Medium)	2.1	250	1.96	234.9
PF 667C (Slow)	2.1	250	1.96	234.9
PF 667CXS (Super Slow)	2.1	250	2.00	239.7

PRECAUTIONARY INFORMATION

Refer to product label and Safety Data Sheet for health and safety information before using this product.

SAFETY CONSIDERATION

Safety Data Sheets are available at www.proformproducts.com or upon request at info@proformproducts.com. These are provided to help our customers satisfy their own handling, safety and disposal needs, and those required by local applicable health and safety regulations. Our Safety data sheets are updated regularly, therefore, please review the most current Safety Data Sheet before handling or using any product.

TECHNICAL INFORMATION:

The technical information, recommendations and other statements contained in this document are based upon tests or experience that Pro Form believes are reliable, but the accuracy or completeness of such information is not guaranteed.

PRODUCT USE:

Many factors beyond Pro Form's control and uniquely within user's knowledge and control can affect the use and performance of a Pro Form product in a particular application. Given the variety of factors that can affect the use and performance of a Pro Form product, user is solely responsible for evaluating the Pro Form product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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