



AUTOMOTIVE SPECIALTIES

1-800-822-4100

FAX 1-800-344-4461

www.crestauto.com

CREST REFINISHING

SYSTEM

TECHNICAL DATA

12/1/17

PREPARED BY:

CREST EAST COAST INC.

732-458-9000

06.14.19

CREST REFINISHING SYSTEM

HIGH SOLIDS - CALIBER CLEARS

CALIBER 50



ALL ABOUT CREST
PERCENT SOLIDS: 49%
HIGH QUALITY RESIN EXCELLENT UV PROTECTION

2 : 1 MIX RATIO

**RAPID CURE / HIGH SOLIDS
EURO PRODUCTION CLEAR**
Stock #: BCC50

CALIBER 41



PERCENT SOLIDS: 42%
HIGH QUALITY RESIN EXCELLENT UV PROTECTION

4 : 1 MIX RATIO

**HIGH SOLIDS \ HIGH GLOSS
OVERALL BAKE BOOTH CLEAR**
Stock #: BCC

HEAT CURING - Allow last coat to flash 10 - 15 minutes, then bake at 140°F / 60°C for 30 minutes. Allow one hour to cool down before buffing.

CALIBER 38 Special



PERCENT SOLIDS: 39%
HIGH QUALITY RESIN EXCELLENT UV PROTECTION

4 : 1 MIX RATIO

**O.E.M. APPEARANCE PRODUCTION
COLLISION CLEAR**
Stock #: BCC38

CALIBER LINE 9MM



PERCENT SOLIDS: 37%
HIGH QUALITY RESIN EXCELLENT UV PROTECTION

4 : 1 MIX RATIO

**UNIVERSAL HIGH VOLUME
PRODUCTION CLEAR**
Stock #: BCC9MM

CALIBER ACTIVATORS

Stock #: BCCA60



FAST SPEED ACTIVATOR
60°F—70°F TEMP RANGE

FLASH TIME	4 - 8 min
DUST FREE	12-15 min.
SAND / BUFF	1.5 - 2 hours
DELIVER	3 hours

Stock #: BCCA70



MEDIUM SPEED ACT.
70°F—80°F TEMP RANGE

FLASH TIME	5 - 10 min
DUST FREE	15 - 20 min.
SAND / BUFF	2 - 3 hours
DELIVER	3 - 4 hours

Stock #: BCCA80 + 90



SLOW SPEED ACTIVATOR
80°F + 90 TEMP RANGE

FLASH TIME	10 - 15 min
DUST FREE	25 - 35 min.
SAND / BUFF	2 - 3 hours
DELIVER	3 - 4 hours

Stock #: BCCA60



FAST SPEED ACTIVATOR
60°F—70°F TEMP RANGE

FLASH TIME	10 - 15 min
DUST FREE	20 - 30 min.
SAND / BUFF	8 hours
DELIVER	16+ hours

Stock #: BCCA70



MEDIUM SPEED ACT.
70°F—80°F TEMP RANGE

FLASH TIME	10 - 15 min
DUST FREE	25 - 35 min.
SAND / BUFF	8 hours
DELIVER	16+ hours

Stock #: BCCA80 + 90



SLOW SPEED ACTIVATOR
80°F + 90 TEMP RANGE

FLASH TIME	10 - 15 min
DUST FREE	35 - 45 min.
SAND / BUFF	8 hours
DELIVER	16+ hours

Stock #: BCCA60



FAST SPEED ACTIVATOR
60°F—70°F TEMP RANGE

FLASH TIME	5 - 10 min
DUST FREE	10 - 15 min.
SAND / BUFF	8 hours
DELIVER	12+ hour

Stock #: BCCA70



MEDIUM SPEED ACT.
70°F—80°F TEMP RANGE

FLASH TIME	10 - 15 min
DUST FREE	15 - 20 min.
SAND / BUFF	8 hours
DELIVER	12+ hours

Stock #: BCCA80 + 90



SLOW SPEED ACTIVATOR
80°F + 90 TEMP RANGE

FLASH TIME	15 - 20 min
DUST FREE	20 - 25 min.
SAND / BUFF	8 hours
DELIVER	12+ hours

Stock #: BCCA60



FAST SPEED ACTIVATOR
60°F—70°F TEMP RANGE

FLASH TIME	5 - 10 min
DUST FREE	10 - 15 min.
SAND / BUFF	8 hours
DELIVER	12+ hour

Stock #: BCCA70



MEDIUM SPEED ACT.
70°F—80°F TEMP RANGE

FLASH TIME	10 - 15 min
DUST FREE	15 - 20 min.
SAND / BUFF	8 hours
DELIVER	12+ hours

Stock #: BCCA80 + 90



SLOW SPEED ACTIVATOR
80°F + 90 TEMP RANGE

FLASH TIME	15 - 20 min
DUST FREE	20 - 25 min.
SAND / BUFF	8 hours
DELIVER	12+ hours



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CREST REFINISHING SYSTEM

MEDIUM SOLIDS - HYPER CLEAR

HYPER CLEAR

PERCENT SOLIDS
35 %
HIGH QUALITY RESIN
EXCELLENT UV PROTECTION



4 : 1
MIX RATIO

UNIVERSAL HIGH PRODUCTION
ACRYLIC URETHANE CLEAR COAT
Stock #: BHC

HYPER ACTIVATORS

Stock #: BHCA65



FAST SPEED ACTIVATOR
65°F—75°F TEMP RANGE

Stock #: BHCA75



MEDIUM SPEED ACT.
75°F—85°F TEMP RANGE

Stock #: BHCA85



SLOW SPEED ACTIVATOR
85°F + TEMP RANGE

FLASH TIME	DUST FREE	SAND / BUFF	DELIVER
8 - 10 min	20 - 30 min.	3 - 4 hours	8 hours

MEDIUM SOLIDS - MACH1 - SUPER PRODUCTION CLEAR COAT

MACH 1+ CLEAR

PERCENT SOLIDS
36 %
HIGH QUALITY RESIN
EXCELLENT UV PROTECTION



NEW

4 : 1
MIX RATIO

30 MINUTE - SUPER PRODUCTION CLEAR

MACH1+ - 30 minute CLEAR

SUPER PRODUCTION - ONE ACTIVATOR
MEDIUM SOLIDS - URETHANE CLEAR COAT

- MACH 1+ is a SUPER-FAST curing, production clear for bumpers, spot repairs, cut-ins, jamb and single panel applications where a fast delivery is required.
 - Same Day delivery!
 - Two Coat Coverage
 - 4:1 Mix ratio
 - 30 Minute Sand / Buff (2 Coats @ 77°F, 50% R.H.)
 - MACH 1+ has excellent Flow and Gloss
- Mach 1+ Clear / Gallon # BCM1
Mach 1+ Activator / Quart # BAM1

FLASH TIME	DUST FREE	SAND / BUFF	DELIVER
1 min	10 min.	30 minutes	30 minutes

URETHANE HI-BUILD PRIMER / SURFACER

URE-PRIME 2



URE-PRIME 2 - Primer - Gallon # BUP2
URE-PRIME 2 - Activator - Quart # BUPA2

4 : 1
Primer Mix Ratio

4 : 1 : 1
Sealer Mix Ratio

EPOXY HI BUILD PRIMER / SEALER

Vers-E-Prime



VERSE - E - PRIME - Primer - Gallon # BVEP
VERSE - E - PRIME - Activator - Gallon # BVEPA

1 : 1
5 : 5
HIGH BUILD
1 : 1 : 10%
5 : 5 : 1
STANDARD
1 : 1 : 20%
5 : 5 : 2
SEALER

O.E.M. - PREMIUM UNIVERSAL REDUCERS



Fast, (Temperature Range 60° - 70°) # BUR-F
Medium, (Temperature Range 65° - 80°) # BUR-M
Slow, (Temperature Range 75° - 90°) # BUR-S

SOLVENTS

ACRYSOLV



PREP

HI SOLV



PRE-PAINT

SUPER SOLV



PLASTICS

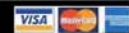


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URETECH SYSTEM UT²

HYPERCLEAR²



HIGH PERFORMANCE URETHANE
CLEARCOAT

Stock No. BH-C

A NEW ADVANCED TECHNOLOGY,
PREMIUM QUALITY, PRODUCTION
CLEAR FOR SPOT, PANEL, MULTI-
PANEL AND OVERALL REFINISHING

- **ULTRA SMOOTH FLOW OUT AND LEVELING**
- **2-COAT COVERAGE**
- **EXCELLENT DURABILITY / UV RESISTANT**
- **HIGH GLOSS AND DOI**
- **EZ BUFFING**
- **"USER FRIENDLY" TO SPRAY**
- **COMPATIBLE WITH ALL BASECOAT
MANUFACTURERS' PAINTS
(EXCEPT ACRYLIC LACQUER)**

Technical Data

MIX RATIO: 4:1 - 4 PARTS BH-C HYPERCLEAR², 1 PART HYPERCLEAR² ACTIVATOR
(BHCA-65 SPOT, BHCA-75 PANEL, BHCA-85 OVERALL)

POT LIFE: 5 HOURS (78°F / 25.6°C)

FLASH TIME: 8 – 10 MINUTES BETWEEN COATS (72°F / 22°C)

BUFF TIME: 3 – 4 HOURS (72°F / 22°C) WITH BHCA-65 ACTIVATOR

HEAT CURE: ALLOW LAST COAT TO FLASH 8 – 10 MINUTES, BAKE AT 140°F FOR
15 – 20 MINUTES. ONE HOUR COOL DOWN BEFORE BUFFING.

*DO NOT FLASH FOR MORE THAN 1 HOUR BETWEEN COATS. IF MORE THAN ONE HOUR AT 72°F / 22°C
IS REACHED, ALLOW AT LEAST 5 HOURS BEFORE APPLYING MORE CLEAR OR BASECOAT.*

VOC: 4.0 LBS./GALLON - READY TO SPRAY

SOLIDS: 35% (BY WEIGHT - READY TO SPRAY)

OPTIMUM DRIED FILM THICKNESS: 2.0 MILS

PHONE: 1-800-822-4100
5/2015

CREST INDUSTRIES, INC.
1337 KING ROAD
TRENTON, MI 48183
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WWW.CRESTAUTO.COM



Automotive Specialty Chemicals

Technical Data Sheet

CALIBER LINE 9MM

Universal High Volume
Acrylic Urethane Clear

STOCK NO. BCC-9mm
GALLONS



BCC-9mm is a two component, high volume, universal 4:1 production clear for spot, panel and overall refinish applications. Matches OEM appearance.

- 2-3 coat coverage / 2 mills minimum
- 4.20 V.O.C. – national rule compliant
- Compatible with waterborne basecoat, solvent borne basecoat, 2K enamel, OEM finish. NOT FOR ACRYLIC LACQUER.
- Fast curing
- EZ buffing

TECHNICAL DATA

Mix Ratio: 4 : 1 (4 Parts BCC-9mm to 1 Part Activator)

Activators: **Stock No. BCCA-60** – Fast Activator for 60° F – 70° F Temperature Range
Stock No. BCCA-70 – Medium Activator for 70° F – 80° F Temperature Range
Stock No. BCCA-80 – Slow Activator for 80° F – 90° F Temperature Range
Stock No. BCCA-90 – Extra Slow Activator for 90° F and Higher Temperature Range

Solids: 37% (By Weight, Ready-To-Spray)

V.O.C.: 4.20 lbs. per gallon, Ready-To-Spray

Pot Life: 3 Hours, Depending On Shop Temperature Conditions

Reduction: May Be Reduced Up To 10% with Crest Urethane Reducer (BURF-Fast, BURM-Medium or BURS-Slow).
 Note: Reducer will increase V.O.C.'s

Shelf Life: 1 Year (unopened)

Gun Set-Up: HVLP – 1.2 - 1.5 Tip / 10 psi at the cap. Conventional – 1.2 - 1.5 tip / 35 - 50 psi at gun.

Curing Timetable:	Activator	Flash Time	Dust Free	Sand/Buff	Deliver
BCC-9mm	BCCA-60	5-10 Minutes	10-15 Minutes	8 Hours	12+ Hours
BCC-9mm	BCCA-70	10-15 Minutes	15-20 Minutes	8 Hours	12+ Hours
BCC-9mm	BCCA-80	15-20 Minutes	20-25 Minutes	8 Hours	12+ Hours
BCC-9mm	BCCA-90	20-25 Minutes	25-30 Minutes	8 Hours	12+ Hours

Critical Re-Coat Time: Do not flash for more than 1 hour between coats. If more than 1 hour is reached, allow at least 5 hours before applying more clear or basecoat.

Heat Curing: Allow last coat to flash 10-15 minutes, then bake at 140° F for 30 minutes. Allow 1 hour cool down before buffing.

Crest Industries, Inc. 1337 King Road, Trenton, MI 48183 **800-822-4100** www.CrestAuto.com

11/17



Technical Data

Caliber 38 SPECIAL



**OEM Appearance
Acrylic Urethane Production Clearcoat**

**Stock No. BCC-38
(Gallons)**

A PREMIUM, USER FRIENDLY, 4:1 MIX RATIO, PRODUCTION CLEAR WITH THE RIGHT COMBINATION OF SOLIDS AND VISCOSITY FOR EASE OF APPLICATION AND OEM APPEARANCE.

- **TWO COAT COVERAGE**
- **4.20 V.O.C. - NATIONAL RULE COMPLIANT**
- **HIGH GLOSS / EXCELLENT D.O.I.**
- **FAST CURING**
- **E-Z BUFFING**

TECHNICAL DATA

Mix Ratio: 4:1 (4 Parts BCC-38 Caliber 38 Special to 1 Part Activator)
Activators: Stock No. BCCA-60 - Spot Activator, Fast Speed, for 60°F - 70°F (16°C - 21°C)
 Stock No. BCCA-70 - Panel Activator, Medium Speed, for 70°F - 80°F (21°C - 27°C)
 Stock No. BCCA-80 - Overall Activator, Slow Speed, for Multi-Panel / Overall Refinish, 80°F (27°C) +
Solids: 39% (By Weight, Ready-to-spray)
V.O.C.: 4.20 lbs. / Gallon - Ready-to-spray
Pot Life: 5 Hours - Depending on Shop Temperature Conditions
Reduction: May be reduced up to 10% with Urethane Grade Reducer, appropriate to Temperature Conditions. **NOTE:** Use of reducer will increase V.O.C.'s
Shelf Life: 1 Year (unopened)
Gun Set-up: HVLP - 1.2-1.5 Tip / 10 psi at the Cap. Conventional - 1.2-1.5 Tip / 35-50 psi at Gun.
Curing Timetable:

Activator	Flash Time*	Dust Free	Sand / Buff	Deliver
BCCA 60	5 - 10 min	10 - 15 min	8 hours	12+ hours
BCCA 70	10 - 15 min	15 - 20 min	8 hours	12+ hours
BCCA 80	15 - 20 min	20 - 25 min	8 hours	12+ hours

* Do not flash for more than 1 hour between coats. If more than one hour at 70°F (21°C) is reached, allow at least 5 hours before applying more clear or basecoat.
Heat Curing: Allow last coat to flash 10 - 15 minutes, then bake at 140°F / 60°C for 30 minutes. Allow one hour cool down before buffing.

November 15, 2017 (Updated)



Technical Data

Caliber 41

High Gloss Precision Acrylic
Urethane Clear Coat



Stock No. BC-C (Gallons)

A PREMIUM, HIGHER SOLIDS / HIGHER VISCOSITY, 4:1 MIX RATIO, ACRYLIC URETHANE CLEAR COAT WITH SUPERIOR FILM BUILD, OUTSTANDING GLOSS AND DISTINCTNESS OF IMAGE (D.O.I.).

- TWO COAT COVERAGE
- 4.14 V.O.C. - NATIONAL RULE COMPLIANT
- HIGH SOLIDS / PREMIUM RESINS FOR EXCELLENT SANDING / POLISHING CHARACTERISTICS
- COMPATIBLE WITH ALL BASECOAT MANUFACTURERS' PAINTS (NOT ACRYLIC LACQUER)
- EXTENDED OPEN TIME FOR MAXIMUM PERFORMANCE AT HIGHER TEMPERATURES, IN BAKE BOOTHS AND FOR "OVERALL REFINISH" APPLICATIONS

TECHNICAL DATA

Mix Ratio: 4:1 (4 Parts BC-C Caliber 41 to 1 Part Activator)

Activators: Stock No. BCCA-60 - Spot Activator, Fast Speed, for 60°F - 70°F (16°C - 21°C)

Stock No. BCCA-70 - Panel Activator, Medium Speed, for 70°F - 80°F (21°C - 27°C)

Stock No. BCCA-80 - Overall Activator, Slow Speed, for Multi-Panel / Overall Refinish, 80°F (27°C) +

Solids: 42% (By Weight, Ready-to-Spray)

V.O.C.: 4.14 lbs. / gallon - Ready-to-Spray

Pot Life: 4-5 Hours - Depending on Shop Temperature Conditions

Reduction: May be reduced up to 10% with Urethane Grade Reducer, appropriate to Temperature Conditions. **NOTE:** Use of reducer will increase V.O.C.'s

Shelf Life: 1 Year (unopened)

Gun Set-up: HVLP - 1.2-1.6 Tip / 10 psi at the Cap. Conventional - 1.2-1.6 Tip / 35-50 psi at Gun.

Curing Timetable:	Activator	Flash Time*	Dust Free	Sand / Buff	Deliver
	BCCA 60	10 - 15 min	20 - 30 min	8 hours	16+ hours
	BCCA 70	10 - 15 min	25 - 35 min	8 hours	16+ hours
	BCCA 80	10 - 15 min	35 - 45 min	8 hours	16+ hours

* Do not flash for more than 1 hour between coats. If more than one hour at 70°F (21°C) is reached, allow at least 5 hours before applying more clear or basecoat.

Heat Curing: Allow last coat to flash 10 - 15 minutes, then bake at 140°F / 60°C for 30 minutes. Allow one hour cool down before buffing.

November 15, 2017 (Updated)



TECHNICAL DATA CALIBER 50

FULL AUTO



**Rapid Cure / High Solids
Acrylic Urethane Clearcoat**

Stock No. BCC-50

A PREMIUM, HIGH-SOLIDS, 2:1 MIX RATIO, ACRYLIC URETHANE PRODUCTION CLEARCOAT. PROVIDES OUTSTANDING FILM BUILD, GLOSS AND D.O.I. (DISTINCTNESS OF IMAGE). WITH THIS CLEAR, YOU CAN PAINT AND DELIVER A CAR IN THE SAME DAY!

- **TWO COAT COVERAGE**
- **3.5 V.O.C. - READY-TO-SPRAY
(NATIONAL RULE COMPLIANT)**
- **PRODUCTION CLEAR FOR SPOT, PANEL AND OVERALL
REFINISH APPLICATIONS**
- **COMPATIBLE WITH ALL BASECOAT MANUFACTURERS'
PAINTS, INCLUDING WATERBORNE.
NOT FOR ACRYLIC LACQUER.**

TECHNICAL DATA

MIX RATIO: 2:1 (2 PARTS BCC-50 CALIBER 50 TO 1 PART ACTIVATOR)

**ACTIVATORS: STOCK No. BCCA-60 - FAST SPEED, FOR 60°F - 70°F (16°C - 21°C)
STOCK No. BCCA-70 - MEDIUM SPEED, FOR 70°F - 80°F (21°C - 27°C)
STOCK No. BCCA-80 - SLOW SPEED, FOR 80°F (27°C) AND ABOVE**

SOLIDS: 49% (BY WEIGHT, READY-TO-SPRAY)

COVERAGE: 672 SQ. FT. PER GALLON @ 1 MIL DRY FILM THICKNESS

V.O.C.: 3.5 LBS. / GALLON, READY-TO-SPRAY

POT LIFE: 2 HOURS - DEPENDING ON SHOP TEMPERATURE CONDITIONS

REDUCTION: MAY BE REDUCED UP TO 10% WITH URETHANE GRADE REDUCER.

NOTE: USE OF REDUCER WILL INCREASE V.O.C.'s

SHELF LIFE: 1 YEAR (UNOPENED)

HVLP GUN SETUP: 1.2 - 1.4 MM FLUID TIP, 10 PSI MAX AT AIRCAP

CONVENTIONAL GUN SETUP: 1.3 - 1.6 MM FLUID TIP, 35 - 50 PSI

CURING TIMETABLE:

<u>ACTIVATOR</u>	<u>FLASH TIME*</u>	<u>DUST FREE</u>	<u>SAND / BUFF</u>	<u>DELIVER</u>
BCCA-60**	4 - 8 MIN	12 - 15 MIN	1.5 - 2 HOURS	3 HOURS
BCCA-70	5 - 10 MIN	15 - 20 MIN	2 - 3 HOURS	3 - 4 HOURS
BCCA-80	10 - 15 MIN	25 - 35 MIN	2 - 3 HOURS	3 - 4 HOURS

*** DO NOT FLASH FOR MORE THAN 30 MINUTES BETWEEN COATS. IF MORE THAN 30 MINUTES IS REACHED, ALLOW AT LEAST 3 HOURS BEFORE APPLYING MORE CLEAR OR BASECOAT. FOR TEMPERATURES ABOVE 85°F (29°C), DO NOT FLASH FOR MORE THAN 20 MINUTES BETWEEN COATS.**

HEAT CURING: BAKE FOR 15 MINUTES AT 140°F (60°C).

**** HEAT CURING NOT RECOMMENDED WITH BCCA-60 ACTIVATOR.**



Automotive Specialty Chemicals

Technical Data Sheet

MACH1+ CLEAR

**SUPER FAST 4:1
PRODUCTION CLEAR**

STOCK NO. BC-M1



Mach 1+ is a super-fast curing 4:1 production clear for spot repairs, door jambs, cut-in and panel applications.

May be sanded, buffed and delivered in as little as 30 minutes. Perfect for jobs that need to go in one day, such as rental cars, bumper repairs, etc...

- One double coat application (down and back with no flash time)
- 2.1 V.O.C. (50 state compliant)
- Compatible with waterborne basecoat, solvent borne basecoat, 2k enamel, OEM finish. NOT FOR ACRYLIC LACQUER
- Super-Fast Curing for 30 minute buff/delivery times

TECHNICAL DATA

- Mix Ratio:** 4 : 1 (4 parts **BCM1-Mach 1+ Clear** to 1 part **BAM1-Mach 1+ Activator**)
- Activators:** Only one activator is used in Mach 1+ for all temperature conditions (**Stock No. BAM1-Mach 1+ Activator**)
- Solids:** 36% (By weight, ready-to-spray)
- V.O.C.:** 2.1 lbs. per gallon (ready-to-spray)
- Pot Life:** 2 hours @ 70 °F / 21 °C and 50% relative humidity
- Reduction:** DO NOT REDUCE
- Shelf Life:** 1 Year (unopened)
- Gun Set-Up:** HVLP – 1.2 - 1.4 fluid tip / 10 psi at the air cap. Conventional – 1.2 - 1.6 fluid tip / 25 - 35 psi at Gun inlet.
- Mil Thickness:** 1 double coat (2.0 mils @ 1 mil per pass)

Curing Timetable:	Activator	Flash Time	Dust Free	Sand/Buf	Deliver
BCM1	BAM1	N/A	10 Minutes	30 Minutes	30 Minutes

Critical Re-Coat Time: Do not apply additional coats above and beyond the application instructions. If additional coats are necessary, wait at least 5 hours before applying more Basecoat or clear. Scuff surface and degrease before application.

Heat Curing: Do not heat cure. Heat curing will result in solvent popping or blushing.

Crest Industries, Inc. 1337 King Road, Trenton, MI 48183 **800-822-4100** www.CrestAuto.com

12/17



URETECH SYSTEM UT²

URE PRIME²



**HIGH PERFORMANCE ACRYLIC URETHANE
PRIMER-SURFACER**

STOCK No. BU-P2

**A PREMIUM QUALITY, HIGH BUILD, 2K
PRIMER-SURFACER THAT PROVIDES
OUTSTANDING RESULTS OVER A WIDE
RANGE OF APPLICATIONS FROM SPOT
REPAIR TO OVERALL REFINISH**

NOW IN GALLONS !

- **EXCELLENT FILM BUILD / TOP COAT HOLDOUT**
- **ADHESION PROMOTERS AND CORROSION
INHIBITORS FOR BARE METAL APPLICATION**
- **FAST, DRY-TO-SAND IN 1-1½ HOURS**
- **EZ SANDING - WON'T LOAD PAPER**
- **MULTI-SURFACE ADHESION**
- **NEUTRAL - LIGHT GRAY COLOR**

TECHNICAL DATA

COLOR: LIGHT GRAY
MIX RATIO: 4:1 4 PARTS BU-P2 URE PRIME²
 1 PART BU-PA2 ACTIVATOR
POT LIFE: 2 HOURS (75°F, 50% RH)
DRY-TO-SAND: 1-1½ HOURS (75°F, 50% RH)
VOC: 4.78 LBS./GALLON (READY TO SPRAY)
SOLIDS: 54.7% (BY WEIGHT - READY TO SPRAY)
OPTIMUM DRIED FILM THICKNESS: 3 MILS (SANDED)

**PHONE: 1-800-822-4100
9/06**

**CREST INDUSTRIES, INC.
1337 KING ROAD
TRENTON, MI 48183
FAX: 1-800-344-4461**

WWW.CRESTAUTO.COM



Technical Data

Universal Urethane Reducers



Stock No. BUR-F	Fast Speed
(Temperature Range	60°F - 70°F)
Stock No. BUR-M	Medium Speed
(Temperature Range	65°F - 80°F)
Stock No. BUR-S	Slow Speed
(Temperature Range	75°F - 90°F)

- **COMPATIBLE WITH 2K URETHANE PRIMERS AND CLEARCOATS**
- **ALL VIRGIN SOLVENTS (NOT RECYCLED)**
- **ALCOHOL FREE**
- **MOISTURE FREE**



Mix Ratios in Grams for Caliber Clears

CALIBER 38 (BCC-38)		CALIBER 41 (BCC)		CALIBER 50 (BCC-50)		Caliber Line 9MM (BCC-9MM)					
Total weight per gallon of each component (grams per gallon)		Total weight per gallon of each component (grams per gallon)		Total weight per gallon of each component (grams per gallon)		Total weight per gallon of each component (grams per gallon)					
Mix Ratio	Caliber 38	Activator	Mix Ratio	Caliber 41	Activator	Mix Ratio	Caliber 50	Activator	Mix Ratio	9MM	Activator
4:1	3438	3765	4:1	3538	3765	2:1	3856	3765	4:1	3438	3765
Mix Ratio By Weight (grams)		Mix Ratio By Weight (grams)		Mix Ratio By Weight (grams)		Mix Ratio By Weight (grams)					
Mix Amount	Caliber 38	Activator	Total Weight of Mix	Mix Amount	Caliber 41	Activator	Total Weight of Mix	Mix Amount	Caliber 50	Activator	Total Weight of Mix
Gallon	2751	753	3504	Gallon	2830	753	3583	Gallon	2570	1255	3825
³ Quart	2063	565	2628	³ Quart	2123	565	2688	³ Quart	1928	941	2869
² Quart	1375	376	1752	² Quart	1415	376	1792	² Quart	1285	628	1913
¹ Quart	688	188	876	¹ Quart	708	188	896	¹ Quart	643	314	956
1 Pint	344	94	438	1 Pint	354	94	448	1 Pint	321	157	478
1/2 Pint	172	47	219	1/2 Pint	177	47	224	1/2 Pint	161	78	239



Mix Ratios in Grams for Hyperclear², Mach 1+, and 2K Primers

Hyperclear ² (BH-C)			Mach 1+ (BC-M1)			Ure Prime ² (BU-P2)			Vers-E-Prime (BV-EP)		
Total weight per gallon of each component (grams per gallon)			Total weight per gallon of each component (grams per gallon)			Total weight per gallon of each component (grams per gallon)			Total weight per gallon of each component (grams per gallon)		
Mix Ratio	Hyper-clear ²	Activator	Mix Ratio	Mach 1+	Activator	Mix Ratio	Ure Prime ²	Activator	Mix Ratio	Vers-E-Prime	Activator
4:1	3425	3828	4:1	4182	4273	4:1	4831	4001	1:1	5390	3234
Mix Ratio By Weight (grams)			Mix Ratio By Weight (grams)			Mix Ratio By Weight (grams)			Mix Ratio By Weight (grams)		
Mix Amount	Hyper-clear ²	Activator	Total Weight of Mix	Mix Amount	Mach 1+	Activator	Total Weight of Mix	Mix Amount	Ure Prime ²	Activator	Total Weight of Mix
Gallon	2740	766	3506	Gallon	3346	855	4201	Gallon	3865	800	4665
³ / ₄ Quart	2055	575	2630	³ / ₄ Quart	2509	641	3150	³ / ₄ Quart	2912	600	3512
² / ₄ Quart	1370	383	1753	² / ₄ Quart	1673	427	2100	² / ₄ Quart	1932	400	2332
¹ / ₄ Quart	685	192	877	¹ / ₄ Quart	836	214	1050	¹ / ₄ Quart	966	200	1166
1 Pint	343	96	439	1 Pint	418	107	525	1 Pint	483	97	580
¹ / ₂ Pint	171	48	219	¹ / ₂ Pint	209	53	262	¹ / ₂ Pint	242	50	292
Gallon	2695	1617	4312	Gallon	3346	855	4201	Gallon	3865	800	4665
³ / ₄ Quart	2021	1212	3233	³ / ₄ Quart	2509	641	3150	³ / ₄ Quart	2912	600	3512
² / ₄ Quart	1348	809	2157	² / ₄ Quart	1673	427	2100	² / ₄ Quart	1932	400	2332
¹ / ₄ Quart	674	404	1078	¹ / ₄ Quart	836	214	1050	¹ / ₄ Quart	966	200	1166
1 Pint	337	202	539	1 Pint	418	107	525	1 Pint	483	97	580
¹ / ₂ Pint	168	101	269	¹ / ₂ Pint	209	53	262	¹ / ₂ Pint	242	50	292

CLEARCOAT TROUBLESHOOTING CHART

CONDITION	DESCRIPTION	CAUSE	REPAIR	PREVENTION
FISH EYES	Craters / pits with raised edges	<ol style="list-style-type: none"> 1) Surface not thoroughly cleaned with a degreaser. 2) Contaminated air supply. 	<p><u>Minor</u> fish eyes: sand and buff. <u>Severe</u> fish eyes: sand flat, thoroughly degrease and respray.</p>	<ol style="list-style-type: none"> 1) Thoroughly clean surfaces with a degreaser before applying paint products. 2) Regular maintenance of air supply.
SOLVENT POP	Tiny bubbles in the paint surface	<ol style="list-style-type: none"> 1) Improper application of product. <ol style="list-style-type: none"> A) Product applied too heavily. B) Inadequate flash times between coats. 2) Incorrect mix ratio / viscosity. 3) Incorrect hardener / reducer for shop temperature. 	<p><u>Minor</u> pop can be sanded and buffed. <u>Severe</u> pop must be thoroughly sanded and repainted.</p>	<ol style="list-style-type: none"> 1) Allow adequate flash times. 2) Choose a suitable hardener / reducer for size of repair and booth temperature. 3) Check viscosity using a #2 Zahn viscosity cup.
ORANGE PEEL	Uneven surface texture resembling the peel of an orange	<ol style="list-style-type: none"> 1) Excessive distance between spray gun and vehicle surface. 2) Fast hardener / reducer used in high temperatures. 3) High spray viscosity. 	<p><u>Minor</u>: wet sand and buff. <u>Severe</u> peel: sand flat and respray.</p>	<ol style="list-style-type: none"> 1) Maintain a distance of 8 to 10 inches from surface. 2) Choose a suitable hardener / reducer for size of repairs and booth temperature. 3) Check viscosity using a #2 Zahn viscosity cup.
PINHOLES / PORES	Pin prick size holes	<ol style="list-style-type: none"> 1) Excessive film build with inadequate flash time before baking. 2) Pores in the body filler were not filled. 3) Contamination in materials. 	<p><u>Minor</u> holes: sand and respray. <u>Severe</u> pinholes: sand thoroughly, fill in pinholes with glazing putty and respray.</p>	<ol style="list-style-type: none"> 1) Allow proper flash times before baking. 2) Apply recommended film thickness. 3) Check for and fill pinholes in body filler before painting. 4) Use only high quality materials.

CLEARCOAT TROUBLESHOOTING CHART

CONDITION	DESCRIPTION	CAUSE	REPAIR	PREVENTION
MOTTLING	Uneven metallic orientation	<ol style="list-style-type: none"> 1) Excessively wet application of color coat. 2) Incorrect hardener / reducer for shop temperature. 3) Incorrect spray viscosity. 4) Incorrect spray pattern setting on gun. 	Sand and respray.	<ol style="list-style-type: none"> 1) Maintain a distance of 8 to 10 inches from surface. 2) Choose a suitable hardener / reducer for size of repair and booth temperature. 3) Properly adjust fan spray at gun to avoid uneven coverage.
LIFTING / WRINKLING	Wrinkled or rippled paint surface	<ol style="list-style-type: none"> 1) Product applied over a reversible substrate (non 2k coatings). 2) Primer / surfacer wasn't allowed to dry thoroughly before top coating. 3) Product applied in critical recoat time (window). 	<p>Minor lifting / wrinkling: sand flat and apply a water borne primer as an isolator, then respray.</p> <p>Severe lifting / wrinkling: strip affected panels and reapply paint system.</p>	<ol style="list-style-type: none"> 1) Apply a water borne primer as an isolator before coating with other paint products. 2) Allow adequate flash / dry time for primer / resurfacer. 3) Follow recoat instructions closely for all clears / primers.
DIE BACK / HAZING / LOSS OF GLOSS	Loss of gloss in top coat.	<ol style="list-style-type: none"> 1) Excessive film build of top coat. 2) Primer / surfacer wasn't allowed to dry thoroughly. 3) Inadequate (short) flash times. 4) Incorrect selection of activators and/or reducers. 	<p>Minor die back: buff to restore gloss.</p> <p>Severe die back: sand, respray.</p> <p>NOTE: If die back occurs due to trapped solvent, allow solvents to flash after sanding and then recoat.</p>	<ol style="list-style-type: none"> 1) Maintain a distance of 8 to 10 inches from surface. 2) Choose a suitable hardener / reducer for size of repair and booth temperature. 3) Check viscosity using a #2 Zahn viscosity cup. 4) Allow proper flash times between coats. 5) Use correct gun setup for top coat.
WATER BLISTERS	Blisters in paint finish.	<ol style="list-style-type: none"> 1) Water residue on surface before paint application. 2) Water contamination in air supply. 	Sand flat and respray.	<ol style="list-style-type: none"> 1) Thoroughly dry surface before paint application. 2) Regular maintenance of air supply, including air hose.

CLEARCOAT TROUBLESHOOTING CHART

CONDITION	DESCRIPTION	CAUSE	REPAIR	PREVENTION
BULL'S EYES / EDGE MAPPING / RING OUT / SAND SCRATCH SWELLING	Ring and/or raised scratches in top coat revealing repairs.	<ol style="list-style-type: none"> Poor feather edging of substrate. Body filler or primer / surfacer applied over a reversible substrate. Body filler under catalyzed. Primer / surfacer not fully cured before recoating. Excessive film build used to fill coarse sand scratches. Incorrect application of primer surfacer. 	<p><u>Minor</u> problem: sand and buff.</p> <p><u>Severe</u> problem: scuff, allow the finish to dry thoroughly, sand flat and respray.</p>	<ol style="list-style-type: none"> Feather edge until surface is smooth and flat. Use a water borne primer on reversible substrates as an isolator. Allow sufficient dry time for body filler and/or primer / surfacer. Use recommended grit of sand paper on substrates. Apply recommended product film thickness. Step out each additional coat of primer surfacer.
RUNS AND SAGS	Runs on vertical surfaces.	<ol style="list-style-type: none"> Excessive application of product. Incorrect distance between spray gun and surface. Slow hardener / reducer used in cold temperatures. Low spray viscosity. Ambient air temperature below 68 degrees. Incorrect (short) flash time between coats. Incorrect fan adjustment on gun. 	<p><u>Minor</u> runs / sags: sand and buff.</p> <p><u>Severe</u> runs / sags: sand flat and respray.</p>	<ol style="list-style-type: none"> Maintain a distance of 8 to 10 inches from surface. Choose a suitable hardener / reducer for size of booth repair and temperature. Check viscosity using a #2 Zahn viscosity cup. Raise shop / booth temperature. Allow proper flash time. Use correct fan spray adjustment at gun.

DIE BACK / Solvent Entrapment

CONDITION	DESCRIPTION	CAUSE	REPAIR	PREVENTION
DIE BACK / HAZING / LOSS OF GLOSS	Loss of gloss in top coat.	<ol style="list-style-type: none"> Excessive film build of top coat. Primer / surfacer wasn't allowed to dry thoroughly. Inadequate (short) flash times. Incorrect selection of activators and/or reducers. 	<p>Minor die back: buff to restore gloss.</p> <p>Severe die back: sand, respray.</p> <p><u>NOTE:</u> If die back occurs due to trapped solvent, allow solvents to flash after sanding and then recoat.</p>	<ol style="list-style-type: none"> Maintain a distance of 8 to 10 inches from surface. Choose a suitable hardener / reducer for size of repair and booth temperature. Check viscosity using a #2 Zahn viscosity cup. Allow proper flash times between coats. Use correct gun setup for top coat.

TROUBLE SHOOTING:

1. WHAT WAS THE SPRAY TEMPERATURE IN THE BOOTH?
2. WHAT WAS THE TEMPERATURE SPEED OF THE ACTIVATOR?
3. WHAT WAS THE FLASH TIME IN MINUTES BETWEEN COATS?
4. HOW MANY COATS WERE APPLIED?
5. WAS THE DIE BACK ONLY ON VERTICAL OR HORIZONTAL SURFACES OR BOTH?
6. WHAT WAS THE MIL THICKNESS IN THE DIE BACK AREA?
7. WERE THE UNDERCOATS COMPLETELY DRY? PROPER RECOMMENDED FLASH TIME?
(SOLVENT FREE) PRIMER?, SEALER? BASE COATS?
8. WAS THE HUMIDITY HIGH? RAINING OUTSIDE?
9. IS THE BOOTH FUNCTIONING PROPERLY? WATER IN THE AIR SUPPLY LINES? ETC.
10. WAS THE GUN USED TO SPRAY THE CLEAR COAT NEW? FAMILIAR?