	North America	Technical Data Sheet
	U-TECH HS21 Clearcoat™	
	Clearcoat 12/13/2016	
<b>FOR PROFESSIONAL USE ONLY</b>		

### Description

HS21 Clearcoat is a low VOC, two-component high-solids polyurethane clearcoat. Provides a high gloss finish with one wet coat plus cross coat or two full wet coats. Flow and leveling is achieved with minimum effort. A compliant VOC clearcoat with excellent sprayability properties. The HS21 Clearcoat can be used as a final clearcoat or as an integrated clearcoat with the U280 Single Stage. The ready to spray VOC is 2.1 lbs/gal.

### Suitable Surfaces

U280 Single Stage  
U350 Single Stage

Existing finishes in the case of spot or blend repair, degrease and sand with #P800 to #P1000 DA Properly degrease substrate prior to sanding with R859 wax and grease remover.

### Product and Additives

<b>Product</b>	HS21 Clearcoat	#399118	
<b>Hardener</b>	HS21 Activator	#399112	
	SuperTop	#393929	Accelerates dry times
	997 Enhancer	#398679	Pot life extender. Slows flash off, allowing better melt-in a high temperatures
<b>Additives</b>	LV Flex Additive	#398767	For flexible substrate application
	B92 Reducer LV SRA	#509407	Special solvent to dissolve fade out areas of spot repairs

### Basic Raw Material

HS21 Clearcoat	Hydroxyl acrylic resins
HS21 Activator	Polyisocyanate resin and solvent
LV Flex Additive	Special polyester resins

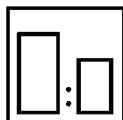
### Product Characteristics

WPG (a-component)	8.20 +/- 0.2 lbs/gal	Gloss	High
Volume Solids (RTS)	45 +/-2 %	Color	Clear
Theoretical Coverage	720 ft <sup>2</sup> /gal @ 1mil – 100%TE	Pot Life (no additives)	1 ½ hrs @ 70°F (21°C)
		Pot Life ( with Supertop)	1 hr @ 70°F (21°C)
		Pot Life (with 997 Enhancer)	2 ½ hrs @ 70°F (21°C)

### Mixing

Standard mix ratio (by volume)

4 HS21 Clearcoat  
1 HS21 Activator




Flexible Plastic Parts mix ratio (by volume)

100 HS21 Clearcoat  
15 LV Flex Additive

Then mix (by volume)

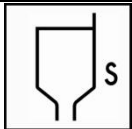
4 HS21 Clearcoat (Flexed)  
1 HS21 Activator

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Add a maximum of ½ oz of Supertop Accelerator per RTS gallon or 3 to 4 grams per RTS quart to speed up cure times  
 Add a maximum of 2oz of 997 Enhancer per RTS gallon or 12 – 14 grams per RTS quart to extend pot life and improve overspray melt-in

HS21 Clearcoat Flexed should be used in combination with flexed primers, sealers and topcoats  
**Note: Raw flexible plastic body parts require U-TECH Plastic Adhesion Promoter**

**Viscosity**



HS21 Clearcoat	18 – 24 sec 11 – 15 sec	EZ ZAHN #2 at 70°F (21°C) DIN #4 at 70°F (21°C)
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Viscosities are reported as Ready to Spray

**Spray gun set-up / application pressure**



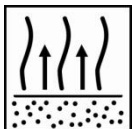
RP – Pressure Feed	0.8 – 1.4mm	30 – 36psi	12 – 16 oz/min
RP – Gravity Feed	1.3 – 1.4mm	30 – 35psi	
HVLP – Pressure	1.0 – 1.2mm	Max 10psi (caps)	12 – 16 oz/min
HVLP – Gravity Feed	1.4 – 1.5mm	Max 10psi (caps)	

**Application**



Apply one (1) wet coat followed by a cross coat (½) or apply two (2) full wet coats

**Flash off**




10 - 15 minutes at 70°F (21°C) between coats  
 10 – 15 minutes at 70°F (21°C) final flash before bake

**Dry times**



	No Additives		½ oz Supertop Accelerator per gal		2oz 997 Enhancer per gal	
	70°F (21°C)	140°F (60°C)	70°F (21°C)	140°F (60°C)	70°F (21°C)	140°F (60°C)
Dust Free	45 min	N.A.	5 min	N.A.	1 hr	N.A.
Dry to handle	10 hrs	45 min	4 hrs	25 min	10 hrs	45 min

Note: SuperTop will decrease pot life. Extreme temperatures may require higher amounts of 997. Using LV Flex will extend curing times and effect the sandability of HS21 Clearcoat

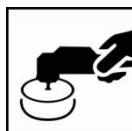
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#### Dry Film Thickness

2.0 – 2.5 mils

Apply 1.2 - 1.4 mils per coat

#### Polishing



Dust and minor damage can be polished out after stated dry times. If baking, allow cool down of the object to ambient temperature.

- Carefully de-nib out dust particles with #P1500 then #P2000 grit paper. Clean and dry the surface to be polished
- Mechanically polish area using quality rubbing compounds followed by polishing glaze

#### Recoatability

HS21 Clearcoat is recoatable with itself after full drying cycle. Sanding becomes necessary after 24 hours.

Striping or lettering on HS21 Clearcoat must be applied within 24 hours for good adhesion. Sanding becomes necessary after 24 hours.

Decals can be applied after 48 hours 70°F (21°C)

#### Cleaning of equipment

Clean equipment with extra strong cleaning solvents

#### VOC

HS21 Clearcoat	2.1 lb/gal	250 g/l
VOC is ready to spray at a mix ratio of 4:1		

#### Product Storage and Shelf Life

Store products unopened and used products with closed lids. Store products between 70°F-95°F (21°C-35°C). Optimal storage temperature is 77°F (25°C). Avoid extreme temperature fluctuation when storing.

HS21 Clearcoat	2 years
HS21 Activator	1 year
Supertop Accelerator	6 months
997 Enhancer	1 year
LV Flex Additive	1 year

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**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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