

4.2 VOC HIGH GLOSS CLEARCOAT

VOC: 479 g/l, 4.2 lb/gl



GENERAL INFORMATION

RC4200 HIGH GLOSS CLEARCOAT is a 4.2 VOC, two component clearcoat, offering refinishers an easy to apply clear with superior gloss.



1. COMPONENTS

- RC4200 4.2 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:	5- 10 min or until surface is dull
Film Thickness Range:	
Dry	1 mil - 6 mils/25 - 250 µm
Wet	3 mils - 6 mils/75 - 250 µm
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	5-10 min.
Dust Free	10-15 min.
Sand/Polish	4-6 hours



8. FLASH / DRY TIMES (Continued)

Force Dry (Convection Heat)

	RH4201
Purge Time before applying heat	20 min.
Force Dry Time	20 min. @ 165°F/75°C
Sand and 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
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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 Reduction)	
	LBS./GAL	g/L
Actual VOC	4.0 Max.	479 Max.
Regulatory VOC (less water and exempt solvents)	4.2 Max.	504 Max.
Density	7 - 10	840 - 1200
	WT. %	VOL. %
Total Volatile Content	45 - 65	55 - 75
Water Content	0	0
Exempt Compound Content	5 - 25	5 - 25
Coating Category	Clearcoat	