



TDS Sheets Hi-Impact Clearcoat

HI-IMPACT clear was developed by Tamco for those who want the ultimate chemical, fuel, UV, scratch and water resistance. This clear can be used under the water line on (fresh or salt water) watercraft which makes it great for boats and jet ski's as well as skydrol resistant for use on aircraft. If you are looking for the best of the best in the automotive refinishing industry look no further than HI-IMPACT

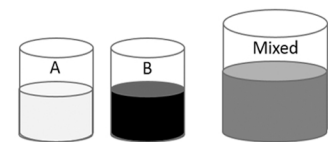


Component

Volume

Hi-Impact	Clear	4
HH-7603/7605/7607	Activator	1
HR-1360/1370/1380/1390	Reducer	As needed up to 5-10%

USE ONLY TAMCO REDUCERS. Our reducers are completely moisture free. Moisture in reducer will kill the shine of our clears. 50% solid content RTS



HH-7603-Fast HH-7605- Standard HH-7607- Slow

Gun Setups

See manufacturers suggestions

Common User Suggestions

Iwata Supernova: 1.3 or 1.4, fluid open, trigger pull full, 1 turn in on fan, 26 psi

Iwata WS400 evo: 1.3hd fluid open, trigger pull full, 1 turn in on fan, 30 psi

Iwata LPH 400: 1.3 or 1.4 fluid open, trigger pull full, 1 turn in on fan, 20 psi (this is an lvp gun recommended by the manufacturer to be no higher than 19 psi but the extra (pressure helps atomize the clear for a smoother finish

Sata RP 4000/5000: 1.3 or 1.4 fluid open, trigger pull full, fan open, 28-30 psi

Sata 4000/5000 hvlp: 1.3 or 1.4 fluid open, trigger pull full, fan open, 29-32 psi

Devilbiss Pro Lite: 1.2, 1.3 or 1.4 TE10 fluid open, trigger pull full 28 psi

Devilbiss Pro Lite: 1.2, 1.3 or 1.4 TE20 24-26 psi





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Application

See manufacturers suggestions

Common User Suggestions

After basecoat has dried for 30 minutes apply 1 medium/wet coat and allow to flash for 15-20 minutes before applying next coat. We recommend no longer than 1 hour application time between base and clear for maximum adhesion. Apply only 3 coats of clear for each session. Shop conditions temperature and air flow will determine flash times. The “string” test method can be used to determine proper flash time for your conditions. Monitor an area by lightly touching. If the clear is still wet or stringing do not apply additional coats. Wait until finish becomes sticky but doesn’t string. Do not apply more clear after 1 hour of dry time



Dry Times

Air Dry at 70° 12 hours

Force Dry at 140°= Allow to flash for 20-30 min then bake 30 minutes and allow a 30 minute cooldown

Finish Sanding

After the clear has cured for at least 12 hours dry or wet sanding is acceptable. Adding a small amount of dish soap to the water and soaking the paper will provide best results. If sanding with a DA sander we recommend denibbing first and taking it slow as “pigtailed” can be introduced and become difficult to remove in the polishing process



Recoat

If you choose to apply additional coats of clear after sanding you can add 5% reducer and apply 1 medium coat followed by 2 more medium wet coats with 20-30 minute flash between. As above shop conditions will vary flash times so “string” test is recommended

Polishing

Allow clear to dry for at least 12 hours before polishing

We recommend going all the way up to 3000 grit for best results and ease of polishing. Follow recommended procedures from the manufacturer of the products you are using. For show car polishing we recommend allowing the car to sit for a few days to outgas before finish sanding and polishing. After finish sanding allow the car to sit in the sun for a day before buffing. This allows more solvents to evaporate and the surface to be easier to polish and won’t show sand scratches