



AUTOMOTIVE

TAMCO PAINT

Ultra High Solids Clearcoat HC2021

Tamco® **HC2021** 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 HC2104 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 **HC2021** contains the maximum amount of useable UV absorbers and DTM resins.



Features & Benefits

- Ideal for high end collision and restoration
- Buries most flake in 2-3 coats
- Very high gloss
- Overall or Spot/Panel
- 54% solids content
- Exceptional DOI
- 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® HH61 hardener
- HR1360
- HR1370
- HR1380
- HR1390

Optional

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

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

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Surface Preparation: Thoroughly clean with HR397 Wax and Grease Remover and wipe dry with clean cloth.
Plastics: Clean with HR397 Wax and Grease Remover using a Scotch-Brite pad, wipe dry with clean cloth.

Mix Ratio:



Component

Volume

HC2021	Clear	4
HH61	Activator	1
HR1360/1370/1380/1390	Reducer	1

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: 1.3 mm – 1.4 mm

Gravity Feed: 1.3 mm – 1.4 mm

Conventional

Siphon Feed: 1.3 mm – 1.4 mm

Gravity Feed: 1.3 mm – 1.4 mm

27-35 PSI at the gun

8-12 PSI at the cap

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



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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 2-3 coats if buying large flakes or tape lines.
6. Apply a 3rd coat and let sit overnight.
7. 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.
8. Do not apply more clear after 2 hours from completion.
9. 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:** 12-24 hours @ 78°F.
Tape Time: 12 hours
Baking: 140°F for 30-45 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



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Tamco® Tips:



Tips:

1. When air drying, a minimum temperature of 60°F must be maintained
2. Sanded surface should be re-sanded if not top-coated within 8 hours.
3. When using hardeners, be sure the mixture is stirred thoroughly.
4. HC2021 is a higher viscosity clearcoat compared to many other clears on the market due to the solid content. Most users dial in their gun setups. Follow next steps if needed.
5. If you notice you have "orange peel" you need to reduce your Fluid inlet & increase your air pressure. You also may need to add a little bit of extra reducer (only an extra 5% if needed, remember you are taking away from solid content by doing this).
6. Open your Fluid inlet 1/2 to 3/4 vs wide open (if you have "orange peel"). Then adjust as needed to zone in.
7. 29 PSI is a good start if you have "orange peel", again adjust as needed once you get the hang of HC2021.
8. Apply over Tamco® Base, HC895 Intercoat & Clearcoat or CC3000 Candy Carrier.

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.

Use the proper tip and setup for your particular gun.

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 100°F.



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TECHNICAL DATA & PHYSICAL PROPERTIES

Color: Clear
Mix Ratio: 4:1:1
Viscosity: (RTS) 18-22 sec. EZ Zahn #2
Pot Life: 1-4 hours depending on temperature
Theoretical Dry Film: 570 ft² @ 1 Mil Weight Solids: 47%
Color & Gloss Holdout: Excellent
Volume Solids (RTS): 46%
Humidity Resistance: Excellent
Weight Per Gallon: 9.22 lbs.
Solvent Resistance: Excellent
Topcoat Times: 30 min. at 1 mils or less
Repair Ability: Excellent
Florida Exposure: Excellent
Package VOC: 3.50 # / 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.

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