

VICTORY

URETHANE CLEAR

FOR PAINTERS DEMANDING
QUALITY AT A FAIR PRICE



PRODUCT FEATURES:

- EXCELLENT CLARITY
- EXCEPTIONAL FLOW AND LEVELING
- DESIGNED FOR SPOT TO OVERALL
- EASY BUFFING
- FAST DUST FREE TIMES
- COMPATIBLE WITH MOST BASECOATS
- EASY 4:1 MIX RATIO
- PREMIUM GLOSS/EXCELLENT DOI
- PRICED TO MAKE YOU MONEY

AXIS
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» DESCRIPTION

VICTORY CLEAR is a quality production clearcoat that can be used for spot, panel and overall repairs. It features exceptional clarity, excellent flow and high gloss. It is designed for shops looking for a lower cost great multipurpose clear.

» AVAILABILITY

CLEAR (Part A)

ACL-1100-1	VICTORY Clear
ACL-1100-4	VICTORY Clear

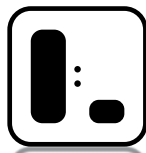
Unit	Per Case
GAL	2
QT	6

ACTIVATOR (Part B)

BCL-1101-4	Fast Activator
BCL-1101-6	Fast Activator
BCL-1102-4	Medium Activator
BCL-1102-6	Medium Activator
BCL-1103-4	Slow Activator
BCL-1103-6	Slow Activator

Unit	Per Case
QT	4
HP	6
QT	4
HP	6
QT	4
HP	6

» MIX RATIO



4 PART A: VICTORY CLEAR

1 PART B: VICTORY CLEAR ACTIVATOR

To improve flow, reduce as needed with compliant reducer.

» SURFACE PREP

Apply basecoat per manufacturer's mixing and application instructions. DO NOT DEVIATE FROM THESE RECOMMENDATIONS.

» SPRAY GUN SETUP

Gun Type	Tip Size	Pressure
Gravity or Siphon Feed HVLP	1.3 to 1.4 mm	25 to 30 PSI (at Gun) 7 to 10 PSI (at Cap)

SPRAY GUN ADJUSTMENT

- » Adjust the material flow according to product viscosity.
- » Fully close the material flow knob then turn knob counter clockwise 1 and 1/4 turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut.

NOTE: Proper spray gun adjustment will determine the final finish. Improper adjustment may cause paint defects such as orange peel, runs, sags and poor drying.

» APPLICATION

Stir components thoroughly before use. Apply 3 medium wet coats. Three mils dry film build is recommended prior to sanding and buffing for long-term durability

» DRY TIMES AT 70°F

AIR DRY

Dust Free	15 Minutes
Flash	Approximately 15 to 20 minutes (Until Hand Slick)
Sand & Buff	At 70°F 16 to 20 hours

FORCE DRY

Flash for 10 minutes and then bake @ 120 -140°F for 30 min

1. Only use Slow or Medium activator when force drying.
2. Allow vehicle to cool down to room temperature before sanding and buffing.

NOTE: All tests are performed at 70°F, higher temperatures will provide faster buffing times.

» TECHNICAL DATA

Color	Transparent
Pot Life	4-6 Hours
Flash Point	(-17°C) 1°F
Dry Film Build	2.2 to 2.5 mils
Sprayable Viscosity (RTS)	15" to 17" #2 Zahn Cup
EPA VOC (RTS)	4.5 (lb/gal)
ACTUAL VOC (RTS)	3.8 (lb/gal)
Theoretical Coverage (1 mil)	512.5 sq ft per gal
Humidity Resistance	Excellent

FOR ADDITIONAL SURFACE PREPARATION, APPLICATION AND TECHNICAL INFORMATION, REFER TO THE TECHNICAL DATA SHEET.

FOR PRODUCT SAFETY INFORMATION, REFER TO THE MATERIAL SAFETY DATA SHEET.



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