



2.1 VOC Production Clear



Description

- 77173 - 2.1 VOC MS Speed Clear
- 77181 - 2.1 VOC Clear Activator - Fast
- 77182 - 2.1 VOC Clear Activator - Medium
- 77183 - 2.1 VOC Clear Activator - Slow

**Insert
Product
Image Here**

High Teck 2.1 VOC Production Clear is a 4:1 medium solids urethane clearcoat designed to provide refinishers superior gloss, easy application, great flow and leveling. 77173 provides terrific image clarity in a highly productive 2K urethane clearcoat. In as little as 90 minutes, High Teck Production Clear can be polished (under proper conditions).



Surface Preparation

Allow basecoats sufficient dry times.



Mixing Directions

Mix four (4) parts clear with one (1) part hardener.



Application

Apply 2-3 full wet coats with 50% overlap.

Gun Setup	
Gravity Feed	1.3 mm – 1.5 mm
Siphon Feed	1.6 mm – 1.8 mm
HVLP	1.3 mm – 1.5 mm

Air Pressures	
Gravity Feed	35-40 psi 45 psi
Siphon Feed	35-45 psi 45-50 psi
HVLP @ Cap	6-8 psi 9-10 psi



Bake Times

Force Drying @ 165°F

Purge Time	15 minutes
Bake Time	20 minutes
Deliver/Polishing/Recoating	After 1 hour cool down



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Dry Times

Air Dry @ 77°F (25°C)

Flash Between Coats	5-10 minutes
Dust Free	10-15 minutes
Sand/Polishing	1.5-2 hours



Fisheye Eliminator

Fisheye eliminator is generally **discouraged**, however, when used as recommended, it may help minimize the surface reaction to contamination. The use of this additive is not a substitute for proper cleaning and preparation. 1/2 oz per sprayable quart.

NOTE: Adding additional materials to a ready-to-spray product will increase the VOC as applied. Check mixture and local regulations to assure compliance.



Suitable Substrates

Compatible with most paint manufactures solvent and waterborne basecoat systems.



Personal Protection

See product SDS.



Technical Data

Clear: 4 parts using HIT#77173
Hardeners: 1 part using HIT#77181, 77182, or 77183
Viscosity (RTS): 17-19 seconds #2 Zahn
Weight Solids (RTS): 33.10%
Film Build: 1.0 mils per full wet coat
Coverage: 539 sq ft per gallon @ 1 dry mil
Pot Life: 1.5-2.5 hours
V.O.C.: 2.1 lbs/gal (using EPA test method 24)
Disposal/Safety: See SDS for this product
Humidity Resistance: Excellent
Salt Spray Resistance: Excellent

SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.

NOTE: High Teck products are not recommended for use in temperatures below 65°F. Using High Teck products below these temperatures will affect dry times and product performance characteristics. Check with all State, local and National rules for compliance before use.