



Technical Data Sheet

High Teck Products
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Product: 77173 2.1 VOC Production Clear
Product: 77181 2.1 VOC Production Clear Activator - Fast
Product: 77182 2.1 VOC Production Clear Activator - Medium
Product: 77183 2.1 VOC Production Clear Activator - Slow

Description: 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).

Basecoat:

- Apply basecoat per manufacture’s mixing and application instructions. Allow sufficient flash times before applying HIT#77173 clearcoat. Inadequate flash time will affect the performance of the clear.

Application:

- Apply 2-3 **flowing coats** allowing a 10-15 minute flash between coats. Keep spray gun 6-10 inches from substrate to avoid problems associated with air entrapment.

Mixing Ratio:

- Mix: 4 Parts #77173 & 1 part #77181 or #77182 or #77183

Dry Times at 77F:

	HIT #77181 & #77182	HIT #77183
Dust Free:	20 minutes	25 minutes
Tack Free:	25 minutes	30 minutes
To Buff:	1.5 - 3 hours	1.5 - 3 hours

Force Drying:

Purge Time: 10-15 minutes at 77F
 Bake Time: 20minutes at 165F

Allow a 1-2 hour cooldown time before wet sanding or buffing after force drying

Recoating:

- HIT #77173 clearcoat may be recoated after a 6-8 hour air dry at 77° F or after 1-2 hour cool down after force drying at 140° F for 40 minutes.

Pot Life:

- Pot life will be 1.5-2.5 hours at 77F

Buffing:

- Allow at least 1.5-3 hours air dry at 77° before buffing. For dirt removal, lightly "nib sand" with 1500 grit wet sandpaper and polish with a micro type compound. Finish with a quality glazing compound. It is best to polish between 6-24 hours after application. Temperature, humidity and film thickness will effect buff times.

Accelerator:

- The use of accelerator is discouraged

Fisheye Eliminator

- The use of fisheye eliminator is strongly discouraged. If a fish eye additive is needed, use urethane fish eye eliminator, mix 1/2 ounce per sprayable quart. Use no more than necessary as it will directory affect flow out.

Equipment Cleanup

- Clean equipment immediately after use with gun wash reducer, a high quality lacquer thinner or urethane reducer.

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
Humidy Resistance:	Excellent
Salt Spray Resistance:	Excellent

NOTE: Not recommended for use in temperatures below 60° F. Use below these temperatures will effect dry times and performance.

FOR INDUSTRY USE ONLY | Read SDS and product label for additional safety information before use

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions.

The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.