

2.1 VOC HIGH GLOSS CLEARCOAT

VOC: 250 g/l, 2.1 lb/gl



GENERAL INFORMATION

RC4221 HIGH GLOSS CLEARCOAT is a 2.1 VOC, two component clearcoat, offering refinishers an easy to apply clear with superior gloss.



1. COMPONENTS

- RC421 2.1 VOC
- RH4201 Hardener



2. MIXING RATIO

Mix four (4) parts RC4221 with one (1) part RH4201 (4:1).



3. POT LIFE @ 77°F (25°C)

4-6 hours, depending on activator selection.



4. CLEAN UP

KT025 (check local regulations).



5. SURFACE PREPARATION

FOR APPLICATION OVER RECOMMENDED BASECOAT SYSTEM.

- Allow basecoats sufficient dry times.
- Over OEM finish P800 or using gray scuff pad.



6. SUBSTRATES

- Commercially available solvent based basecoats
- Properly prepared previously painted substrates
- Properly cleaned and sanded OEM finishes



7. APPLICATION

Number of Coats: 3-4
 Application Density: Medium-wet to wet
 Overlap: 50%
 Flash: Follow recommendations in "Flash/Dry Times" section

Film Thickness Range:
 Dry: 1 mil - 6 mils/25 - 250 um
 Wet: 3 mil - 6 mils/75 - 250 um

Application Conditions:
 Min. Temp: 50°F/10°C (Substrate Temp.)
 Max. Temp: 100°F/38°C (Substrate Temp.)
 Ambient Humidity: Less than 80% preferred

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



8. FLASH / DRY TIMES

Ambient Application (Reported at 77°F/25°C and 80% Humidity)

	RH4201@ or above 85°F/30°C
Flash between coats	10-15 min.
Dust Free	15-20 min.
Sand/Polish	4-6 hours



8. FLASH / DRY TIMES (Continued)

Force Dry (Convection Heat)

	RH4201
Purge Time before applying heat	0 min.
Force Dry Time	20 min. @ 165°F/75°C
Sand & Buff	After Cool Down



9. GUN SET UP

CONVENTIONAL

Gravity Feed 1.3 mm - 1.4 mm

Siphon Feed 1.4 mm - 1.6 mm

HVLP

Gravity Feed 1.3 mm - 1.5 mm

AIR PRESSURES

Conventional @ Gun

Gravity Feed 30-40 psi (2.0-2.8 bar)

Siphon Feed 35-50 psi (2.5-3.4 bar)

HVLP Inlet Air 30 psi (2.0 bar)

See spray gun manufacturer info



10. PHYSICAL DATA

RTS REGULATORY DATA:	4:1 (No Reducer)	
	LBS./GAL	g/L
	Actual VOC	1.0 Max.
Regulatory VOC (less water & exempt solvents)	2.1 Max.	250 Max.
Density	9 - 10	1080 - 1200
	WT. %	VOL. %
Total Volatile Content	60 - 70	60 - 07
Water Content	0	0
Exempt Compound Content	50 - 60	45 - 55
Coating Category	Clearcoat	