



TECHNICAL DATASHEET

CLEARWORX 4:1 (2.1 VOC)

ART. NO: # 190.001 (1G) & # 190.002 (1Qt.)

CLEARWORX 4:1 (2.1 VOC) is a premium, acrylic urethane clear designed for areas that have certain VOC limitations. It has excellent gloss retention, leveling and cure properties, and can be air dried or forced dried. Its simple 4:1 mix ratio makes this clear very easy to use and it can be applied over all acrylic and polyester color systems.

FEATURES

- ✓ Easy to use
- ✓ Excellent leveling
- ✓ Superb blending
- ✓ Excellent gloss Retention
- ✓ Can be applied to flexible parts
- ✓ Guaranteed performance

COMPATIBLE SURFACES

- ✓ Water & Solvent base coats
- ✓ Activated polyurethane enamel (must be cured at least 8 hours)
- ✓ Activated acrylic urethane enamel (must be cured at least 8 hours)
- ✓ OEM clear coats (must be sanded with P800)

CONDITIONS OF USE AND CONFORMITY

The before mentioned technical data and information, especially the recommendations for applying and using our products, are based on our current knowledge and experience when applied under normal conditions. In practice, the materials, surfaces or site conditions are so different that no warranty regarding the working results or liability, arising out of any relationship, can be inferred neither from this information nor from a verbal consultation, except we are charged with intent or gross negligence. In this case the user is obliged to prove that he has informed us about all points required for a proper and promising judgment in writing, in time and completely. Patent rights of any third party are to be observed. Furthermore, our general sales and delivery Terms and Conditions and the latest Technical Data Sheet, which should be demanded, apply.

HEALTH & SAFETY

See Safety Data Sheet and labels for additional safety information and handling instructions. Directions for handling and waste disposal are in our Material Safety Data Sheet and the specifications of the Employers Liability Insurance Association for the chemical industry. Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS. Always observe all applicable precautions and follow good safety and hygiene practices.

Product (Part A) VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
	g/L	LBS/GAL
Actual VOC	24.46	0.20
Regulatory VOC (less water & exempt solvents)	78.50	0.66
Density	1031	8.60
	WEIGHT %	VOLUME %
Total Solid Content	31%	30%
Total Volatile Content	69%	70%
Water	0%	0%
Exempt Compound Content	64%	63%

Hardener (Part B) VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
	g/L	LBS/GAL
Actual VOC	283.99 - 286.77	2.37 - 2.39
Regulatory VOC (less water & exempt solvents)	354.69 - 358.48	2.96 - 2.99
Density	1060 - 1070	8.84 - 8.93
	WEIGHT %	VOLUME %
Total Solid Content	48%	48%
Total Volatile Content	52%	52%
Water	0%	0%
Exempt Compound Content	25%	20%

RTS VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
Coating Category	Clear Coating	
Mixing Ratio	4:1	
	g/L	LBS/GAL
Actual VOC	76.36 - 76.9	0.63 - 0.64
Regulatory VOC (less water & exempt solvents)	186.53 - 187.95	1.55 - 1.57
Density	1036 - 1039	8.65 - 8.67
	WEIGHT %	VOLUME %
Total Solid Content	34%	33.6%
Total Volatile Content	66%	66%
Water	0%	0%
Exempt Compound Content	56%	54%

PRODUCT DATA

Dry Film Thickness / coat (DFT): 1.0

Coverage: 450 Sq. Ft. / gal @ 1 mil*

Shelf Life: 24 months

Package: 1 Gallon or 1 Quart

Number per case: 4(G) or 12(QT)

Safety Data Sheet (SDS) is available on our website

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HANDLING

MIXING

Make sure product is at room temperature 72°F (22.2°C) before mixing

4 Parts Clear: # 190.001 (1G)
190.002 (1QT)

1 Part Activator: # 191.001 (1QT) - Slow
191.002 (1QT) - Medium
191.003 (1QT) - Fast



POT LIFE

1 hour @ 68°F to 75°F



GUN SETUP

Conventional Gravity: 1.3mm - 1.6mm 35 - 45 psi @ gun

Siphon: 1.4mm - 1.8mm 35 - 45 psi @ gun

HVLP Gravity: 1.3mm - 1.4mm 8 - 10 psi @ gun

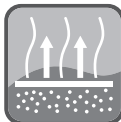


APPLICATION

1. Apply base coat color per recommended procedures
2. Apply 2 full wet coats with 5 - 10 minutes flash between coats

BLENDING

1. Apply first coat of clear coat
2. Extend second coat of clear past first coat
3. After the final coat of clear melt in the edge by applying a blending solvent



FLASH TIME

Between coats: 5 - 10 minutes

Before force dry: 10 minutes



DRY TIMES

Dust Free: 5 minutes depending on temperature and activator selection

Force Dry: 40 minutes @ 140°F (60°C)

Air Dry: 10 - 12 hours @ 75°F (23.9°C)

Time to decal: 24 hours

Time to deliver: 10 hours air dry or 1 hour after cool down when forced dry

SANDING & BUFFING

Optimum Times: **Force Dry:** 1 hour after cool down

Air Dry: 10 - 12 hours



Sanding:

Use 1500 grit or finer wet sandpaper or use a foam interface pad with P1500 grit or finer DA paper.



Polishing:

Using polishing foam pad apply a ribbon of material to work a 2-3 foot square area. Maintain buffer speed at 1500-2200 rpm. Keep buffer moving at all times overlapping approximately 50% each pass. Wipe off excess compound with clean soft cloth. Hand buff with clean soft cloth as a finishing touch.