DI-21 2.1 VOC ACRYLIC CLEARCOAT

Technical Data Sheet

DESCRIPTION:

DI-21 2.1 V.O.C. Acrylic Clearcoat is a 4:1 mix ratio ultra low V.O.C. clear designed specially to meet the most stringent V.O.C. requirements. It sprays easily and has excellent leveling and gloss retention. It can be used as an air dry or bake system clearcoat. DI-21 2.1 V.O.C. Acrylic Clearcoat has excellent durability. This clearcoat utilizes a temperature control activator system. DI-21 2.1 V.O.C. Acrylic Clearcoat can be applied over any urethane or polyester basecoat system.

PACKAGING:

► DI-21/DI-21-Q	2.1 VOC Acrylic Urethane Clearcoat	1 Gallon/Quart
► DI-60/DI-60-8	Fast Clearcoat Activator	Quart/8 oz.
► DI-75/DI-75-8	Medium Clearcoat Activator	Quart/8 oz.
► DI-90/DI-90-8	Slow Clearcoat Activator	Quart/8 oz.

MIX RATIO:

► 4 Parts DI-21 2.1 VOC Acrylic Urethane Clearcoat
► 1 Part DI-60, DI-75, DI-90 Clearcoat Activator
Can be reduced up to 5% with Zero VOC Reducer
(Adding any other reducer will increase V.O.C.'s)

BASECOAT:

► All Acrylic and Polyester Basecoat Color Systems

GUN SETUP:

► Conventional Gravity 1.3mm-1.4mm 40-45 psi @ gun
► Siphon 1.3mm-1.4mm 40-45 psi @ gun
► HVLP 1.3mm-1.4mm 8-10 psi @ gun

APPLICATION:

► Apply 2 full wet coats

DRY TIMES:

► AIR DRY

Flash between coats	5-10 minutes
Dust Free	5-10 minutes
Air Dry	8-10 hours @ 75°F

► EXPRESS DRY

Flash between coats	5-10 minutes
Flash before force dry (Purge Time)	10-15 minutes
Cycle Time	40 minutes @ 140°F

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BLENDING:

- Apply first coat of clearcoat.
- Extend second coat of clear past first coat.
- Mix the remaining clearcoat 1:1 with blending solvent.
- Apply mixture over the edge of the clear with 50% overlap to melt in the edge.
- To further melt-in the remaining edge, apply 100% blending solvent with 50% overlap.

RECOATABILITY / REPAIR:

- Baked
  - After cool down
- Air Dry
  - 8-10 hours @ 75°F
  - *If recoating after 24 hours, scuff before applying clearcoat.

SANDING, COMPOUNDING, POLISHING:

- OPTIMUM TIMES
  - Express Dry: After cool down
  - Air Dry: 8-10 hours @ 75°F
- SANDING
  - For dirt removal, lightly denib sand with 1500 / 2000 grit wet sandpaper.
- COMPOUNDING
  - Using a finishing compound apply a thin ribbon of material to the area to be polished. Use a foam compounding or polishing pad. Maintain buffer speed at 1500-2200 rpm. Remove excess compound with a clean soft cloth before applying polish.
- POLISHING
  - Using a finishing polish and a foam polishing pad apply a ribbon of material to work a 2-3 foot square area. Maintain buffer speed at 1200-1800 rpm. Keep the buffer moving at all times. Use a pattern utilizing a 50% overlap. Wipe off excess polish with a clean soft cloth. Hand buff with a clean soft cloth as a finishing touch.

TECHNICAL PRODUCT INFORMATION:

Dust Free	5-10 minutes
Flash Time	5-10 minutes
Tack Free	20 mins. @ 75°F
Purge Time	10-15 mins.
Bake	40 min. @ 140°F
Air Dry	8-10 hrs. @ 75°F
Pot Life:	5 hours @ 68°F-75°F
Shelf Life:	One Year (unopened)

Health and Safety:

See Material Safety Data Sheet and labels for additional safety information and handling instructions.

* The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and MSDS's of all components, since the mixture will have the hazards of all its parts.
* Improper handling and use, for example, poor spray technique, inadequate engineering controls and or lack of Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
* Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
* Provide adequate ventilation for health and fire hazard control.
* Follow company, product MSDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
* Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.
* Always observe all applicable precautions and follow good safety and hygiene practices.
* Material Safety Data Sheets are available at www. www.distinctive-image.com.

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