

High solid clear formulated to offer the versatility of three activators for spot, panel and overall repair. It will produce a high gloss fast dry finish with easy buffing that will perform with most basecoat systems.

PRODUCT	SIZE	ACTIVATOR	
PF 451	5 L (1.3 U.S. Gallons)	PF 451F Fast	2.5 L (0.7 U.S. Gallon)
		PF 451M Medium	2.5 L (0.7 U.S. Gallon)
		PF 451S Slow	2.5 L (0.7 U.S. Gallon)

READ ALL INSTRUCTIONS AND SAFETY PROCEDURES PRIOR TO USING!

IMPORTANT! This product contains hazardous materials.

Proper protective equipment should be used at all times. Please consult labels on each product as well as the safety data sheet for complete safe handling procedures and personal protection information.

NOTE: TEST ON A HIDDEN AREA BEFORE USING TO MAKE SURE THE PRODUCT PERFORMS TO YOUR SATISFACTION.

SUITABLE SUBSTRATES

- Automotive refinish basecoats (solvent based)
- Automotive refinish single stage (except acrylic lacquer)

ADVANTAGES

- High gloss
- Good flow out
- Easy buffing
- Good weather resistance

SURFACE PREPARATION:

Apply basecoat as per manufacturer's mixing and application instructions. Allow sufficient flash times before applying Clearcoat. Inadequate flash time will affect the performance of the product.

MIXING DIRECTIONS:



2 parts of clearcoat PF 451 : 1 part of activator PF 451F, PF 451M or PF 451S. Stir thoroughly between each addition. Strain before spraying material.

DIRECTIONS FOR USE:

All drying times refer to shop temperature of 20°C (68°F) / 50% humidity. Allow additional drying time when optimal conditions are not reached.

1. Read all label directions, warnings and cautions for safe usage.
2. Mix clearcoat and activator as per clearcoat manufacturer recommendations.
3. Stir thoroughly between each addition. Strain before spraying material.
4. Clean all spray equipment immediately after use as activated paints will harden in the equipment.
5. Keep cap closed at all times, exposure to atmosphere can affect performance of this product.

SPRAY GUN AND PRESSURE:

<i>Gun Type</i>	<i>Tip</i>	<i>Air Pressure</i>	<i>Gun Distance</i>
Siphon Feed	1.4-1.6 mm	34-45 psi	12-18 cm (5-7")
Gravity Feed	1.2-1.6 mm	25-35 psi	12-18 cm (5-7")
HVLP	1.2-1.6 mm	10 psi	12-18 cm (5-7")

Apply 2 full wet coats allowing 10 to 15 minutes flash time between coats or as conditions dictate. Caution: Do not apply over non catalyzed acrylic or synthetic enamels or acrylic lacquer finishes.

DRY TIMES:

	PF 451F Fast	PF 451M Medium	PF 451S Slow
Dry to Touch:	10-15 minutes	10-15 minutes	15-20 minutes
Tack Free:	45-50 minutes	50-60 minutes	1-1.25 hours
Dry Through:	1-1.25 hours	1.5-2 hours	2-2.25 hours
Flash:	5-10 minutes	5-10 minutes	10-15 minutes
To Sand:	5-6 hours	5-6 hours	6-7 hours
To Buff:	5-6 hours	5-6 hours	6-7 hours
To Deliver:	Overnight	Overnight	Overnight
Pot Life:	1 hour	1.5 hours	1.5 hours

Note: Pot life will shorten as temperatures increase. Products are not recommended for use in temperature below 60°F(16°C).

FORCE DRYING:	Let the last coat flash for 20 minutes before baking. Bake at 60°C (140°F) for 20 minutes. Clearcoat may be wet sanded and buffed after 1 hour cool down time.
RECOATING:	Clearcoat may be recoated after a 8 hour dry or upon cool down after force drying at 60°C (140°F). After 1 week, clear must be sanded before recoating.
FISH EYE:	The use of fish eye eliminator is not recommended.
ACCELERATOR:	Use up to ½ fluid ounce of PF 655 Super Kick Accelerator per sprayable quart. The addition of Accelerator will reduce cure times and pot life by 50%.
CLEANING INSTRUCTIONS:	Clean equipment with lacquer thinner immediately after use.

CAUTION: It is important to test the compatibility of this product with your paint system. This product is not recommended for use in temperatures below 16°C (60°F). The use below these temperatures will affect dry times and performance.

TECHNICAL DATA:

Appearance:	Clear
Resin Type:	Acrylic Urethane
Reduction:	Up to maximum 10% Urethane Reducer
Flex Additive:	Not required
Film Build:	Maximum 6 mils wet, 2-2.5 mils dry

	PF 451F Fast	PF 451M Medium	PF 451S Slow
Weight Solids (R.T.S.):	41.95%	42.12%	41.12%
Volume Solids (R.T.S.):	39.08%	39.22%	38.98%
VOC (R.T.S.):	2.00 lbs/usg • 239.66 g/L	2.01 lbs/usg • 240.85 g/L	2.01 lbs/usg • 240.85 g/L
Mixed Viscosity:	14" Zahn#2	13.5" Zahn#2	14" Zahn#2
Coverage @ sq.ft/gal:	627	629	625

PRECAUTIONARY INFORMATION

Refer to product label and Safety Data Sheet for health and safety information before using this product.

SAFETY CONSIDERATION

Safety Data Sheets are available at www.proformproducts.com or upon request at info@proformproducts.com. These are provided to help our customers satisfy their own handling, safety and disposal needs, and those required by local applicable health and safety regulations. Our Safety data sheets are updated regularly, therefore, please review the most current Safety Data Sheet before handling or using any product.

TECHNICAL INFORMATION

The technical information, recommendations and other statements contained in this document are based upon tests or experience that Pro Form believes are reliable, but the accuracy or completeness of such information is not guaranteed.

PRODUCT USE

Many factors beyond Pro Form’s control and uniquely within user’s knowledge and control can affect the use and performance of a Pro Form product in a particular application. Given the variety of factors that can affect the use and performance of a Pro Form product, user is solely responsible for evaluating the Pro Form product and determining whether it is fit for a particular purpose and suitable for user’s method of application.

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