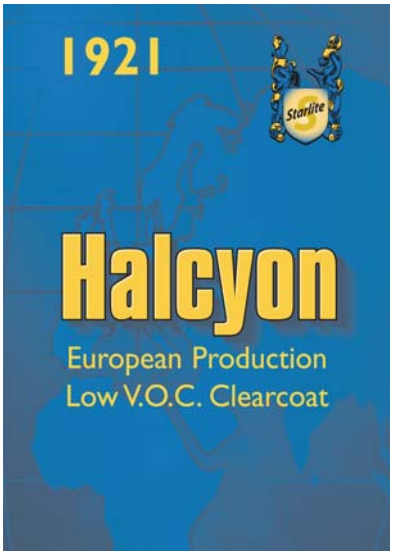
Technical Data Sheet



1921 European Production Clear Coat

HC-1921 is a high quality 2.1 VOC clear coat formulated with the latest Euorpean acrylic resin technology to give exceptional gloss, flow, and durability. This clear coat has been formulated for use in the demanding conditions of todays production shops. Easy to use, great results, all at an economical price.

- Exceptional Clarity for Better Color Match
- Economical European 2.1 VOC Clear Coat
- High Gloss and DOI
- Ease Of Application
- Long Term Durability
- Excellant Flow / Leveling

FEATURES:
- 2.1 VOC compliant
- Excellent gloss retention
- Excellent flow and leveling
- Apply over most basecoat systems
- Easy buffing within 6-36 hours
- Excellent flexibility and durability

RECOMMENDED SUBSTRATES:
- All basecoat systems
- Polyurethane enamel (after 8 hour dry)
- Acrylic urethane enamel (after 8 hour dry)
- Gel coat (must be properly prepared)

MIXING INSTRUCTIONS:
2 parts HC-1921 Clear to 1 part Activator

ACTIVATOR OPTIONS:
HC-2160 Low Temp HC-2175 Medium Temp
HC-2185 High Temp HC-2195 Very High Temp

APPLICATION INSTRUCTIONS:
1. Apply basecoat color per manufacturer's recommended procedures. Note: Allow polyurethane and acrylic enamel basecoat to dry at least 8 hours before applying clear.
2. Apply two wet coats of clear using 50-60 PSI at gun, conventional spray 6-10 PSI at gun, HVLP.
3. Mix HC-1921 Clear with appropriate activator as per instructions.
4. Allow 10-15 minutes flash between coats. Optional: On small jobs (i.e. fenders & doors) one tack coat can be applied, followed by one full wet coat with no flash between coats. Tack coat must be applied evenly.
5. Dry times:
   Dust Free:5-15 minutes depending on temperature and activator selection.
   Tack Free:20-40 minutes depending on activator speed.
   Buff Time: Minimum 6-8 hours air dry.
   Force Dry: 10 minutes flash bake 30 minutes at 140^0 F
   Delivery: 6-8 hours
6. Pot Life: One and a half hours. Note: By using one ounce per paint cup of SLX-081 Accelerator, buff time and delivery time can be substantially reduced. Accelerator should not be used when air temperature is above 80^0 F.

BUFFABILITY:
HC-1921 Clearcoat can be wet sanded and buffed after 6-8 hours. HC-1921 should be buffed within 36 hours for best results. Film thickness, flash times, and temperature will effect buffing times.

CLEANING:
Use good quality lacquer thinner to thoroughly clean all equipment. Do not leave catalyzed clear in gun longer than 3 hours. Clean equipment immediately when using SLX-081 Accelerator.

FEATURES:

Color:	Water Clear
Flash Point :	< 0^o F TCC
Pot Life:	1.5 hours @ 75^o F
Recommended Film Build:	2 – 2.5 mil DFT
Coverage 1 mil.:	690 sq. ft.
Gloss:	92 Plus
Mix Ratio:	2:1
Weight Solids:	37%
Sprayable Viscosity:	16-19 sec. #2 Zahn
V.O.C.:	RTS 2.1 lbs./gal. mixed 2:1 with HC-2160, HC-2175, HC-2185, and HC-2195.

41158 Koppernick Rd. • Canton, MI 48187 • 734 335-6665

Material Safety Data Sheet

PRODUCT IDENTITY: HC-1921 European Production Clearcoat

Section I – Manufacturer Information

Manufacturer Name: Innovative Solutions Technologies, Inc.
Address: 41158 Koppernick Rd.
Canton, MI 48187
Emergency Telephone: 800 255-3924
Information Telephone: 734 335-6665

NFPA Ratings	
Health	2
Flammability	3
Reactivity	0
Personal Protection	G

Section II-Hazardous Ingredients/Identity Information

Hazardous Components (Specific Chemical Identity, Common Name)

	CAS#	OSHA PEL	ACGIH TLV	Wt %
METHYL AMYL KETONE	110-43-0	100 ppm	50 ppm	5/10
*TOLUENE	108-88-3	100 ppm	100 ppm	1/5
OXSOL 100	98-56-6	100 ppm	100 ppm	10/15
ACETONE	67-64-1	750 ppm	750 ppm	30/40

* SARA 313 listed chemical
DOT SHIPPING: FLAMMABLE LIQUID; PAINT RELATED MATERIAL UN 1263

Section III-Physical/Chemical Characteristics

Boiling Point: 132°F Specific Gravity (H20 = 1): 0.98
Vapor Pressure (mmHg @ 70°F): 85 mmHg Vapor Density (Air = 1): Heavier than Air
Evaporation Rate:(butyl acetate = 1) >1
Appearance and Odor: Water white liquid, solvent odor
Material V.O.C.: 0.8 #/gal. 96.1 gm/l Coatings V.O.C. 1.1 #/gal. 131.0 gm/l

Section IV-Fire and Explosion Hazard Data

Flash Point (Method Used): -20°F (TCC) Flammable Limits: LEL 1.0 UEL 10.5
Extinguishing Media
Class B extinguisher, Carbon Dioxide, Dry Chemical, Foam Special Fire Fighting Procedures. Water spray can be used to cool containers exposed to fire. Clear area of unprotected personnel. Fire fighters are to wear self-contained breathing apparatus and proper protection gear. Keep containers closed tightly. Isolate from heat, sparks, and open flames.
Unusual Fire and Explosion Hazards
Closed containers may explode when exposed to extreme heat.

Section V- Reactivity Data

Stability – Unstable: Conditions to Avoid: Sources of ignition
Stable: Yes
Incompatibility (Materials to Avoid): Strong Oxidizers
Hazardous Decomposition products: Carbon monoxide, Carbon dioxide,and Oxides of nitrogen.
Hazardous Polymerization: Will not occur

Section VI- Health Hazard Data

Routes of Entry: Inhalation? Yes Skin? Yes Ingestion? Yes
Health Hazards (Acute and Chronic)
May cause dizziness or narcosis in high vapor concentrations. Will cause defatting of skin. Effects are reversible. Long-term exposure (years) vapor may cause lung, liver or kidney damage. The solvents listed have been reported to affect the central nervous system. Signs and Symptoms of Exposure: Inhalation - difficulty in breathing; Skin – redness; Ingestion - vomiting

Medical Conditions Generally Aggravated by Exposure:
Heart Disease; respiratory disorders.
Emergency and First Aid Procedures:
If overcome by vapors give oxygen. Do not induce vomiting. Wash eyes with large quantities of water. Wash skin with soap and water.

Carcinogenicity: NTP? No IARC Monographs? No OSHA? No

Section VII - Precautions for Safe handling and Use

Steps to be taken in Case Material is Released or Spilled: Eliminate all ignition sources. Scrape up with NONSPARKING tools. FLASHBACK POSSIBLE.
Waste Disposal Method: Dispose as hazardous waste in accordance with EPA RCRA.
Precautions to be taken in Handling and Storing: Keep away from heat, sparks or open flame. Store at temperatures below 120oF
Other Precautions:
Excessive skin contact may defat skin causing dermatitis.
Respiratory Protection (Specify Type): Self contained breathing apparatus if above TLV limit.
Ventilation Local Exhaust: YES Mechanical (General)
Special: NONE
Protective Gloves: Neoprene, Viton
Eye Protection: Wear eye protection.
Other Protective Clothing or Equipment: N/A
Work/Hygienic Practices: Do not smoke while using. Wash your hands after every use. Avoid unnecessary exposure.

* SARA
All chemical compounds marked with an asterisk (*) are toxic chemicals subject to the reporting requirements of Section 313 of Title III of the Super Fund Amendments and Reauthorization Act (SARA) if 1906 and 40 CFR Part 372.
You must notify each person to whom this mixture or trade name product is sold. This statement must remain a part of this Material Safety Data Sheet. This statement must not be detached. Any copy or redistribution of this Material Safety Data Sheet shall include this statement.
Material Safety Data Sheet