

EX-2C Clear 221

Endura EX-2C Clear 221 is a ready to spray automotive clear. It is formulated to maximize UV resistance and maintain a clear durable finish.

Product Features

- ◆ Excellent protection against acids and alkalis
- ◆ Exceptional ultraviolet light protection
- ◆ Available in high and reduced gloss
- ◆ A durable, self prime coatings for wood floors

Theoretical Solids Content:

Volume: 29%

Shelf Life*

Component A: (3) years
Component B: (1) year

*For unopened product.

Pot Life of Mixed Product:

8-10 Hours* @ 77°F (25°C) and 50% RH

*Less when Endura Super Catalyst II is used.



Suitability

EX-2C Clear 221 is a clear coating designed to give extra UV protection and higher gloss. The UV light stabilizer contained in the EX-2C Clear 221 will increase the service-life of less finished surfaces including solid colors, metallic and pearl colors, and fluorescent coatings.



Surface Preparation

Ensure that surfaces to be clear coated are free of flaws, surface contaminants, and other imperfections. If the surface has been allowed to cure longer than 24 hours, sanding will be required to achieve intercoat adhesion. Sand topcoat lightly with 600 grit sandpaper or 3M White Scuff Pads.

Do not sand Metallic or Pearl colors.

Do not mix Clear 221 with color for final coat.



Mixing Ratio

2 parts by volume of component A [CLRTB221]
1 part by volume of component B [FUB0100]

The recommended temperature when mixed is 20-25°C (68-77°F).

Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be between 20°C-25°C* (68°F-77°F). To prevent condensation during application the surface temperature must be 3°C (5°F) or more above the dew point at all times.

*for use outside this range please contact your Endura representative.



Spraying Viscosity*

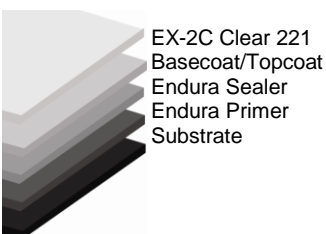
Using a Ford 4 Cup (white)	
13 Seconds *	reduce as necessary *
Conventional	Airless

* Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and on the desired surface finish.



Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.3-1.4 mm	30-40 psi	
Pressure Feed	1.0-1.4 mm	55-65 psi	10-14 oz/min
Air Assist Airless	9-11 Thou	1,000-1,800 psi	
Airless	9-11 Thou	1,700-3,000 psi	



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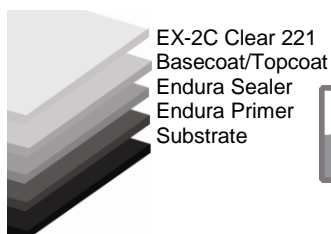
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Application Method

Apply two wet coats with 20 – 60 minutes between coats. Note: EX-2C Topcoats require a drying time of 8 -10 hours before application of EX-2C Clear 221. Drying time can be reduced with accelerator*.

*Refer to the Super Catalyst II Datasheet

Recommended Film Build Thickness and Cover Rate

Endura EX-2C Clear 221 has a recommended film thickness of:

Wet (unreduced): 3.5 – 5.0 mils wet (87.5 – 125 microns)

Dry: 1.0 – 1.5 mils dry (25 – 37.5 microns)

Theoretical coverage at 1.0 mil (25 microns) DFT: 464 ft² per gallon @ 100% transfer efficiency.



Drying Time*

Recoats or clear coating may be applied after 4-6 hours. After 24 hours, sand with 400 -600 grit sandpaper to achieve intercoat adhesion.

* Please note that the use of Super Catalyst II with Endura topcoats will accelerate drying times.

	20°C (68°F)	30°C (86°F)	40°C (104°F)
Dust Free	2 Hours	1 Hour	30 Minutes
Full Cure	7-14 Days		

* Subject to ambient conditions (temperature and humidity) film build and good airflow. For improved scheduling please contact your Endura representative.

Specifications

Hardness	ASTM D3363	4H
Solvent resistance	ASTM D4752	100 MEK rubs; NO failure
Abrasion resistance (1000 cycles CS-17)	ASTM D4060	25 mg loss
Impact resistance	ASTM D2794	80 in. lbs; NO failure
Flexibility	ASTM D522	1/8" mandrel bend; NO failure
VOC	For VOC amounts please refer to the product MSDS	



Clean Up

Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.