



TDS Sheets

High Solids Clearcoat

HC-2021 is an ultra high solids clear that works great for burying art work, flake and tape lines. Due to its mixing ratio it is the same solids as HC-2104 but has a higher viscosity making it a little more difficult for first time users who aren't accustomed to a clear this thick. As with all other Tamco clears HC-2021 contains the maximum amount of useable UV absorbers and DTM resins

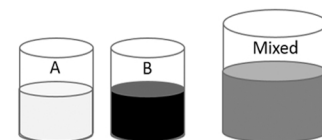


Component

Volume

HC-2021	Clear	4
HH-61	Activator	1
HR-1360/1370/1380/1390	Reducer	1

USE ONLY TAMCO REDUCERS. Our reducers are completely moisture free. Moisture in reducer will kill the shine of our clears. 54 % solid content RTS



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 fluid open, trigger puff full 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 25% 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