




HIGH TECK TECHNICAL DATA SHEETS


2.1 MS FINISH CLEAR

HIT.8620-1 2.1 MS FINISH CLEAR
 HIT.8621-4 2.1 MS FAST ACTIVATOR
 HIT.8622-4 2.1 MS MEDIUM ACTIVATOR
 HIT.8623-4 2.1 MS SLOW ACTIVATOR




 8620 is a 2K ready to spray premium quality overall clear. 8620 possesses a “water white” color that eliminates concerns of color change over some basecoat colors, especially white. 8620 has excellent buffing capabilities and ultimate gloss appearance.


	COMPONENTS	
	• 8620-1	2.1 MS FINISH CLEAR
	• 8621-4	Fast – Low VOC Activator
	• 8622-4	Medium – Low VOC Activator
	• 8623-4	Slow – Low VOC Activator

 **MIXING RATIO**
 Mix four (4) parts 8620 clear with one (1) part selected activator, 8620 is ready to spray after activation.


 **POT LIFE**
 2 hours @ 77° F/25° C

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

	PHYSICAL DATA	
	Solids wt. (as mixed)	37.5%
	VOC as mixed (restricted areas) (Using Low VOC Activator)	2.0 lbs/gl
	Color	Water white

	DRY / FLASH TIMES	
	Air Dry at 77° F/25°C	10-20 minutes
	Flash between coats	35 minutes
	Dust free	20-30 minutes
	Tack free	20-30 minutes
	Sand & Buff	12-24 hours (air dry) @77° F/25° C

Force Dry
 Flash before force dry 15 minute flash
 Force dry time 35 minutes @140° F/60°C
 Sand & Buff after 2 hour cool down


 **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	
	Compliant	
	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**
 Clean substrate free of grease, dirt, and foreign contaminants.

APPLICATION AT 77° F/25° C

-  • Apply 2 medium wet coats over substrate to desired film thickness
- Allow 10 – 15 minutes between coats
- Scuff after 24 hours before recoating
- Clean gun after spraying is completed

 **SAFETY**
 Refer to Material Safety Data Sheet (MSDS) 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.