

SMR-102

High Gloss Fast Cure

90 Minute CLEARCOAT

TECHNICAL DATA

DESCRIPTION:

SMR-102 Speedo High Gloss Fast Cure 90 Minute Clearcoat. This 4.2 V.O.C. two component clearcoat can be used for spot and multi-panel repairs of OEM base/clear finishes. SMR-102 eliminates the typical 30 minutes @ 140 °F baking step normally required to process clearcoat. It air dries in 1.5 hours at 72 °F, or if rapid delivery is required, the clear can be express baked using a 10 minute bake cycle at 120°F metal temperature. SMR-102 is also easy to spray and buffs easily after 1.5-2 hours air dry time. When mixed with SpeedoKote activators according to the volume ratio 4:1, this product can be applied over any urethane compatible basecoat. **% Solid; Sprayable by Weight: 40.4%.**

PACKAGING:

Part Number	Description	Temp.	Size	Qty. Case
SMR-102	High Gloss Fast Cure 90 Minute Clearcoat		Gallon	4
SMR-60	SPEEDO ACTIVATOR Fast	55°F - 65°F	Quart	12
SMR-75	SPEEDO ACTIVATOR Medium	65°F - 75°F	Quart	12
SMR-85	SPEEDO ACTIVATOR Slow	75°F - 85°F	Quart	12
SMR-95	SPEEDO ACTIVATOR X-Slow	85°F - up	Quart	12

MIX RATIO:

SMR-102 is activated with SMR-60,SMR-75,SMR-85,SMR-95 (Speedo Activator) at a 4:1 ratio.

4 Parts	High Gloss Fast Cure 90 Minute Clearcoat
1 Part	SPEEDO ACTIVATOR

BASECOAT:

Can be applied over any urethane compatible basecoat. Please follow the basecoat manufacture's recommended clearcoat dry times. To increase Basecoat adhesion to substrate and/or clearcoat, add 5% SMR-600 Speedo Basecoat Activator to mixed basecoat prior to application.

GUN SETUP

	Fluid Tip	psi
HVLP Gravity	1.3 – 1.4mm	8-10 psi
Conventional Gravity Feed	1.3 – 1.4mm	40-45 psi

APPLICATION

Apply two wet coats of SMR-102 Clearcoat
Allow 5 minutes flash between coats.

DRY TIMES

Air Dry	
Flash Between Coats	5 minutes
Dust Free	2-5 minutes
Air Dry	1 ½ - 2 Hours
Express Dry	
Flash Between Coats	5 minutes
Flash Before Force Dry	0 minutes
Bake Time	10 minutes @120°F

RECOATABILITY/REPAIR

Fast Cure 90 Minute Clearcoat may be recoated for repair. After 2 hour 90° F or 3 hours @ 70° F air dry

SANDING/COMPOUNDING/POLISHING

Optimum Times		
Express Dry	After cool down	
Air Dry	1 ½ - 2 Hours	
Sanding		
Express Dry	After cool down	Light de-nib: 2000 grit wet
Air Dry	1 ½ - 2 Hours	Light de-nib: 2000 grit wet
Compounding		
Express Dry	After cool down	Foam compound pad (recommended)
Air Dry	1 ½ - 2 Hours	Foam compound pad (recommended)
Polishing		
Express Dry	After cool down	Foam polishing pad (recommended)
Air Dry	1 ½ - 2 Hours	Foam polishing pad (recommended)

VOC INFORMATION

Coating Category: Gloss Clear

	Regulatory VOC	Regulatory VOC	Actual VOC	Actual VOC	Volatile Wt.	Water Wt.	Exempt Compounds	Density
	lbs/gal	g/l	lbs/gal	g/l	%	%	%	g/l
SMR-102	4.37	523	3.47	416	63.05	0	17.7	917
SMR-60	3.8	455	3.8	455	46.8	0	0	972
SMR-75	3.8	455	3.8	455	46.8	0	0	972
SMR-85	3.8	455	3.8	455	46.6	0	0	977
SMR-95	3.8	455	3.8	455	46.4	0	0	980
Mixed VOC (4:1)								
SMR-102 w/ SMR-75	4.23	507	3.54	424	59.6	0	14	927

Health and Safety:

See Safety Data Sheet and labels for additional safety information and handling instructions.

- * The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDS's of all components, since the mixture will have the hazards of all its parts.
- * Improper handling and use, for example, poor spray technique, inadequate engineering controls and or lack of Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- * Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- * Provide adequate ventilation for health and fire hazard control.
- * Follow company, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- * Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- * Always observe all applicable precautions and follow good safety and hygiene practices.
- * Safety Data Sheets are available at www.speedokote.com. **FOR PROFESSIONAL USE ONLY**