VALOREM

**PROGRAMMED SYSTEM TECHNIQUE (PST)**
**CLEARCOATS**
**NORTH AMERICA**

## VC-223LV 2:1 Clear

Valorem VC-223LV Clear is a VOC compliant acrylic urethane clearcoat for use over Valorem Basecoat. VC-223LV offers excellent results in a wide variety of conditions with excellent gloss and easy detailing - making it an ideal choice for air dry or low-bake environments at a 2.1 lb/gal VOC.

### SAFETY CONSIDERATIONS

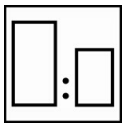
- Use suitable personal protection.
- When exposed to paint or solvents, AkzoNobel recommends the use of a fresh air supply respirator.

### SURFACE PREPARATION

- Refinish Basecoat
  - Wait until the basecoat TDS indicated flash time before clearcoat 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**

| | |
|---|---|
| 2 | Parts Valorem VC-223LV Clear |
| 1 | Part Valorem VH-221LV Hardener |

**BY VOLUME**

### EQUIPMENT

**Spray-Gun Set-Up**

- 1.3 – 1.4 mm HVLP Gravity
- 1.3 – 1.4 mm Compliant

**Application Air Pressure**

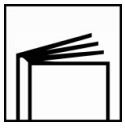
- HVLP – 10 psi (<0.7 bar) at cap maximum
- Consult manufacturer specifications

### APPLICATION

- 2 single wet coats
  - Flash 5-10 minutes between coats and 5-10 minutes before force dry

### DRYING

| | At 70°F (21°C) | At 120°F (49°C) (Ambient) |
|---|---|---|
| • VC-223LV – Dust Free | • 15 – 20 minutes | – 5 – 10 minutes |
| • VC-223LV – Dry to Handle | • 1.5 – 2 hours | – 30 – 40 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

## DESCRIPTION

Valorem VC-223LV Clear is a VOC compliant acrylic urethane clearcoat for use over Valorem Basecoat. VC-223LV offers excellent results in a wide variety of conditions with excellent gloss and easy detailing - making it an ideal choice for air dry or low-bake environments at a 2.1 lb/gal VOC.

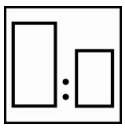
### PRODUCT ASSORTMENT

- Valorem VC-223LV Clear – Item #601306 (Gallon)
- Valorem VH-221LV 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 TDS indicated flash time before clearcoat application.
- Existing Clearcoat
  - Thoroughly abraded with P1000 dry or a gray scuff pad.
  - Use suitable surface cleaners and technique to ensure a clean surface.

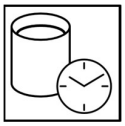


BY VOLUME

### MIXING

| Mix | By Volume |
|---|---|
| 2 | Parts VC-223LV Clear |
| 1 | Part VH-221LV Hardener |

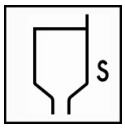
✓ VC-223LV Clear does not require flex additive for flexible parts



### POT-LIFE WHEN MIXED

| Product Mix | At 70°F (21°C) |
|---|---|
| • Valorem VC-223LV Clear | 1.5 hours |

✓ 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 – 1.5 mm HVLP Gravity | – HVLP – 10 psi (<0.7 bar) at cap, maximum. |
| • 1.3 – 1.5 mm Compliant | – Consult manufacturer specifications. |

**APPLICATION**

- Apply 2 single wet coats
  - Flash dry between coats
  - If heavy sanding and polishing is required, a third coat may be applied after observing the indicated flash time.

**FLASH DRYING**

| Flash Between Coats at 70°F (21°C) | Flash at 70°F (21°C) Before Force Drying |
|---|---|
| • 5 – 10 minutes | • 5 – 10 minutes |

✓ Flash time is dependent on temperature and application

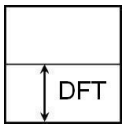
**DRYING / CURING TIME**

| Ambient Temperature | At 70°F (21°C) | At 120°F (49°C) |
|---|---|---|
| • VC-223LV – Dust Free | – 15 to 20 minutes | – 5 to 10 minutes |
| • VC-223LV – Dry to Handle | – 1.5 to 2 hours | – 30 to 40 minutes |

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

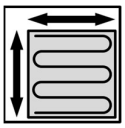
**RECOATING**

- 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-223LV ready to use is ≤2.1 lb/gal (≤250 g/L)

## VC-223LV 2:1 Clear

**AkzoNobel Inc., North America**
**Address: 1845 Maxwell Street – Troy, MI USA**
**Tel: 800.618.1010**

**FOR PROFESSIONAL USE WITH SUITABLE HSE EQUIPMENT**



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