



AUTOMOTIVE

TAMCO PAINT

MATTE CLEAR

HC5000

Have you wanted a traditional **Matte Clear** that is not flattened with the run of the mill flattening agent, but uses better technology for that perfect matte finish? This is the matte clear for you. We also offer several of our traditional Tamco® clears in a matte finish, they use traditional flattening agents that work very well. This uses a silica based flattening agent, known in the industry to perform better long term in some applications. It mixes 2:1:1 and the kit includes all items needed. (Clear, hardener and reducer) Tamco's® Speciality Flattened Clear-Coats use a state of the art flattening system using highly cross-linked PMMA micro-beads are used in the formulation of textured coatings and inks. Due to the high level of cross-linking they have excellent hydrolysis and chemical resistance. Their aliphatic nature ensures a high level of UV stability. Additionally, they impart a deep matting effect and offer excellent scrub resistance with no marring.



Features & Benefits

- Very Easy to Spray
- Choice of Hardeners
- Direct to metal
- Increased scrub resistance
- Enhanced mar resistance (lower content of fumed silica) to fulfill requirements of DIN / ISO 68000
- Same level of flatness regardless of coats

Compatible Surfaces

- Tamco® Basecoats
- Other premium basecoats, but no warranty implied.

Required products

Tamco® HH76XX series hardeners and HR reducers.

- | | |
|----------|----------|
| • HR1360 | • HH7603 |
| • HR1370 | • HH7605 |
| • HR1380 | • HH7607 |
| • HR1390 | |

Optional

- Pot-Life Extender
- HP1001 Accelerator
- HP1010 Fisheye Eliminator
- HP Flat

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



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Surface Preparation: Metals: 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.

Basecoats: Apply within recoat times. Tamco® basecoat is 8 hours.

Recoat: Flash times are dependent on how heavy the flattened clear is applied.

Allow clear to lose gloss as a flash before applying another coat.

Mix Ratio:



Component

Volume

HC5000	Clear	2
HH7603/7605/7607	Activator	1
HR1370/1380/1390	Reducer	1

Additives:



HR Reducers, Pot-Life Extender, HP1001 Accelerator, HP1010 Fisheye Eliminator, HP Flat.

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

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

Application:



Any Tamco® flattened clear-coats are applied just like our regular clear-coats. These are modified clears build to become what they are (Flat-Satin) without any special application procedure of the painter.

- Allow basecoat to dry from 30 minutes to 8 hours.
- Apply first medium-wet coat. Spray the way you want it to look.
- Allow 30-45 minute flash at 78F
- Apply second wet coat. Two coats are generally sufficient.



INTERCOAT & CLEAR

HC895

On Metal:

- Clean Car first with soap and water. Then use Tamco® HR397 (or HR397W) Wax and Grease remover. Our high strength HR397 solvent is an excellent choice for the initial cleaning of cured paint surfaces before sanding and for cleaning bare metal. We also have a waterborne version in the HR397W (water) which is great for cleaning plastics.
 - Sand the paint either to the bare metal, the original primer, or at least sufficiently for the new paint to adhere. Dry sand using 180-grit sandpaper to remove rust or surface damage before moving on to a 320-grit paper to remove your previous 180-grit scratches. Whichever method that you decide, follow it up using 400- to 600-grit sandpaper to sand the paint to prep the existing paint surface for the new coatings to be applied.
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Drying Times:



2 hours at 78°F.

Cure: Air Dry 12-16 @ 75°F.

Bake: Do not bake.

Polishing:



Finish sanding. None! Not to be buffed!

Tamco® Tips:



Tips:

1. Apply same as any Tamco® clear-The best tech advice on modified flattened clears is to "spray like the regular clear, the product is designed and built to become the desired finish without extra work.
2. When air drying, a minimum temperature of 60°F must be maintained.
3. Sanded surface should be re-sanded if not top-coated within 8 hours.
4. When HH76XX Hardeners, extra reducer may be required.
5. When using hardeners, be sure the mixture is stirred thoroughly.

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

Use the proper tip and setup for your particular Gun.



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Equipment Cleaning:

Lacquer Thinner

Cold Shop Conditions:

Do not spray under 65°F or above 100°F.

TECHNICAL DATA & PHYSICAL PROPERTIES

Colors Clear

Viscosity (RTS) 18-22 sec. EZ Zahn #2

Pot Life 1-4 hours depending on temperature

Mix Ratio 2:1:1

Theoretical Dry Film 480 ft² @ 1 Mil Weight Solids (RTS) 57%

Color & Gloss holdout Excellent

Volume Solids (RTS) 52%

Humidity Resistance Excellent

Weight Per Gallon 8.70 lbs.

Solvent Resistance Excellent

Topcoat times 30 min. at 1 mils or less

Repair ability Excellent

Florida Exposure Good

Package voc 3.60 # / gal

Chip resistance Good

RTS voc 4.0# / 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

Follow us online: @TamcoPaint

