General Information

KC2020 is a medium solids two component polyurethane clearcoat formulated to offer refinishers ease of application, very good flow and leveling, very good gloss and good distinctness of image in a productive 2K polyurethane clearcoat. KC2020 is compliant under current 2.1 VOC regulations in the United States.

1. Components

- KC2020 Low VOC Urethane Clearcoat
- KH2021 Medium Activator

2. Mixing Ratio

Mix four (4) parts KC2020 base with one (1) part KH2021 Activator by volume. Activator selection should be based on the size of the part to be painted and the temperature of both the air and part at time of painting.

3. Pot Life @ 77°F (25°C)

When properly covered at 77°F (25°C), KC2020 will maintain a sprayable viscosity for at least from 3-4 hours depending on activator selection.

4. Additives

- Accelerator: T566 up to 2% (max).
- Fish Eye: T152 Fish eye Eliminator up to 1% (max).

5. Surface Preparation

- Apply Undercoats and Basecoat per data sheet instructions. Over OEM or completely cured previously painted substrates scuff with a grey scuff pad or P800 grit then wipe clean with an approved solvent or water base wipe.
- Allow basecoat adequate flash time (follow manufacturer’s recommendation).
- Follow basecoat manufacturer’s recommendation for recoat intervals.

6. Application

Spray 2-3 medium-wet to wet coats. Overlap 50%.

Note: Do not spray when surface temperature is below 50°F (10°C).

7. Flash / Dry Times

**Air Dry @ 77°F (25°C)**

<table>
<thead>
<tr>
<th>Type</th>
<th>Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flash between coats</td>
<td>15-20 minutes</td>
</tr>
<tr>
<td>Dust Free</td>
<td>20-25 minutes</td>
</tr>
</tbody>
</table>

Sand and Buff

- KH2021 Activated
- Overnight

9. Flash / Dry Times (Continued)

**Force Dry with HPC0 and HPC1 Activator**

- Flash before Force Dry: 20 Minutes
- Force Dry Time: 45 Minutes @ 130°F (54°C)
- Sand and Buff: After Cool Down

**Force Dry with HPC2 and HPC3 Activator**

- Flash before Force Dry: 0 Minutes
- Force Dry Time: 15-20 Minutes @ 165°F (74°C)

10. Infrared Cure

See Infrared Curing Information.

11. Gun Setup

**Conventional Gun**

<table>
<thead>
<tr>
<th>Type</th>
<th>Tip Size (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gravity Feed</td>
<td>1.3 - 1.5</td>
</tr>
<tr>
<td>Siphon Feed</td>
<td>1.6 - 1.8</td>
</tr>
<tr>
<td>HVLP</td>
<td>1.3 - 1.5</td>
</tr>
</tbody>
</table>

**Air Pressures**

- Conventional @ Gun
  - Gravity Feed: 35-40 psi (2.5-2.8 bar)
  - Siphon Feed: 35-45 psi (2.5-3.1 bar)
  - HVLP Inlet Air: 30 psi (2.0 bar)

See spray gun manufacturer info.

12. Physical Data

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>VOC</td>
<td>2.1 lbs/gal.</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>35.3%</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>566 sq. ft. per mi/25 µm per gallon</td>
</tr>
<tr>
<td>Recommended DFT</td>
<td>1-4 mils/25-100 µm</td>
</tr>
<tr>
<td>Zahn #2 Viscosity (RTS)</td>
<td>19 - 21 Seconds</td>
</tr>
<tr>
<td>Din Cup #4 mm</td>
<td>16 - 18 Seconds</td>
</tr>
</tbody>
</table>