



Technical Data Sheet

RC15 RAPID REPAIR CLEARCOAT

DESCRIPTION:

AutoKote RC15 Rapid Repair Clearcoat utilizes the latest resin and hardener technology to provide the drying performance of a baking clear in air dry environments. This eco-friendly product will shorten your cycle time while generating substantial energy savings.

PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
RC15 Rapid Repair Clearcoat	5411	Gallon
RC15 Rapid Repair Clearcoat	5414	Quart
RH15 Rapid Repair Hardener	5434	Quart
RH15 Rapid Repair Hardener	5439	Half Pint
Jet-Speed Accelerator (Optional)	1154	Quart

COMPATIBLE SUBSTRATES:

RC15 Rapid Repair may be applied over any urethane compatible basecoat. Refer to basecoat manufacturer's instructions for proper basecoat flash times.

Note: For maximum adhesion to substrate and/or clearcoat, add 10% RH15 Rapid Repair Hardener or Autokote Basecoat Activator to mixed ready to spray basecoat prior to application.

Note: When using Wandabase always add 10% RH15 Rapid Repair Hardener or Autokote Basecoat Activator.

SAFETY ASPECTS:



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

MIXING RATIOS:



4 parts RC15 Rapid Repair Clearcoat
 1 part RH15 Rapid Repair Hardener
 5% X-tend Pot Life Extender (Optional)
 5 - 10% Autokote Jet-Speed (Optional)

Note: For faster cure times, add 5-10% Autokote Jet-Speed at the rate of 1.5 ounces (4 capfuls) to 3 ounces (8 capfuls) per sprayable quart. Autokote Jet-Speed will reduce pot life according to amount used.

GUN SETUP:



TYPE	FLUID TIP	SPRAYING PRESSURE
Conventional Gravity	1.3 mm	25 - 30 psi @ gun
Mini Spray Gun	1.0 mm - 1.3 mm	5 - 15 psi @ gun

NUMBER OF COATS:

Apply three full wet coats back to back with no flash time between coats.



Technical Data Sheet

RC15 RAPID REPAIR CLEARCOAT

PURGE TIME: 0 minutes.

DRYING TIMES:



METAL TEMP	DUST FREE	DRY
75°F (24°C)	1 minute	15 - 20 minutes
140°F (60°C)	N/A	5 minutes

RECOATABILITY:

RC15 Rapid Repair may be recoated after bake cycle when metal has completely cooled down. For best results in air dry situations repair after one hour.

POLISHING:



Dry to polish time for air dry applications is 30 minutes @ 75°F (24°C) or after metal cool down for baking applications. For best results when compounding use Autokote EZ-Buff rapid cut compound with an Autokote foam or wool compounding pad. For any follow-up polishing, use Autokote Micro-Buff Polishing compound or Autokote EZ-Glaze finishing glaze with an Autokote foam polishing pad.

DECALS:

Decals, lettering or stripes can be applied after 24 hours.

CLEANING EQUIPMENT:

Clean equipment immediately with Autokote lacquer thinner.

TECHNICAL DATA:



Color	Water Clear
Activator/Hardener	RH15 Rapid Repair Hardener
Mix Ratio	4:1
Additive	Optional 5% X-Tend Pot Life Extender
Number of Coats	3 full wet coats
Flash Time	0 minutes
Purge Time	0 minutes
Dry Time	Air Dry 15 to 20 minutes @ 75°F(24°C) Force Dry 5 minutes @ 140°F (60°C)
Gun Set-Up	Refer to Table on Page 1
Air Pressure @ Gun	Refer to Table on Page 1
Regulatory V.O.C.	2.31 lbs/gal (277 g/l)
Actual V.O.C	0.95 lbs/gal (114 g/l)
% Solids RTS by Wt.	35.7%
Package Size	Gallon, Quart
Case Quantity	4 Gallons, 6 Quarts
Shelf Life	12 months unopened

All data given below are MAXIMUM THEORETICAL VALUES based on the product AS CURRENTLY FORMULATED. Variations may occur on individual batches due to adjustments made during production.



Technical Data Sheet

RC15 RAPID REPAIR CLEARCOAT

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 Autokote Systems, LLC deems appropriate.