

Technical Data Sheet**XC1 EXPRESS CLEAR****PRODUCT DESCRIPTION:**

XC1 is a new generation Acrylic Urethane Clearcoat. XC1 is a premium clear coating that is easy to spray and is compatible with all acrylic and polyester color systems. XC1 is specifically designed for spot work to increase shop productivity. Air dry in 90 minutes at 72°F to buff or deliver. Bake 10 minutes @ 120°F for greater productivity.

FEATURES:

1. Premium resin system
2. Clear color - no yellowing
3. Extra gloss and depth of image
4. Compatible with all acrylic and polyester color systems
5. Excellent cure through time
6. Excellent gloss retention and durability

RECOMMENDED SUBSTRATES:

1. All acrylic and polyester color systems

MIXING INSTRUCTIONS:

3 parts - Clear

1 part – FA4, MA4, SA4, ESA4 Activator. **NOTE: DO NOT ACCELERATE**

APPLICATION INSTRUCTIONS:

1. Apply color as per manufactures instructions.
2. Mix XC1 according to mixing instructions.
3. XC1 can be applied in two (2) wet coats with 5 minutes flash between coats.
4. Can be baked at 120 F for 10 minutes.
4. **DO NOT WAX FOR 120 DAYS.**

AIR DRY TIMES:

1. Flash between Coats: 5 minutes
2. Dust Free: 2 – 5 minutes
3. Time to Handle (Assemble): 1.5 – 2 hours

4. Time to Polish: 1.5 – 2 hours

5. Time to Stripe: 1.5 – 2 hours

6. Time to Deliver: 1.5 – 2 hours

7. Time to Decal: 24 hours

FORCE DRY TIMES:

1. Flash between Coats: 5 minutes

2. Flash before Force Dry: 0 minutes

3. Cycle Time: 10 minutes @ 120°F (booth temp)

4. Dust Free: 2 – 5 minutes

5. Time to Handle (Assemble): 15 – 20 minutes

6. Time to Polish: after cool down

7. Time to Stripe: 1 hour

8. Time to Deliver: 45 minutes

9. Time to Decal: 24 hours

RECOMMENDED SPRAYING INSTRUCTIONS:

1. Conventional gravity 1.3 mm – 1.6 mm (.051' - .063') @ 35 – 45 ps1 at the gun.

2. Siphon 1.4 mm – 1.8 mm (.055' - .070'') @ 35 – 45 psi at the gun.

3. HVLP 1.3 mm – 1.4 mm (.051' - .055) @ 8 – 10 psi at the gun cap.

3. Open fan adjustment to achieve maximum atomization.

RECOATABILITY / REPAIR:

1. Can be recoated 2 hours @ 70°F or 1 hour @ 90°F.

2. When force dried, wait one hour. If recoating after 24 hours, sand with 1200 – 1500 grit paper.

CLEANING:

Use good quality lacquer thinner or urethane reducer (URF1/URM1/URS1/URXS1) to thoroughly clean all equipment. Clean equipment immediately after use. Do not allow catalyzed clear to remain in gun longer than two (2) hours.

TECHNICAL DATA:

Color	Clear
Pot Life	1 1/2 hours at 70° F
Coverage (theoretical)	655 sq. ft. per Ready-to-Spray gallon at 1 mil
Mix Ratio	3:1
Flash Point	9 F
Recommended Film	2 - 2.4 mil Dry Film Thickness (DFT)
Gloss	Excellent
Solids by Weight	45% +
Solids by Volume	40% +
Sprayable V.O.C.	3.5lbs./gal.
V.O.C.	3.27 lbs./gal. Before activator