# CLEARCOAT OPTIONS



• Mix

FC710 or FH611, FH612 FC720 or FH613

# CLEARCOAT/HARDENER SELECTION CHART

Temperature Range	Repair Size		
	1–2 panels	3–4 panels	overalls
60°F	FC710/FH611	FC710/FH612	FC720/FH611
70°F	FC710/FH611	FC710/FH612	FC720/FH612
80°F	FC710/FH612	FC720/FH612	FC720/FH613
90°F	FC710/FH613	FC720/FH613	FC720/FH613



• Stir thoroughly and strain.



- Apply two coats allowing 2–5 minutes flash between coats.
- Adjust air pressure to 8-10 psi for HVLP guns.
- Adjust air pressure to 50–60 psi for conventional guns.



• Air dry times at 70°F:

FC710 FC720

Dust Free: 15 min 40-45 min

To Deliver: 4-6 hours 8 hours

• Force dry times at 120°F surface temperature:

**FC710 FC720** 15 min 30 min



• Pot life: 1 hour @ 75°F

 If necessary, after 24 hours air dry, or cool down from force dry, sand with 1500 or finer grit paper and buff with the appropriate compound. Buffing is easiest when done within the first 48 hours following application.

# CARE FOR YOUR FINISH

#### For the First 30 Days

- 1. Commercial car washes should be avoided.
- Wash with cool water using a very mild household detergent.
- 3. Wash your car in the shade, not in the hot sun. Wipe dry with a soft towel.
- 4. Extreme heat or cold should be avoided. In hot weather, keep car in shade whenever possible.
- 5. Dry wiping with a dry cloth is not recommended.
- 6. Gravel roads should be avoided.
- 7. Parking under trees or near factories with heavy smoke fall-out can cause damage.
- 8. Anti-freeze, gasoline, or windshield solvent, if spilled on the painted surface should be rinsed off with water immediately.
- Ice or snow should not be scraped from the painted surface. Brush off!

### For the First 60 days

1. Wax or polish should not be used!

# SAFETY

- · Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a positive air respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, and rubber gloves when using product.
- Always apply coatings in a well ventilated area.



2008 ACME® Automotive Finishes Cleveland, Ohio 44128

AUTOMOTIVE REFINISH PRODUCTS Applications Guide

# SURFACE PREPARATION



- Wash thoroughly with a mild detergent and hot water.
- Rinse well and dry with a clean dry cloth.
- Solvent clean with Wax and Grease remover FT200.
- Wipe dry with a clean dry cloth.

# GRIND AND REPAIR AREA



 Grind or sandblast repair area to remove paint and all rust as needed.



• Fill as needed using an appropriate body filler.



 Sand repair area and featheredge using 80, 120, 280, and finish with 320 grit treated sandpaper on a random orbital sander.

# PRIMING (BARE METAL)



- For bare metal use FP301 Etching Filler
- Mix





- Stir thoroughly and strain.
- Adjust air pressure to 8–9 psi at the cap for HVLP or 30–35 psi for conventional gun.
- Apply 2–3 medium wet coats allowing 2–3 minutes flash time between coats.
- Recoat or sand after 30 minutes and before 24 hours.
- Pot life: 24 hours

# PRIMER SURFACER

- For best results use FP410
- Mix



## 2K HS Urethane Option (preferred)



- 4 parts FP410 2K Surfacer with 1 part FP411 Hardener.
- Pot life:
   @ 70°F 1 hour
   @ 80°F 45 minutes
   @ 90°F 30 minutes



### **Acrylic Primer Surfacer Option**



• 1 part with FP401 or FP402 Primer with 1 part FT210 or FT215 reducer.



- For either primer, stir thoroughly and strain into oun cup.
- Adjust air pressure at cap to 5–7 psi for FP410, 8–9 psi for FP401 or FP402, when using HVLP guns.
- Adjust air pressure at gun to 30–40 psi for FP410 and 40–45 psi for FP401 or FP402, when using conventional guns.



- Apply 2–3 medium coats allowing each coat to become hand slick before the next coat (approximately 5–10 minutes).
- Use medium coats for filling instead of heavy wet coats.



- FP401 & FP402 may be sanded in 15–20 minutes.
- FP410 may be sanded in approximately 2 hours @ 70°F.



- Block sand FP401 or FP402 with 320-400 grit.
- Block sand FP410 with 400-600 grit.

# SEALING

## FS510, FS512, FS514 4.6 VOC Sealer



- For optimum performance, consult color card for recommended sealer color for each topcoat color.
- Blow off car with air. Clean with tack rag. Stir or shake Sealer.
- Mix



## 1K Option





#### 2K Option





- Pot life: 1 hour with 2K option
- Stir thoroughly and strain.
- Adjust air pressure to 7-10 psi for HVLP guns.
- Adjust air pressure to 45–55 psi for conventional guns.



### Wet-on-Wet Application (most commonly used)

- Apply 1 full even wet coat to achieve .8 to 1.2 mils at a gun distance of 4" 7".
- Topcoat after a 5–10 minute flash, up to 8 hours.

#### **Barrier Coat Application** (2K Only)

- Apply 2-3 medium coats, allowing each coat to flash handslick between coats, to achieve 2.0 mils. Apply to complete panels only.
- Allow to dry overnight @ 80°F. Then scuff sand with 600 grit or finer prior to topcoating.
- Resealing is not necessary.

# ACRYLIC ENAMEL



• Mix



- · Stir thoroughly and strain.
- Hardener Temperature Range:

FH611: 65°-70°F (air dry only)

FH612: 65°–85°F FH613: 80° and above



- Apply two medium wet coats or until uniform color is achieved.
- Allow each coat to flash until handslick.
- Adjust air pressure to 10 psi HVLP.
- Adjust air pressure to 40–45 psi conventional gravity feed.



- Air dry times at 70°F:
   Dust Free: 30 minutes
   To Deliver: overnight
- Force dry times at 120°F surface temperature:
   Dust Free: 30 minutes



 Buff after 24 hours air dry, or 30 minutes of cool down from force dry. Buffing of metallic colors may cause streaking. Only a light polishing of metallic colors is recommended.

