

# HBC21

## AutoClear Clearcoat

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### DESCRIPTION

HBC21 is a premium automotive 2.1 VOC compliant clear. It's distinct "water white" property eliminates concerns of color change, especially over white. HBC21 has outstanding buffing capabilities and a superior gloss for a glamour appearance. Developed specifically for markets with VOC legislation.

### COMPONENTS

- HBC21 AutoClear Clearcoat
- HB065/HB075HB085 Fast/Medium/Slow – Low VOC Activators

### MIXING RATIO

Mix four (4) parts HBC21 clear with one (1) part selected activator. No reducer needed

### POT LIFE AT 77° F

2 hours

### CLEAN UP

Use Lacquer Thinner or zero VOC solvents. (Check local regulation)

### PHYSICAL DATA

Solids wt. (as mixed)	32%
VOC as mixed	2.1
Color	Water white

### DRY / FLASH TIMES

#### Air Dry at 77° F

Flash between coats	8-10 minutes
Dust free	30 minutes
Tack free	15-20 minutes
Sand & Buff	12-24 hours

**Force Dry**

Flash before force dry	15 minute flash
Force dry time	40 minutes at 140° F
Sand & Buff	After 2 hour cooldown

**COLOR SANDING**

Wet sand with 1500 to 2000 wet or dry paper, then buff with appropriate compounds and glazes to achieve a high gloss finish.

**GUN SETUPS**

**Conventional**

Gravity Feed	1.3 mm – 1.5 mm
Siphon Feed	1.3 mm – 1.5 mm

**AIR PRESSURES**

**Conventional at Gun**

Gravity Feed	30 – 40 psi
Siphon Feed	35 – 45 psi
HVLP at cap	8 – 10 psi

**SURFACE PREPARATION**

Use Waterbourne to clean substrate free of grease, dirt, and foreign contaminants.

**APPLICATION AT 77° F**

- Apply 2 medium wet coats over substrate to desired film thickness
- Allow 8-10 minutes between coats
- Scuff after 24 hours before recoating
- Clean gun after spraying is completed

**SAFETY**

Refer to Safety Data Sheet (SDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

Download SDS



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