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## HS21 CLEAR (LOW VOC)

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**DESCRIPTION:** HS21 Clear is a low VOC, two-component high solids polyurethane clearcoat. Provides a high gloss finish with only two coats. Flow and leveling is achieved with a minimum effort. Can be used over U-Tech Polybase Plus and cured 2.8 HSP single stage.

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### PRODUCT & ADDITIVES:

**PRODUCT:** HS21 Clear

**ACTIVATOR:** HS21 Activator/Hardener: An activator/hardener designed for all refinishing. Temperatures from 60°F (16°C) and above.

**ACCELERATORS:**

- 994 Super Accelerator: a very fast accelerator for spot and panel repairs.
- 995 Blocked Accelerator: speeds cure and increases potlife. Designed for larger areas and warmer temperatures. Temperatures up to 90°F (32°C).
- 996 Supercharger: speeds cure and increases potlife. Designed for larger areas and cooler temperatures. Temperatures from 60°F–75°F (16°C–24°C).

**ADDITIVES:**

- 997 Enhancer: increases potlife and slows flash-off, allowing for better sprayability and overspray melt-in at high temperatures. Temperatures from 100°F (38°C) and above.
- U-Tech LV Flex Agent: Additive to increase flexibility of HS21 Clear for use on flexible parts.
- T890 Flatting Agent: A matting agent designed to reduce the gloss level of HS21 Clear down to eggshell or matte if desired.

**BASIC RAW MATERIALS:**

- HS21 Clear: hydroxyl acrylic resins
- HS21 Activator: polyisocyanate resins and solvent

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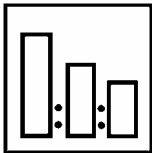
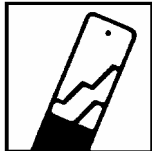

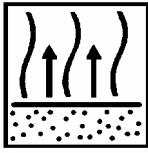

### SUITABLE

**SUBSTRATES:**

- U-Tech Polybase Plus Solid, Metallic and Pearl Colors: after a flash-off time of 20–30 minutes at 70°F (20°C).
- Existing finishes that have been sanded and degreased. In the case of spot repairs and blending, see TDS “Spot Repairs with Polybase Plus”.

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### Application:

1.  Contains acrylic resins and other ingredients. When mixed, also contains isocyanates.
2.  4:1  
HS21 Clear  
HS21 Activator/hardener
3.  Use the U-Tech Measuring Stick
4.  **1.5 x 1 or 2-3 x 1**  
Spray one coat followed by a cross coat or two to three single flowing coats.
5.  10-15 minutes at 70°F (20°C)
6.  12 hours at 70°F (20°C)  
45 minutes at 140°F (60°C)

### SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure	Fluid Pressure
Pressure Feed	1.0–1.2 mm	40–50 psi	8–10 psi
HVLP Siphon	1.8–2.2 mm	max. 10 psi	
HVLP Gravity	1.4–1.5 mm	max. 10 psi	

### APPLICATION METHOD:

HS21 Clear can be Sprayed in one coat followed by a cross coat or two to three wet flowing coats allowing 10-15 minutes flash between each coat.

**NOTE:** For clearcoat spot repair and over reduction (sail panel blends), use U-Tech R201 Blending Reducer. Please see TDS "Spot Repairs with Polybase Plus".

### SPRAYING VISCOSITY:

16 seconds ZAHN cup #2 (13 seconds DIN #4) at 70°F (20°C).

### POT LIFE:

4 hours at 70°F (20°C)

### POLISHING:

Dust and minor damage can be polished out after the stated air-dry times have been reached, or after a full bake at 140°F (60°C) metal temperature followed by a cool down of panel to ambient temperature. Carefully sand out dust particles with #10 micron (#1500) grit paper wet, and then polish the area manually or mechanically

### NOTE:

When heavy color sanding and rubbing are required, it may be necessary to apply one extra coat of HS21 Clear.



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**DECALS:** Decals can be applied after 48 hours at 70°F (20°C).

**LETTERING:** Enamel striping or lettering on HS21 Clear must be applied within 48 hours for good adhesion. After 48 hours scuff with a gray scuffing pad.

**DRY FILM THICKNESS:** Approximately 2.1 mils per single coat.

**DRYING TIMES:** Below is a chart indicating drying times:

Metal Temp.	Drying	HS21 Clear & HS21 Activator
70°F (20°C)	Dust Free	45 min.
	Dry	12 hours
140°F (60°C)	Dry	45 min.

Below is a chart indicating various drying times with HS21 Activator and the U-Tech accelerators:

Metal Temp.	Drying	994 Super Accelerator	995 Blocked Accelerator	996 Supercharger
70°F (20°C)	Dust Free	30 minutes	1 hour	50 min.
	Dry	4 hours	6 hours	5 hours
140°F (60°C)	Dry	N/A	35 min.	30 min.

**PRODUCT SPECIFICATIONS:**  
(Testing at 70°F Ready to Spray)

	HS21 Clear
Pencil Hardness:	5H
Electrostatic Sprayability: Rating 1-10 (10 being best)	.2 MΩ 4 Rating
Chemical Resistance	>200 MEK RUBS – no failure

**QUV WEATHERING:**  
(5000 HOURS UVA 340 BLUB)

60°	85% gloss (Initial)
20°	93% gloss (Initial)
60°	85% gloss (Final)
20°	93% gloss (Final)



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**CLEANING OF  
EQUIPMENT:**

Use Extra Strong Cleaning Solvent, or lacquer thinner.

**COVER RATE:**

Approximately 734 sq. ft./gallon at a film thickness of 1.0 mils. HS21 Clear should be applied at a minimum film thickness of approximately 2.0 mils, applying 1 cross coat should achieve this.

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**STOCK KEEPING:**

**COLOR:** Clear

**SHELF LIFE:**  
—HS21 Clear: Two years if stored unopened at room temperature.  
—HS21 Activator: One year if stored unopened at room temperature.

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**SAFETY ASPECTS:**

**READY TO  
SPRAY VOC:**

HS21 Clear:	2.1 lb/gal	252 g/liter
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**NOTICE:**

Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.