

**PS-3250****2.1 VOC European Universal Clearcoat****DESCRIPTION**

PS-3250 is a crystal clear acrylic urethane clearcoat designed for 1-3 panel applications. This clearcoat is compliant in all 50 states as well as Canada. This clear sprays and levels easily and has excellent gloss retention and durability. PS-3250 can be air or forced dried and is a two-full wet coat system.

**TECHNICAL PRODUCT INFORMATION**

- |                            |                         |
|----------------------------|-------------------------|
| • Percent Solids by weight | 40.7%                   |
| • Usable Pot Life          | 1 hour @ 68°F-75°F      |
| • Dry Film Thickness       | 1 mil per coat (D.F.T.) |
| • Shelf Life               | One Year (unopened)     |

**PACKAGING**

- |               |                             |           |        |
|---------------|-----------------------------|-----------|--------|
| • PS-3250     | 2.1 VOC Universal Clearcoat | 5 Liter   | 2/case |
| • PS-3214-2.5 | Clearcoat Activator Fast    | 2.5 Liter | 2/case |
| • PS-3215-2.5 | Clearcoat Activator Medium  | 2.5 Liter | 2/case |
| • PS-3216-2.5 | Clearcoat Activator Slow    | 2.5 Liter | 2/case |

**MIX RATIO**

- |           |  |
|-----------|--|
| • 2 Parts | 2.1 VOC Urethane Clearcoat                       |
| • 1 Part  | PS-3214, PS-3215, or PS-3216 Clearcoat Activator |

**BASECOAT**

- All Acrylic and polyester Basecoat Color Systems that have been catalyzed with basecoat activator.

**GUN SETUP**

- |        |             |                |
|--------|-------------|----------------|
| • HVLP | 1.3mm-1.4mm | 8-10 psi @ gun |
|--------|-------------|----------------|

**APPLICATION**

- Apply 2 full wet coats

**DRY TIMES**

- |                        |                     |
|------------------------|---------------------|
| • Air dry              |                     |
| Flash between coats    | 5-10 minutes        |
| Dust free              | 15 minutes          |
| Air dry                | 8-12 hours @ 75° F  |
| • Express dry          |                     |
| Flash between coats:   | 5-10 minutes        |
| Flash before force dry | 10 minutes          |
| Cycle time             | 30 minutes @ 130° F |

**BLENDING**

Carefully taper second coat of clear beyond the first. After the final coat of clear, step out the coating by mixing 1 part Blending Clear to 1 part of remaining clear and taper the blend with the resulting mixture.

After the final coat of clear has been blended with the mixture of Blending Clear, further reduce the mixture and use the same gun to finish melting in the edge.

**RECOATABILITY / REPAIR**

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PS-3250 Clearcoat may be recoated for repair. After cool down when baked.  
Air dry repair next day. If recoating after 24 hours, scuff with 1000 grit paper.

**SANDING, COMPOUNDING, POLISHING**

- Optimum times
  - Express Dry                      After cool down
  - Air Dry                              8-12 hours
- Sanding
  - For dirt removal, lightly nib sand with 1500 grit wet paper and compound.
  - For best results compound within 24 hours of application.
- Compounding
  - Using a finishing compound apply a thin ribbon of material to area to be polished. Use a foam polishing pad. Maintain buffer speed at 1200-2000 rpm. Remove excess compound with clean soft cloth before applying polish.
- Polishing
  - Using a finishing polish and foam polishing pad apply a ribbon of material to work a 2-3 foot square area. Maintain buffer speed at 1000-1600 rpm. Keep buffer moving at all times overlapping approximately 50% each pass. Wipe off excess polish with clean soft cloth. Hand buff with clean soft cloth as a finishing touch.

**HEALTH & 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.performerseries.com](http://www.performerseries.com)