





Metacryl 7380 3.5 VOC HS Fleet Clearcoat




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7360, 7361, 7362 or 7363 Hardener
COMPONENTS 7370, 7371 and 7372 Reducer



1 tack coat followed by
1 wet coat
5 minute flash time
between coats

APPLICATION



2 : 1 : 5 – 10%

MIX RATIO




Hand Slick: 20 Minutes
Dust Free: 45 Minutes
Dry to Polish: Overnight
Dry to Handle: Overnight

DRY TIME



ZAHN #2
20 – 22 Seconds

VISCOSITY



3.5 lbs/gal
419 g/L

VOC



GENERAL

DESCRIPTION

Metacryl 7380 3.5 VOC HS Fleet Clearcoat is a high build, polyurethane / urethane for multi-panel and overall refinishing. 7380 provides ease of use and short flash times without sacrificing performance and appearance. For use over any Metacryl basecoat or single stage.

COMPATIBLE SUBSTRATES

- Metacryl FN, FH, FB and FC Colors
- Properly prepared OEM or aged finishes

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



MIXING

COMPONENTS

Mix 2 parts 7380 3.5 VOC HS Fleet Clearcoat to 1 part 7360, 7361, 7362 or 7363 Hardener. Optional 5 – 10% part 7370, 7371 or 7372 Reducer.

Component	Volume
Metacryl 7380 3.5 VOC HS Fleet Clearcoat	2
Metacryl 7360, 7361, 7362 or 7363 Hardener	1
Metacryl 7370, 7371 or 7372 Reducer	1

HARDENER SELECTION

- 7360 Fast 65 – 75°F/18 – 24°C
- 7361 Medium 75 – 85°F/24 – 29°C
- 7362 Slow 85 – 95°F/29 – 35°C
- 7363 Extra Slow 85°F+/29°C



SPECIALTY COMPONENTS

- 7377 Accelerator: 1 – 3%
- 7376 Fisheye Eliminator: Max 2%
- 7349 Matting Base

POT LIFE

2 – 4 Hours at 77°F/24°C / 50% R.H.



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 - 1.5 mm	6 - 10 PSI	*At the cap
High Efficiency	1.3 - 1.5 mm	30 PSI	At gauge
Pressure Pot	1.0 – 1.1 mm	6 - 10 PSI	*At the pot

NOTE: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

SURFACE PREPARATION

Apply base coat as needed with proper flash time between coats. Allow base to dry 20 – 30 minutes at 75°F/23°C before applying clear.

APPLICATION

Allow proper dry times for color systems prior to topcoating. Spray 1 tack coat followed by 1 wet coat. Allow 5 minutes flash time between coats. Can be used as an integrating clear in FH or FL color: Reduce and catalyze 7380 or FH or FL color as normal. Mix 7380 with equal volume of FH or FL color.

CLEAN-UP

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner. Dispose of all paint and paint related materials in accordance with state and local regulations.



DRY TIMES

AIR DRY

@ 75°F/23°C

Hand Slick	20 Minutes
Dust Free	45 Minutes
To Polish	Overnight
To Handle	Overnight
IR Cure	20 Minutes at 170°F/77°C
Force Dry Time	45 Minutes at 140°F/60°C
To Sand/Buff	After Cool Down (1 – 2hrs)

FORCE DRY

Bake 45 minutes at 140°F/60°C. No purge time is necessary.



PHYSICAL PROPERTIES

Direct Impact	100 in/lbs
Reverse Impact	80 in/lbs
Solvent Resistance	MEK pass 100 rubs Xylene pass 1000 rubs
Chemical Resistance	Acid (HCl) – No effect, 6hr Base (NaOH) – No effect, 6hr Skydrol – No effect, 24hr
Flexibility	Pass Conical Mandrel
Film Hardness	2H
RTS VOC	3.5 lbs/gallon



RTS Volume Solids	53.0%
ZAHN #2 Viscosity	20 – 22 Seconds
DFT per Coat	Approximately 1.5 mil
Theoretical Coverage	Approx. 848 SqFt at 1 Mil DFT/mixed gallon
Product Class	Clearcoat

STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).

VOC REGULATED AREAS

VOC as Applied 419 grams/liter | 3.5 lbs/gallon

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 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 and Canada:
1.855.6.AXALTA
metacryl.us

