

COMPLIANT COATING SYSTEM

2.1 VOC HIGH GLOSS CLEARCOAT RC4221

VOC: 250 9/l, 2.1 lb/gl Revision Date: 8-01-21



Date Issued 8-01-21

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

- RH4201 Hardener
- RC4221 2.1 VOC Clear

2. MIXING RATIO

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

3. POT LIFE @ 77°F (25°C)

1.5-2 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 / 2°5 Cand 80% Humidity)

	RH4201 at or above 85°F / 30°C
Flash between coats	10 - 15 min.
Dust Free	5 - 15 min.
Sand/Polish	6 - 8 hours

8. FLASH / DRYTIMES (Continued) Force Dry

Convection Heat	RH4201
Purge time before applying heat	10 min.
Force Dry Time	30 Min @ 140 F
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	gm/L
Actual VOC	1.0 Max.	125.7 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	

Restoration Shop

6695 Rasha Street, San Diego, CA 92121
(858) 909-2110