



Technical Data Sheet

RAPID DRY CLEARCOAT

DESCRIPTION:

Rapid Dry Clearcoat has been formulated for the mobile wheel repair industry providing the fastest air-dry/express bake clear offered. It also revolutionizes energy savings and productivity, without sacrificing appearance. This 4.2 V.O.C. 2-component clearcoat can be used for spot repairs and complete wheel refinishing. The Rapid Dry Clearcoat mixes 4:1 with the Wheelkote High Performance Clear Hardeners. Air Dry's in approximately 30-45 minutes, depending on hardener selection and ambient temperature.

PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
Rapid Dry Clearcoat	157003	Quart
Rapid Dry Clearcoat	157004	Gallon
Fast High Performance Clear Hardener	157009	½ Pint
	157010	Quart
Medium High Performance Clear Hardener	157011	½ Pint
	157012	Quart
Slow High Performance Clear Hardener	157013	½ Pint
	157014	Quart
Wheelkote Reducers (Only If Needed)	Various	Various

COMPATIBLE SUBSTRATES:

DTA Foundation Coating
Wheelkote Colors
OEM Finishes

SAFETY ASPECTS:

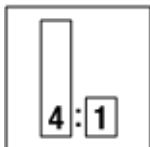


Users should review the Safety Data Sheet (SDS) and product label for the material to be used to determine possible health hazards, appropriate engineering controls and precautions to be observed in the use of the material. Copies of the SDS are available on the ordering portal. Click on the SDS button located under each product. You can also locate the SDS on the tech center website or call the technical department and request them.

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MIXING RATIOS:



MIX 4:1

4 parts: Rapid Dry Clearcoat

1 part: Fast, Medium or Slow High Performance Clear Hardeners

*Optional use: up to 5% Wheelkote Reducers

Notes:

*Recommended to only use fast hardener for small spot repair areas

*Using reducer can increase the V.O.C. level

*Can be applied over activated basecoat

GUN SETUP:



TYPE	FLUID TIP	SPRAYING PRESSURE
Mini Gravity	1.0 mm-1.3 mm	5-15 psi
Conventional Gravity	1.3 mm-1.4 mm	25-35 psi @ gun
HVLP Gravity	1.3 mm-1.4 mm	8-10 psi @ gun

Note: Using a 1.0 – 1.2 mm spray tip, apply 2-4 coats continuously until desired leveling is achieved.

No flash time is required between coats

NUMBER OF COATS:

Apply 2-4 wet coats

FLASH TIMES:

0-1 minute flash time between coats

PURGE TIME:

No purge prior to baking

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DRYING TIMES:


AIR DRYING	TIME	FORCE DRYING	TIME
Flash Per Coat	0-1 Minute	Flash Per Coat	0-1 Minute
Dust Free	1-2 Minutes	Flash Prior To Force Drying	None
Air Dry	30-45 Minutes	Bake Time	5-8 Minutes @120°F to 140°
	Depending on hardener speed		Depending on hardener speed

RECOATABILITY:

Rapid Dry Clearcoat may be re-coated after bake cycle when wheel has completely cooled down. Air dry repair can be done after 1-3 hours. For best results in air dry situations repair next day.

FILM THICKNESS:

Approximately 0.8-1.0 mil per single coat.

POLISHING:

Sanding / Compounding / Polishing

**This can be done as soon as: Force Drying = After cool down
Air Drying = 30-45 minutes**

Sanding: Light de-nib with 2000 grit wet

Compounding: Foam compound pad

Polishing : Foam polishing pad

DECALS:

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

CLEANING EQUIPMENT

Clean equipment immediately with lacquer thinner.

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TECHNICAL DATA:


Color	Clear
Activator/Hardener	Fast, Medium or Slow High Performance Clear Hardeners
Mix Ratio	4:1
Reducer	Optional: 1- 5% Wheelkote Fast, Medium, or Slow Reducer only if needed
Additives	WK.162110 Fish-Eye Eliminator
Number of Coats	2-4 wet coats
Flash Time	1-2 minutes
Purge Time	None
Dry Time	30-45 minutes @ 75°/24°C 5-8 minutes @ 120°F to 140°F
Gun Set-Up	Refer to Table on Page 2
Air Pressure @ Gun	Refer to Table on Page 2
Pot Life:	1 hours @ 72°F
Sprayable V.O.C.	4.2 lbs/gal (500 g/l)
Package Size	Quart / Gallon
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.

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