



# EXCEL™ PRO 3420S™ CLEARCOAT



## GENERAL

### DESCRIPTION

A 2.1 lb. /gal (250 g/l) VOC, two-component, clearcoat designed for overall and panel applications. It delivers very good appearance, durability and chemical resistance. The multiple temperature range activators provide added application latitude and flexibility.

### SUGGESTED USES

It is highly recommended for accounts with force dry capabilities.

### RECOMMENDED FOR USE OVER

Excel™ Pro Basecoat (EK quality)  
Excel™ Pro Topcoat (EZ quality)

### NOT RECOMMENDED FOR

Immersion service

### DRY FILM CHARACTERISTICS

Chemical Resistance	EXCELLENT
Weatherability	VERY GOOD
Humidity Resistance	EXCELLENT
Acid Resistance	VERY GOOD
Alkali Resistance	EXCELLENT
Solvent Resistance	VERY GOOD
Abrasion Resistance	EXCELLENT
Flexibility	EXCELLENT

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



## MIXING

### MIX RATIO

Stir clearcoat thoroughly prior to activation. Combine components and mix thoroughly. Filter material prior to spray application.

Components	Parts by Volume
Excel™ Pro 3420S™ Clearcoat	3
15309S™ Low VOC Activator	1

### ADDITIVES

#### Extend pot life and improve dry time:

Add up to 2 oz. of 389S™ Accelerator to activated gal.

### INITIAL APPLICATION VISCOSITY

12-14 seconds with #3 Zahn Cup.

### INDUCTION TIME

No induction time is required.

### POT LIFE - 70°F (21°C)

2 hours as activated  
2-4 hours with 389S™ Accelerator



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## APPLICATION

### APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) below the dew point. Relative humidity should be below 90%.

### APPLICATION EQUIPMENT

Refer to spray equipment documentation for setting recommendations.

Pressure Pot (recommended)

Gravity Feed

Suction Spray

Air-Assisted Airless

### APPLICATION

- Apply using a cross-coat technique - a wet coat using a top-to-bottom motion and a medium-wet second coat using a side-to-side motion. Flash 30 seconds to 5 minutes between coats. In general, the shorter the flash the smoother the appearance.
- Excel™ Pro 3420S™ can be applied over Excel™ Pro basecoat (EK quality) and Excel™ Pro topcoat (EZ quality) solid colors with minimal flash times.
- Allow Excel™ Pro (EK quality) basecoat solid, metallic and pearl colors to flash dry for 30 minutes prior to clearcoat application.
- Allow Excel™ Pro (EZ quality) single stage topcoat solid colors to flash dry for 30 minutes prior to clearcoat application.
- To avoid mottling of the metallic flake, allow Excel™ Pro topcoat (EZ quality) metallic colors to cure overnight prior to applying clearcoat. They should be lightly scuff-sanded if allowed to dry for more than 16 hours prior to application of Excel™ Pro 3420S™ clearcoat.
- When recoating 3420S™ with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.
- For pressure pot application fluid delivery should be set for 10-12 fluid oz/min.

### APPLICATION SOLVENTS

No reduction necessary; product is ready-to-spray at less than 2.1 lbs. /gal VOC upon activation. Further reduction may result in greater than 2.1 VOC.

### CLEANUP SOLVENTS

3602S™ Lacquer Thinner

106™ Lacquer Thinner

107™ Low VOC Gun Cleaner

108™ Low HAPS Cleaning Solvent

### ADDITIONAL COMMENTS

Heating activated material above 110°F (43°C) will shorten pot life and cause product to gel.



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## DRY TIMES

### AIR DRY

77°F (25°C) & 50% RH at recommended film thickness

	Without 389S™	With 389S™
Dry to touch	4-6 hours	1-2 hours
Tack free	10-12 hours	2-4 hours
Tape free	12-24 hours	4-6 hours
Dry to assemble	72 hours	72 hours

### FORCE DRY

30 minutes at 140-160°F (60-71°C).



## PHYSICAL PROPERTIES

Maximum Service Temperature	200°F (92°C) in continuous service 300°F (148°C) in intermittent heat
Weight Per Gallon (component only)	8.56 lbs.
Weight Per Liter (component only)	1026 grams
Suggested Dry Film Thickness	1.8 – 2.2 mils
Gloss	High
Color	Clear
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

### RTS mixed 3:1 with:

#### Includes 389S **15309S**

Gallon Weight pounds per gallon	8.72
Gallon Weight grams per liter	1045
VOC AP pounds per gallon	1.6
VOC AP grams per liter	197
VOC LE pounds. per gallon	2.1
VOC LE grams per liter	250
Weight Solids	60.0%
Volume Solids	55.0%
Weight Volatiles	40.0%
Weight Water	0.0%
Volume Water	0.0%
Weight Exempt Solvents	21.1%
Volume Exempt Solvents	21.2%
Theoretical Coverage per RTS Gallon at 1 mil DFT	882 ft <sup>2</sup> (82.0 m <sup>2</sup> )

## VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

## SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States:  
**1.855.6.AXALTA**  
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In Canada:  
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