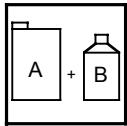


PRO-2021 Low VOC Clear

PRO-2021 Low VOC Clear is a high-solids, multi-use clear designed for an easy-to-apply, high gloss finish. PRO-2021 offers superior gloss, high build, and outstanding resistance to shrinkage and dieback.



Mix Ratio:

<u>Component</u>	<u>Volume</u>
PRO-2021 Low VOC Clear	4
PRO-61 Activator	1
PRO-2060/70/85/95 Reducer	1

Viscosity

16-20 seconds in #2 Zahn Cup

Pot Life

2 hours at 70°F



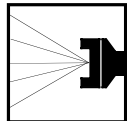
Gun Setups:

Conventional

Siphon Feed:	1.3 mm – 1.6 mm (0.050" – 0.063")
Gravity Feed:	1.3 mm – 1.6 mm (0.050" – 0.063")

HVLP

Siphon Feed:	1.3 mm – 1.6 mm (0.050" – 0.063")
Gravity Feed:	1.3 mm – 1.6 mm (0.050" – 0.063")



Air Pressures

Conventional

Siphon Feed:	Panel 45-55 psi at the gun	Overall 45-55 psi at the gun
Gravity Feed:	45-55 psi at the gun	45-55 psi at the gun

HVLP

8-10 psi at the gun	8-10 psi at the gun
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Application:

1. Allow basecoat to dry 15-30 minutes – 30 minutes if applying multiple coats of pearl or if shop is below 70°F.
2. Apply 2 wet coats of PRO-2021 with 10 minutes flash between coats.
3. Do not apply more clear after 1 hour from completion.

PRO-2021 Low VOC Clear



Flash/Dry Times (Air Dry):

Flash Between Coats:	10 minutes
Dust Free:	45 minutes
Time to Assemble	Overnight
Time to Polish	Overnight
Time to Stripe	Overnight
Time to Deliver	Overnight
Time to Decal	48 hours

Flash/Dry Times (Bake @ 140°F):

Flash Before Bake	0-5 minutes
Cycle Time	30 minutes at 140°F metal temperature
Dust Free	At cool down
Time to Assemble	At cool down
Time to Polish	20 minutes after cool down
Time to Stripe	20 minutes after cool down
Time to Deliver	At cool down



Polishing:

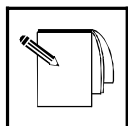
Optimum Times:	Air Dry: Overnight @ 70°F; Bake: 20 minutes after cool
Sanding:	Use 1500 grit or finer or use 1500 DA or finer
Compounding:	Use finishing compound. Apply a thin ribbon of material to the area to be polished. Use a double sided wool pad or a foam pad. Maintain air polisher or variable speed polisher at 1800-3000 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polishing.



Safety:

Before using any Carolinas Pro-Finish products be sure to read all safety warnings and MSDS. Please read all directions carefully.

For professional use only by trained painters. Not for sale or use by the general public.



Technical Data & Physical Properties:

Color	Clear	Sprayable Viscosity	16-20 sec. #2Z
Pot Life	2 hours	Mix Ratio	4:1:1
Weight Solids	45%	Volume Solids	38%
Gloss	Excellent	Weight per Gallon	8.30 lbs
Color Holdout	Excellent	Buff Times	8-12 hours @ 70°F
Humidity Resistance	Excellent	Flash Point	25°C
Solvent Resistance	Excellent	Package VOC	3.90
lbs/gal Repairability	Excellent	RTS VOC	4.20 lbs/gal
Florida Exposure	Excellent	Chip Resistance	Very Good