VALOREM

PROGRAMMED SYSTEM TECHNIQUE (PST)
CLEARCOATS
NORTH AMERICA

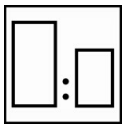
VC-221LV 2:1 CLEAR LV

Valorem VC-221LV 2:1 Clear LV clearcoat is a VOC compliant acrylic urethane clearcoat for use over Valorem Basecoat. VC-221LV 2:1 Clear LV offers excellent results in a wide variety of conditions with excellent gloss and easy detailing - making it an ideal choice for air dry environments at a 2.1 lb/gal VOC.

SAFETY CONSIDERATIONS
Use suitable personal protection.

SURFACE PREPARATION
- Refinish Basecoat
  - Wait until the basecoat's indicated flash time before clear application
- Existing Clearcoat
  - Thoroughly abraded with P1000 dry or a gray scuff pad

SURFACE CLEANING
- Use suitable surface cleaners and technique to ensure a clean surface



MIXING

Mix	Standard Mix
2	Parts Valorem VC-221LV 2:1 Clear LV
1	Part Valorem VH-221LV 2:1 Clear LV Hardener

BY VOLUME

EQUIPMENT

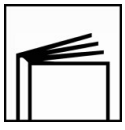
Spray-Gun Set-Up
- 1.3 – 1.4 mm HVLP Gravity
- 1.3 – 1.4 mm Compliant

Application Air Pressure
- HVLP – 10 psi (<0.7 bar) at cap maximum
- Consult manufacturer specifications

APPLICATION
- 2 single wet coats
  - Flash 5-10 minutes between coats

DRYING

	At 70°F (21°C)	At 120°F (49°C) (Ambient)
• VC-221LV 2:1 Clear LV – Dust Free	• 15 minutes	– 5 minutes
• VC-221LV 2:1 Clear LV – Dry to Handle	• 1 to 1.5 hours	– 25 minutes
• VC-221LV 2:1 Clear LV – Dry to Polish	• 1.5 to 2.5 hours	– 30 minutes



RECOATABILITY
- May be recoated with itself at any stage for up to 24 hours without sanding
  - After 24 hours, the surface must be abraded before recoating

Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information

VC-221LV 2:1 CLEAR LV

DESCRIPTION

Valorem VC-221LV 2:1 Clear LV clearcoat is a VOC compliant acrylic urethane clearcoat for use over Valorem Basecoat. VC-221LV 2:1 Clear LV offers excellent results in a wide variety of conditions with excellent gloss and easy detailing - making it an ideal choice for air dry environments at a 2.1 lb/gal VOC.

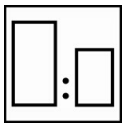
PRODUCT ASSORTMENT

- Valorem VC-221LV 2:1 Clear LV
  - Item #596191 (Gallon)
- Valorem VH-221LV 2:1 Clear LV Hardener
  - Item #596192 (Gallon)

- Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).
- Refer to the Product Shelf Life Overview TDS or the current price list for the most up-to-date shelf-life information.

SURFACE PREPARATION

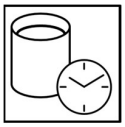
- Refinish Basecoat
  - Wait until the basecoat instructions indicated flash time before clear application
- Existing Clearcoat
  - Thoroughly abraded with P1000 dry or a gray scuff pad
  - Use suitable surface cleaners and technique to ensure a clean surface



BY VOLUME

MIXING

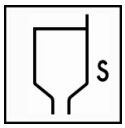
Mix	Standard Mix
2	Parts VC-221LV 2:1 Clear LV
1	Part VH-221LV 2:1 Clear LV Hardener



POT-LIFE WHEN MIXED

Product Mix — **At 70°F (21°C)**

- Valorem VC-221LV 2:1 Clearcoat LV — 45 Minutes
  - ✓ A shorter pot-life can be expected in higher temperatures



VISCOSITY – READY TO SPRAY

14-16 Seconds

- Measured with a DIN #4 viscosity cup at 70°F (21°C).

SPRAY-GUN SET-UP

Spray-Gun Set-Up	Application Air Pressure
• 1.3 – 1.4 mm HVLP Gravity	– HVLP – 10 psi (<0.7 bar) at cap maximum.
• 1.3 – 1.4 mm Compliant	– Consult manufacturer specifications.

APPLICATION

- Apply 2 single wet coats
  - Flash dry between coats

FLASH DRYING

Flash Between Coats at 70°F (21°C)

- 5 – 10 minutes.

Flash at 70°F (21°C) Before Force Drying

- 3 – 5 minutes.

✓ Flash time is dependent on temperature and application

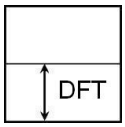
DRYING / CURING TIME

	At 70°F (21°C)	At 120°F (49°C) (Ambient)
• VC-221LV 2:1 Clear LV – Dust Free	– 15 minutes	– 5 minutes
• VC-221LV 2:1 Clear LV – Dry to Handle	– 1 to 1.5 hours	– 25 minutes
• VC-221LV 2:1 Clear LV – Dry to Polish	– 1.5 to 2.5 hours	– 30 minutes

  - When baked, allow repair to cool down for approximately 1 hour before polishing

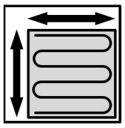
RECOATING

- After a full drying cycle, may be recoated with itself for up to 24 hours without sanding
  - After 24 hours, the surface must be abraded before recoating



FILM THICKNESS – USING SUITABLE APPLICATION

- 1 coat will achieve a thickness of 1.2-1.5 mils (30-38 µm)
- The minimum clearcoat film thickness to provide suitable protection and appearance over basecoat is 2.4 mils (61µm)



THEORETICAL COVERAGE

- With the recommended application the theoretical coverage is ≈675 ft^2/gallon (≈16.5 m^2/liter) at a 1 mil thickness (25.4 µm)
- Actual coverage is dependent on many factors which may include the shape of the object, surface smoothness, application technique, and other application variables

VOC / REGULATORY INFORMATION

Notice: Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on 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.

- The VOC content of VC-221LV 2:1 Clear LV ready to use is ≤2.1 lb/gal (≤250 g/L)

VC-221LV 2:1 CLEAR LV

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FOR PROFESSIONAL USE WITH SUITABLE HSE EQUIPMENT

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