





Metacryl 7381 2.1 VOC Fleet Clearcoat



COMPONENTS

7381 2.1 VOC Fleet Clearcoat
7360, 7361, 7362 Hardener
7370, 7371, 7372 or use only
7373 Reducer to achieve 2.1 VOC



APPLICATION

2 medium coats in cross-coat fashion or 1 medium coat
5-10 minute flash time between coats




MIX RATIO

2 : 1 : 1




DRY TIME

Hand Slick: 5 – 10 Minutes
Dust Free: 30 Minutes
Dry to Polish: 8 Hours
Dry to Handle: Overnight



VISCOSITY

ZAHN #2
20 – 22 Seconds



VOC

2.1 lbs/gal
251 g/L



GENERAL

DESCRIPTION

Metacryl 7381 2.1 VOC Fleet Clearcoat is an excellent choice for use on multi-panel and overall refinishing. 7381 is designed to offer the versatility of use as either a standard two coat clear with flash or single cross-coat without flash. For use over Metacryl basecoats and single stage colors.

COMPATIBLE SUBSTRATES

- Metacryl FN, FZ, FH, FL, 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 7381 2.1 VOC Fleet Clearcoat to 1 part 7360, 7361, or 7362 Hardener to 1 part 7370, 7371, 7372 or 7373 Reducer.

Component	Volume
Metacryl 7381 2.1 VOC Fleet Clearcoat	2
Metacryl 7360, 7361 or 7362 Hardener	1
Metacryl 7370, 7371, 7372 or 7373 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



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 2 medium coats in cross-coat fashion, or spray one medium coat, allow a 5 –10 minute flash time followed by a second medium coat. Can be used as an integrating clear in single stage color. Reduce and catalyze 7381 and single stage color as normal. Mix 7381 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	5 – 10 Minutes
Dust Free	30 Minutes
To Polish	8 Hours
To Handle	Overnight
IR Cure	20 Minutes at 170°F/77°C
Force Dry Time	40 Minutes at 140°F/60°C
To Sand/Buff	After Cool Down (1 – 2hrs)

FORCE DRY

Bake 40 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 (Using 7373)	2.1 lbs/gallon
RTS VOC (Using 7370/7371/7372)	3.6 lbs/gallon
RTS Volume Solids	43.0%
ZAHN #2 Viscosity	20 – 22 Seconds
DFT per Coat	Approximately 1.2 mil
Theoretical Coverage	Approx. 688 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 251 grams/liter | 2.1 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
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