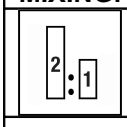
2500V 2.1 VOC EUROPEAN CLEARCOAT

DESCRIPTION:
2500V 2.1 V.O.C. European Clearcoat is formulated with premium European resins. This water clear formula utilizes the best UV stabilizer system to prevent yellowing. It has superior vertical stability avoiding runs. 2500V mixes 2 to 1 with a versatile activator system for various temperature ranges. It can be applied in air dry or bake environments.

FEATURES:
- Easy to spray, excellent leveling
- Superior Gloss-2501V
- Excellent adhesion to acrylic and polyester basecoats
- Superb flexibility prevents chipping on bumper covers and front-end parts
- Two-coat system
- Guaranteed Performance

COMPATIBLE SUBSTRATES:	
	➢ Acrylic or polyester basecoats ➢ Activated polyurethane enamel (must be cured at least 8 hours) ➢ Activated acrylic urethane enamel (must be cured at least 8 hours)
INSTRUCTIONS:	
	Make sure product is at room temperature 72°F (22.2°C) before mixing
GUN SETUP:	
	➢ Conventional Gravity 1.3mm -1.4mm 40-45 psi @ gun ➢ Siphon 1.3mm -1.4mm 40-45 psi @ gun ➢ HVLP gravity 1.3mm -1.4mm 8-10 psi @ gun ➢ Fluid Adjustment for 1.3 mm nozzle—turn out 3 to 3 ½ full turns ➢ Fluid Adjustment for 1.4 mm nozzle--- turn out 3 to 3 ½ full turns
MIXING:	
	Mix 2 parts 2500V 2.1 VOC EUROPEAN CLEARCOAT to 1 part 2520V/ 2521V/ 2522 activator according to temperature and spray area. Optional: 10% Zero VOC Urethane Grade Reducer
	Activators: -2520V - 60°F-75°F (12.6°C-23.9°C) -2521V - 75°F-90°F (23.9°C-32.2°C) -2522V - 90°F & Up (32.2°C & Up)
	Reducers: – *Zero V.O.C.* Reducer-Fast – *Zero V.O.C.* Reducer-Medium – *Zero V.O.C.* Reducer-Slow – *Zero V.O.C* . Reducer- Ex-Slow **Optional** - 2500V 2.1 VOC EUROPEAN CLEARCOAT *can be reduced 5-10% with Zero V.O.C. Reducers. Adding reducer will decrease dry film thickness (DFT). Adding other standard grade urethane reducers will increase V.O.C.'s. NOTE: use slow reducer for bake applications*
SURFACE PREPARATION:	
	Wash area with soap and warm water. Thoroughly clean area with90 Final-Clean . 95 Water Base Pre clean must be used where more strict V.O.C. regulations apply.

APPLICATION:

1. Apply basecoat color per recommended procedures.
   Note: Allow activated polyurethane and acrylic enamel systems to cure at least eight hours
2. Apply two wet coats of 2500V using 40-45 psi at the gun for conventional guns and 8-10 psi for an HVLP gun.
3. Allow 10-15 minutes flash between coats.
   (Optional) On small jobs (i.e. fenders & doors), one tack coat can be applied, followed by one full wet coat with no flash time between coats. Tack coat must be applied evenly.
4. Dry Times:
   Dust Free: 8-10 minutes depending on temperature and activator selection
   Tack Free: 8-10 minutes
   Purge Time: 10 minutes
   Force Dry: 35 minutes @ 140°F (60°C)
   Sand/Buff Time
   Air Dry: 8-12 hours
   Bake: After cool down
   Time to stripe:
   Air Dry: 8-12 hours
   Bake: After cool down
   Time to decal:
   Air Dry: Next day
   Bake: After Cool Down
   Time to deliver
   Air Dry: Next Day
   Bake: After Cool Down
   Time to recoat
   Air Dry: 8-12 hours
   Bake: Immediately after cool down
   Note: If recoating after 24 hours, scuff sand with 1000-1200 grit sandpaper before recoating. In sand-thru areas, apply heat before applying additional coatings to eliminate featheredge lifting.

BLENDING:

1. Apply first coat of clearcoat
2. Extend second coat of clear past first coat
3. Mix the remaining clearcoat 1:1 with Choice of Zero VOC Reducer
4. Apply mixture over the edge of the clear with 50% overlap to melt in the edge.
5. To further melt-in the remaining edge, apply 100% Zero VOC Reducer or a color blender.

SANDING: ***(Prior to buffing process)***

Use 1500/2000 grit or finer wet sandpaper or use a foam interface pad with P1500/2000 grit or finer DA paper.

- 2500 can be wet sanded and buffed in 8-12 hours (air dry). In a bake situation, it can be lightly de-nibbed or sanded after cool down. Depending on length of cure time before buffing, a wool, finishing or foam pad could be used. Apply a straight line of liquid to a 2-3 foot area. Set the buffer at 1200-1800 RPM's. Use a 50% overlap. Wipe off excess material with a micro-fiber cloth.

TIPS FOR SUCCESS:

- Always use clean water to wet sand and add a few drops of soap to help clear the paper
- Always use a foam interface pad when DA sanding.
- Do not use medium to heavy duty compounds.
- Use clean micro-fiber cloths and pads to minimize scratching of the clearcoat.

TECHNICAL DATA

Technical Data Sheet

Color	Water Clear
Activator/Hardener	2520V / 2521V / and 2522
Reducer	Z80 / Z81/ Z82 ZERO VOC REDUCERS
Mix Ratio	2:1 Reducer Optional
Pot Life	2. hour @ 72°F (22.2°C) 50% RH
Number of Coats	2 Full Wet Coats
Flash Time (between coats) Flash Time (Before bake)	10-15 minutes 10 minutes
Dust Free	8-10 minutes
Tack Free	8-10 minutes
Dry to Sand 75°F (23.8°C) 50% RH	8-12 hours
Bake 45 minutes @ 140°F (60.0°C)	After cool down
Delivery--Air Dry	Next Day @ 72°F (22.2°C)
Force Dry	After Cool Down
Force Dry (metal temperature)	10 minute purge time 35 minutes @ 140°F (60.0°C)
Gun Set-Up -- Gravity Feed	1.3mm – Turn out 3 full turns
(HVLP)	1.4mm – Turn out 2 ½ full turns
Air Pressure @ Gun, HVLP	8 – 10 psi
Air Pressure @ Gun, Conventional	40 -45 psi
Dry Film Thickness / coat (DFT)	1.0
Regulatory V.O.C. Limit (CA)	2.1 lbs/gal (252 g/l)
Regulatory V.O.C.	1.29 lbs/gal (155 g/l)
Actual V.O.C.	55 lbs/gal (65 g/l)
Sprayable V.O.C.* 2520V / 2521V / 2522	2.1 lbs/gal (252 g/l) 2.1 lbs/gal (252 g/l) 2.1 lbs/gal (252 g/l)
% Solids Sprayable by Weight	40.4% (unreduced)
Coverage Sq. Ft. / gal @ 1 mil*	460
Package	
Clear	5 liters (1.32 U.S. Gallons)
Activator	2.5 liters (.66 U.S. Gallons)
Number per case	2
Shelf Life	12 months