



## TECHNICAL DATA SHEET & PROCESS GUIDE

# RAPID

SYSTEM

## 2:1 CLEARCOAT

RAPID SYSTEM CLEARCOAT, with unique new Rapid Cure Technology, is a high performance clearcoat that gives an exceptional high gloss 'just buffed' finish and cures in a fraction of the time compared to conventional clearcoats. It is easy to apply and significantly reduces cycle time, increasing productivity and reducing costs.

- Rapid Cure Technology - cured in 10 mins @ 140°F metal temperature
- Only one hardener required for all climates and conditions, reducing your stock investment
- Exceptional high gloss 'just buffed' finish\*
- Air dry, oven bake or IR
- Use with other RAPID SYSTEM products to increase job throughput from start to finish



### TECHNICAL DATA



Flash point	93°F (34°C)
Solid content	60% by weight and by volume
Specific gravity	Approx. 0.99
Pot Life	<u>20-40 mins @ 68°F (20°C)</u> dependent on heat and humidity

***This is a fast curing product so cleaning all equipment immediately after use with a cleaning solvent or thinner is imperative.***



VOC Information	As packaged regulatory VOC: 3.84 lb/gal (460 g/l) As applied regulatory VOC: 3.34 lb/gal (400 g/l)
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### SURFACE PREPARATION



#### Basecoat

Follow manufacturers application recommendations for drying.

## APPLICATION METHOD

### Mixing by volume



Mix 2 parts RAPID Clearcoat with 1 part RAPID Clearcoat Hardener

Reducer

Adding up to 5% reducer is recommended for ambient temperatures above 80°F and is optional for temperatures below 80°F.

UP2442

<60°F

UP2452

60°F - 75°F

UP2462

>75°F

*Accelerators and other additives not recommended.*



Viscosity

13-15 seconds DIN 4 cup at 70°F



Compliant HVLP/RP Spray gun set up

Gun tip size

1.2 - 1.3 mm recommended. 1.4mm optional.

Air Pressure at the gun

28 - 35 PSI (2.0 - 2.5 BAR)



Coats

Half coat followed by one full coat with 1 minute flash off between coats on single panels. No flash time necessary if spraying multiple panels.

Build / microns

1.6 – 2.0 MILs









Flash-off

5 - 10 mins before bake

## DRYING TIMES



 Through Dry @ 140°F metal temperature*	 Through Dry @ 70°F	 Through Dry with I.R.	 Tack free @ 70°F	 De-Nibbing	 Polishing
10 mins	65-85 mins	10 mins at 500mm (160°F, short wave)	20-25 mins	35-40 mins	70-90 mins

*All force dry times are quoted for the time after reaching the substrate temperature, based on standard application and spray booth conditions. Additional time must be allowed for the substrate to reach the recommended temperature.*

Tape Time	90 minutes @ 70°F
Recoat	Force dry: After cool down Air dry: 90 minutes @ 70°F

RAPID Clearcoat must be sanded before recoating with primer, color and/or clearcoat.

## SHELF LIFE & STORAGE



Shelf Life	1 year from date of manufacture in sealed original containers.
Storage	Store in cool, dry conditions in the original containers.
Opened cans of clear and hardener should be used within 1 month	

## ORDERING INFORMATION

Order Code	Format	Description
UP6501	1L Tin	RAPID SYSTEM 2:1 Clearcoat
UP6505	5L Tin	RAPID SYSTEM 2:1 Clearcoat
UP6600	1L Tin	RAPID SYSTEM 2:1 Clearcoat Hardener
UP6602	5L Tin	RAPID SYSTEM 2:1 Clearcoat Hardener



FOR PPE  
RECOMMENDATIONS  
REFER TO SDS

### IMPORTANT: FOR PROFESSIONAL USE ONLY. Read full instructions before use.

This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the safety data sheet for full handling instructions and personal protection information. U-POL disclaims any liability where the user does not wear the recommended personal protective equipment. The above data is for information only and may change without prior notice. It is the Buyers responsibility to ensure the suitability of the products for their own use and check the up-to-datedness of this information. The recommendation of use of our products and application are based on our knowledge and experience. Please refer to the label and consult the safety data sheet for full handling instructions and personal protection information. These are available via your local distributor or via the U-POL website at [www.u-pol.com](http://www.u-pol.com) is not responsible for the results obtained by others over whose methods we have no control and thereof U-POL is not liable for consequential or incidental damages including loss of profits.