



# WORLD CLASS™ PRODUCTION CLEARCOAT 2.1 VOC

## TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

### DESCRIPTION

World Class Production Clearcoat is a 2.1 VOC, two-component, urethane clearcoat for collision facilities in regulated areas.

### FEATURES

- 24 month warranty
- Great product at mid-grade price
- 2 Coat application
- Excellent vertical hold
- Firm after bake
- Easy to buff
- Excellent UV protection

### SUITABLE SUBSTRATES

- All automotive basecoat paint systems
- Fully cured refinish materials
- Properly prepped OEM finishes

### TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
50211	World Class Production Clearcoat 2.1 VOC	Clear	Gallon
50214	World Class Production Clearcoat 2.1 VOC	Clear	Quart

RTS weight solids:	36.7%
RTS volume solids:	32.7%
RTS VOC:	Max 2.1 lb/gal (252 g/L)
Pot life:	1 Hour @ 70°F (21°C) and 50% RH
Fluid tip size:	1.3 – 1.4
Inlet air pressure:	22 – 30 psi
Coverage:	262 sq.ft./gal @ 2 mils DFT
Dust Time:	10-30 minutes
Air dry time to buff:	4-8 hours



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## HANDLING AND APPLICATION



### PREPARATION:

After sanding primer, scuff any blend areas with **Scuff & Clean** according to directions. Clean surface with **SEM Solve** or **XXX Universal Surface Cleaner**. Apply basecoat per instructions and allow to fully flash dry.



### MIXING:

Shake or stir thoroughly. Mix by volume:

4 Parts	1 Part
Production Clearcoat	2.1 VOC Activator

### ACTIVATORS:

Part:	Product Name:	For:
50254, 50256	2.1 VOC Fast Activator	Small parts, 1-2 panels. Larger jobs from 55°F (13°C)
50264, 50266	2.1 VOC Medium Activator	2-3 panels. Larger jobs from 65°F (18°C)
50274, 50276	2.1 VOC Slow Activator	3-5 panels. Larger jobs from 75°F (23°C)

### ADDITIVES:

Part:	Product Name:	For:
50918	Accelerator	Reducing cure to handle times by up to 25%
50928	Extender	Extending pot life in hot and/or humid conditions

**Note:** The use of **Accelerator** may reduce time to buff by up to 30 minutes. For best performance when using **Accelerator**, complete buffing operation within 16-24 hours.

Thinning with reducer is not recommended. If used, amount should not exceed 5% by volume.



### APPLICATION:

1. Set air pressure to 8-10 psi at the cap for HVLP equipment.
2. Use a spray gun equipped with a 1.3–1.4 fluid nozzle.
3. Spray two full coats, allowing 5-15 minutes between coats.



Allow 10 minute flash after last coat prior to force drying.

### DRY TIMES:

**Note:** Dry and cure times are dependent on several factors including temperature, air-flow, film build, activator selection, and humidity.



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	<b>Air Dry</b>	<b>Force Dry 20 min @140°F (60°C)</b>
<b>To handle:</b>	3-8 hours	After cool down
<b>To buff:</b>	4-8 hours	After cool down
<b>To deliver:</b>	8-24 hours	After cool down

**Note:** If re-coating with clear only, sand with 1000 grit. If re-applying basecoat and clearcoat, sand with 600 grit.



### **CLEANUP:**

Use **XXX Gun Cleaner** or appropriate cleaning materials compliant with VOC regulations in your area.



### **STORAGE:**

**World Class Production Clearcoat 2.1 VOC** should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **World Class Production Clearcoat 2.1 VOC** is 5 years when stored under normal conditions. The shelf life for **World Class 2.1 VOC Activators** is 3 years.

## **RELATED PRODUCTS:**

<b>Part:</b>	<b>Product Name:</b>	<b>Size:</b>
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
38391	Scuff & Clean	Gallon
38398	Scuff & Clean	16 oz. Tube
50254	2.1 VOC Fast Activator	Quart
50256	2.1 VOC Fast Activator	½ Pint
50264	2.1 VOC Medium Activator	Quart
50266	2.1 VOC Medium Activator	½ Pint
50274	2.1 VOC Slow Activator	Quart
50276	2.1 VOC Slow Activator	½ Pint
50918	Accelerator	Pint
50928	Extender	Pint
77743	XXX Gun Cleaner	20 oz. Aerosol
77763	XXX Universal Gun Cleaner	20 oz. Aerosol
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



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### **Technical Consultation Service**

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

#### **Disclaimer:**

The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.