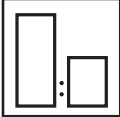



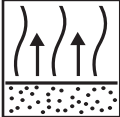





# 2.1 VOC CLEAR COAT

## 80-121

### APPLICATION DATA

	Mixing Ratio :	3 Parts 80-121 2.1 VOC Clear Coat 1 Part 80-190 Low VOC Hardener 10% Uni Thinner 1-141 / 1-151 / 1-161 / 1-171 OR 80-131 Production Additive or 80-132 Air Dry Production Additive (see table below for Technical Information)			
	RTS (Ready To Spray) Viscosity @ 20°C/70°F DIN Cup 4 mm :	Less than 15 sec.			
		:	<u>Spraygun Type</u>	<u>Nozzle diameter</u>	<u>Air Pressure</u>
			Gravity feed	1.3 - 1.4	30-35 psi (2.0-2.5 bar)
			Suction feed	1.4 - 1.6	40-45 psi (2.0-2.5 bar)
			HVLP/LVLP	1.3 - 1.4	inlet air 30 psi (2.0 bar)
	Flash-off :	Not stringing for two coat application No flash for 1/2 coat – full coat application			
	Film Thickness :	2 – 2.5 mils (50-60 µm) 2 full coats 2 mils (50 µm) on 1/2 coat – full coat			
	Drying :	<u>20°C/70°F Air Dry</u>	<u>Force Cure (booth Temp)</u>		
		8 hrs - Overnight	20-30 mins 65-71°C / 150-160°F		
	(Polish Times)	(8 hrs - Overnight)	(After Cool Down)		
		<b>****For faster air dry and bake times, see table below****</b>			
	Potlife @ 20°C/70°F :	Sprayable 60-90 minutes with Uni-Thinners Sprayable 30 minutes with 80-131 Production Additive Sprayable 20-30 minutes with 80-132 Production Additive			

**FOR FASTER APPLICATION, AIRDRY AND BAKE TIME, FOLLOW INSTRUCTIONS BELOW:**

- 3 Parts 80-121 2.1 VOC Clear Coat
- 1 Part 80-190 Low VOC Activator
- 10% Reduction with 80-131 Production Additive

**SMALL AND LARGE AREAS CAN BE DONE WITH THIS OPERATION.**

Below are 4 different types of applications. Choose the one that suits your needs.

FIRST COAT	FLASH TIME	SECOND COAT	FLASH TIME	CURE TIME	TIME TO POLISH
1/2 COAT	NO FLASH	1 FULL WET	5 MINS	BAKE 15-20 MIN @ 65-71°C / 140°F	AFTER COOL DOWN
1/2 COAT	NO FLASH	1 FULL WET		AIR DRY 4-5 HRS	4-5 HOURS
1 FULL WET	Not stringing	1 FULL WET	5 MINS	BAKE 15-20 MIN @ 65-71°C / 140°F	AFTER COOL DOWN
1 FULL WET	Not stringing	1 FULL WET		AIR DRY 4-5 HRS	AIR DRY 4-5 HRS

**FOR FASTER APPLICATION AND AIRDRY TIME, FOLLOW INSTRUCTIONS BELOW:**

- 3 Parts 80-121 2.1 VOC Clear Coat
- 1 Part 80-190 Low VOC Activator
- 5-10% Reduction with 80-132 Air Dry Production Additive

**SMALL AREAS SHOULD BE DONE WITH THIS OPERATION.**



# 2.1 VOC CLEAR COAT

## 80-121

Below are 2 different types of applications. Choose the one that suits your needs (AIR DRY ONLY).

FIRST COAT	FLASH TIME	SECOND COAT	FLASH TIME	CURE TIME	TIME TO POLISH
1/2 COAT	NO FLASH	1 FULL WET		AIR DRY 2-3 HRS	2-3 HOURS
1 FULL WET	5 MINS	1 FULL WET		AIR DRY 2-3 HRS	2-3 HOURS

**Field of application** : For application over 500 Series BeroBase and 900 Series Waterbase. High quality production clearcoat. Suitable for passenger cars.

**Chemical basis** : Polyurethane finish based on viscous hydroxyacrylic resins.

**General qualities** : High gloss clearcoat with bake and air dry capabilities. One activator with the adjustment of reducers for size of job and spray temperature. This product also has optional two production additives 80-131 and 80-132 to speed up application for bake and air dry times. Highly versatile clear coat.

**Auxiliary materials** : 80-190 Low VOC Hardener  
1-141 / 1-151 / 1-161 / 1-171 Uni Thinners  
80-131 Production Additive  
80-132 Air Dry Production Additive

**Physical properties**

Density (A)	9.80 lbs./gal.
Density (RTS)	9.70 lbs./gal.
VOC (A)	1.95 lbs./gal. max
VOC (RTS)	2.1 lbs./gal. max
VISC (RTS) DIN Cup 4mm	<15 seconds
Recommended DFT	2.0 – 2.5
% Volume Solids (RTS)	43.85
% Weight Solids (RTS)	42.75
Coverage	701.8 sq. ft/gal per mil
Flash Point (°C / °F)	18 / 64

**Gloss** : High gloss.

**Substrates** : 500 Series BeroBase and 900 Series Waterbase (as described in the preparation system)  
Degreased and sanded OEM or 2K finishes.

**Cleaning the Equipment** : Per local regulations

**Colour** : Clear.

**Storage life** : Under normal storage conditions (50 - 90°F/10 - 30°C) up to two years (unopened container)