



# AUTOMOTIVE

# TAMCO PAINT

## Medium Solids Euro Clearcoat HC2100

**HC2100** is a medium solids clearcoat that has excellent flow, leveling and gloss retention. At 45% solids it still provides plenty of film build for the custom and collision industry. As with many of the other Tamco® clears **HC2100** is manufactured from direct to metal resins. This means clear can be applied directly over properly sanded and cleaned metal where protection from the elements is required.



### Features & Benefits

- Simple 2:1 mix ratio
- Fast Dry
- Multi use
- Very High Gloss
- Ideal for Collision and Custom
- Overall/Spot
- High buff ability
- 45% solids content
- Easy to spray / User friendly
- Direct to metal and aluminum
- 97-99% on gloss meter
- Very high UV resistance
- Durable (excellent weathering)
- Water white clarity

### Compatible Surfaces

- Sanded metal or aluminum
- All Tamco® Basecoats, HC895 & CC3000
- Other premium basecoats, but no warranty implied

### Required products

- Tamco® HH700X Series Hardeners.
  - HH7001
  - HH7002
  - HH7003

### Optional

- HR1370
- HR1380
- HR1390
- HP1001 Accelerator
- HP1010 Fisheye Eliminator
- HR900 Retarder
- HP Flat
- Pot Life Extender
- Flo N Go

(See our "What Temperature should I choose PDF" for a guideline on which suits your current job)



# Medium Solids Euro Clearcoat

## HC2100

---

### Surface Preparation:

Thoroughly cleaned with HR397 wax and grease remover and wipe dry with clean cloth.  
Plastics: Clean with HR397 using a Scotch-Brite pad, wipe dry with clean cloth.

---

### Mix Ratio:



#### Component

#### Volume

HC2100	Clear	2
HH7001/7002/7003	Activator	1
HR1370/1380/1390	Reducer	up to 10%

**Note:** Use only Tamco® Reducers. Our reducers are completely moisture free. Moisture in reducer will kill the shine of our clears.

---

### Additives:



HR900 Retarder, Pot-Life Extender, HP1001 Accelerator, HH1010 Fisheye Eliminator, Flo N Go: 1-2 oz per spray able Quart.

HR Reducers: up to 10%

HP Flat: Refer to our HP Flat TDS sheet for mixing instructions.

---

### Air Pressure & Gun Setups:



Gun Setups:

#### HVLP

Siphon Feed: 1.2 mm – 1.4 mm

Gravity Feed: 1.2 mm – 1.4 mm

#### Conventional

Siphon Feed: 1.2 mm – 1.4 mm

Gravity Feed: 1.2 mm – 1.4 mm

25-29 PSI at the gun

5-10 PSI at the cap

Air Pressures Conventional: Always refer to your gun manual for their advice in using our products.



# Medium Solids Euro Clearcoat

## HC2100

---

### Application:



1. Allow Tamco basecoat to dry from 30 minutes to 8 hours.
2. Apply first medium-wet coat.
3. Allow 20-30 minute flash at 78°F between coats
4. Apply second wet coat. (Two coats are generally sufficient, unless you plan to cut and buff.)
5. Apply a 3rd coat and let sit overnight.
6. Flow Coat: Add 5-10% HR1390 Very Slow Reducer and apply 1 wet coat, followed by second wet coat with 30-40 minute flash times between coats.
7. Apply over Tamco® Base, HC895 Intercoat & Clearcoat or CC3000 Candy Carrier.

#### On Metal:

- Clean substrate first with soap and water.
  - Use Tamco® HR397 (or HR397W) Wax and Grease remover.
  - Dry sand substrate using 180 Grit to remove rust, or surface damage.
  - Dry sand substrate with 320 grit to remove your 180 grit scratches.
  - Finish with 400-600 grit.
- Clean the substrate again with HR397 (or HR397W) Wax and Grease remover.
  - Final Clean: Clean the substrate for the last time with HR398 Final Wipe.

---

### Drying Times:



**Airdry:** 12-16 hours @ 78°F.

**Tape Time:** 6-8 hours

**Baking:** 140°F for 30 minutes

---

### Wet Sanding:



Sand with 400-600 grit if re-coat is needed.

---

### Polishing:



Finish sanding. After 12-16 hour cure time, dry or wet sand adding a small amount of dish soap to water and wet sand with 800 grit and work your way to 1500-2000 grit then 3000 grit before buffing.

Follow the recommendations on the polish you use.

For best results use Tamco's® 2 step polish.

For show car gloss: Allow the vehicle to sit up to 3 or 4 days for a total gas-out of solvents before polishing. After finish sanding, when the clear is 'open' sit the vehicle in the sun for a full 24 hours.

Do not wax for 120 days



# Medium Solids Euro Clearcoat

## HC2100

---

### Tamco® Tips:



#### Tips:

1. HC2100 is the perfect choice for a clearcoat when users find it hard to make HC2104 lay down without orange peel due to solid content differences.
2. To increase air dry time, a minimum temperature of 60°F must be maintained.
3. Sanded surface should be re-sanded if not top-coated within 8 hours.
4. Extra reducer may be required in high temperature using HR1390 Very Slow Reducer or HR900 Retarder.
5. When using hardeners, be sure the mixture is stirred thoroughly.
6. Apply over Tamco® Base, HC895 Intercoat & Clearcoat or CC3000 Candy Carrier.

Flow Coat: Add 5-10% Very Slow Reducer and apply 1 wet coat, followed by second wet coat with 30-40 minute flash times between coats.

**Note:** Use only Tamco® Reducers.

---

### Equipment Cleaning:

Lacquer Thinner or HR1360 is an excellent cleaner.

---

### Cold Shop Conditions:

Do not spray under 65°F or above 95°F.  
At 95°F - 100°F + We recommend spraying our HC2105 Extra Slow High Solids Euro Clearcoat.



# Medium Solids Euro Clearcoat HC2100

## TECHNICAL DATA & PHYSICAL PROPERTIES

**Color:** Clear

**Mix Ratio:** 2:1

**Viscosity:** (RTS) 18-20. EZ Zahn #2

**Pot Life:** 1 hour @78F depending on temperature

**Theoretical Dry:** 570 ft<sup>2</sup> @ 1 Mil

**Weight Solids:** 44%

**Color & Gloss holdout:** Very Good

**Volume Solids (RTS):** 38%

**Humidity Resistance:** Excellent

**Weight Per Gallon:** 8.08 lbs.

**Solvent Resistance:** Very Good

**Topcoat times:** 30 minutes 1 mils or less

**Repair ability:** Excellent

**Florida Exposure:** Very Good

**Package VOC:** 3.70 # / gal

**Chip Resistance:** Good

**RTS VOC:** 3.7 # / gal

**See Safety Data Sheet/Material Safety Data Sheet and Labels for additional safety information and handling instructions.**

Important: The contents of this package must 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 of all components since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Tamco Paint Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Tamco Paint warrant freedom from patent infringement in the use of any formula or process set forth herein.

Tamco Paint  
Barney Family Enterprises  
PO BOX 711  
Wakefield, Va 23888  
(757-627-9551)

[www.TamcoPaint.com](http://www.TamcoPaint.com)

Follow us online: @TamcoPaint



For more TDS Sheets, scan QR code

To contact us, scan QR code



[Info@TamcoPaint.com](mailto:Info@TamcoPaint.com)



[www.TamcoPaint.com](http://www.TamcoPaint.com)



(757) 627-9551

5-5