



# CC-421LV

## 2K PREMIUM LOW VOC 4:1 HS URETHANE CLEAR COAT

# TECHNICAL DATA SHEET

### I. COMPONENTS

- CC-421LV PREMIUM MS URETHANE CLEAR COAT
  - CC-42LVS SLOW 4:1 ACTIVATOR
  - CC-42LVM MEDIUM 4:1 ACTIVATOR
  - CC-42LVF FAST 4:1 ACTIVATOR
    - CB-018 ACCELERATOR
    - CB-013 HIGH TEMP REDUCER

### II. SAFETY CONSIDERATIONS

Contents are flammable. Keep away from heat, sparks and flame. Product is intended for professional use only. Use suitable protection. The use of an air supply respirator, gloves and a paint suit are recommended. This product is intended for use under controlled conditions: Adequate ventilation is required to prevent vapor build up. Please refer to our Safety Data Sheet (SDS) for complete safety information.

### III. CC-471- APPLICATION & MIXING CHARTS

#### Spray Settings

 <b>Gun Settings</b>	<u>Fluid Tip (HVLP)</u>	1.3-1.4 mm
	<u>Pressure (HVLP)</u>	<10 psi @ air cap
	<u>Gravity Feed Tip</u>	1.3 -1.4 mm
	<u>Pressure(Gravity Feed)</u>	<10 psi @ air cap







#### Mixing Ratios

 <b>Mix Ratio</b>	<b>A= CC-421LV Clear Coat</b>	<b>A:B:C HS Spray</b>	<b>A:B:C MS Spray</b>
	<b>B=CC 42LV M/F/S Activator</b>		
	<b>C= Urethane Grade Reducer</b>	<b>4:1:0</b>	<b>4:1:1</b>


#### Mixing Ratio Guidelines

CC-421LV can be reduced up to 4:1:1 as a medium solids clear. At a 4:1:1 mixture, CC-421LV has about 36% sprayable solids content. To comply with the regulations of all 50 States and Canada, use only LOW or 0 VOC reducer when reducing CC-421LV.





## Application Times

Times	Air Dry 75°F(24°C)	Force Dry 135°F(57°C)	Times	Air Dry 75°F(24°C)	Force Dry 135°F(57°C)
Flash Times 	After 1 <sup>st</sup> Coat: 5-10 min. After 2 <sup>nd</sup> Coat: 10-15 min.	After 1 <sup>st</sup> Coat: 5-10 min. After 2 <sup>nd</sup> Coat: 10-15 min.	Dry to Deliver 	1-2 Panels: 6-8 Hrs. 3 Panels-Overall: 12 Hrs.	25 min. Allow 45 min. cooldown
Dust Free Times 	1-2 Panels: 20-25 min. 3 Panels-Overall: 45-60 min.	The panel will be dust free coming out of cure.	Recoat Time 	Additional Coats can be added until dust-free time	Sanding is required after curing
Dry to Polish 	1-2 Panels: 6-12 Hrs. 3 Panels-Overall: 12-24 Hrs.	25 min. Allow 45 min. cooldown	Pot Life 	2-3 Hours	2-3 Hours

## IV. General Surface Preparation

	For best results, all substrates must be washed with soap and water. Rinse the surface well and wipe dry with a clean cloth. A scuff pad and scuffing agent is suitable to clean all hydrophilic contaminants on the surface. Wipe with a clean dry cloth. Solvent clean the surface with a <b>Wax and Grease Remover</b> or <b>Pre-Cleaning</b> solvent cleaner. Wipe down with a clean cloth and wipe down. When the surface is dry, you are ready for application.
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## V. Application Recommendations

Number of Coats 	Apply 2 Single Full Wet Coats. If heavy polishing and buffing is desired, a 3 <sup>rd</sup> coat may be applied after flash time.	Use of Accelerator* 	For slow film cure situations: ¼ to ½ fluid oz. of accelerator <b>CB-18</b> is recommended per sprayable quart of clear coat.
Film Thickness* 	Each coat is around 1.1-1.3 mils without reduction. The film thickness should not exceed 3.5mils. <b>If you plan to buff after more than 24 hours from application, we recommend applying a 3<sup>rd</sup> to coat for an easier buff application.</b>	Wet Sand-Polish* 	If buffing is desired, sand with 1200 grit sandpaper and work your way up to finer until the texture you want is reached. <b>Buffing becomes more difficult as more time after its delivery time has passed.</b>

### **WHEN USING ACCELERATOR:**

The painter should bear in mind that the speed of solvents/activator governs the solvent speed while the use of accelerator governs the speed of the film cure. It is important to properly assess the drying problem before deciding to use a faster activator/reducer or using accelerator. When spraying a medium solids clear coat like **CC-421LV** the use of reducer is not recommended because the addition of reducer could lead to an insufficient film build. Use caution when using Accelerator. Keep in mind that the use of accelerator interferes with the intended chemistry of your urethane formation. Too much accelerator could be detrimental to your paint job. **The addition of accelerator could lead to film shrinkage, a loss of gloss, and/or incomplete cure.**

### **FILM THICKNESS GUIDELINES:**

When trying to predict the mil thickness, it is safe to assume the following:

**1 Full Coat = 1.25 mils**  
**1 Medium(Light Coat) = .70 mils**

**NOTE:** These are only theoretical measurements for quick calculations. Based on the spray gun used, distance from the spray and various other factors, the actual mil thickness will vary.

**Always remember: The higher the film build, the MORE critical it is to wait the appropriate flash time**  
**The higher the film build sprayed on = a longer flash time**

The higher the film build, the longer distance the solvents need to escape the film. A complete disaster full of solvent popping, die back and poor adhesion can happen if you apply the next coat before the solvents of the previous coat have escaped.

### **BUFFING RECOMMENDATIONS:**

We recommend following the instructions of the buffing compound manufacturer. Use caution when using a buffing compound. Too much buffing compound could burn through the clear coat.

### **FISHEYE ELIMINATOR/REMOVER:**

The use of a fisheye eliminator is discouraged. This is because there are already products formulated within the clearcoat to help reduce contamination and the surface tension of the coating. If using a fisheye eliminator is necessary, please use as instructed by the manufacturer. Problems with fisheye will be greatly reduced with proper cleaning and preparation.






### **FLEX ADDITIVE:**

When the flexibility of a product needs to be increased, you can add a flex additive to improve flexibility for application of flexible parts. This product may help when heavy coats of clear coat are applied on a flexible part.

### **IMPORTANT INFORMATION ABOUT USING REDUCER:**

It is important to **ONLY** use URETHANE GRADE REDUCER. Lacquer thinner and other grades of reducer can cause defects in the film as they are not able to dilute the film properly. This can ruin the overall flow and rheology of the clear coat. Adding quality should immediately drop the viscosity of the clear coat. A poor grade of reducer will not reduce the viscosity of the paint and will lead to problems in the appearance of the clear coat. For 50 State Compliance, use either 0 or LOW VOC reducer. CARB and SQAMD require a final application VOC of no more than 250 g/L or 2.1 lbs./gal. Using a non-compliant reducer can cause the overall coating VOC to go over those limits. CCG Products Inc.® condemns the use of non-compliant reducer in VOC restricted states. We recommend that you follow your local VOC regulations.

## VI. Regulatory/Product Information

<b>Product Specifications</b> 	<b>% Solids Mix (RTS) (Ready-to-Spray)</b>	<b>43.1-44.1%</b>	<b>Product Viscosity RTS (Ready to Spray)</b>		<b>21-23 sec. #2 Zahn</b>	
	<b>Product Density:</b>	<b>lbs./gal.</b>	<b>VOC Content</b> 	<b>Product</b>	<b>VOC Actual</b>	<b>VOC Regulatory</b>
	<b>CC-421LV</b>	<b>8.00-8.40</b>		<b>CC-421LV</b>	<b>~.66 lbs./gal (~79 g/l)</b>	<b>~1.70 lbs./gal (~204 g/l)</b>
	<b>CC-42LV M,F,S</b>	<b>8.70-8.90</b>	<b>Product Description</b>		<b>Transparent liquid</b>	
<b>Cleaning and Product Disposal</b> 	<p>All products must be disposed of according to the regulations of the environmental health authorities. Clean equipment following all local and federal regulations.</p>		<b>Manufacturer Support and Information</b> 		<p>www.catamountcoatings.com            Phone: (980)376-2325            Email : <a href="mailto:support@catamountcoatings.com">support@catamountcoatings.com</a>            1441 E Broad St.            Fuquay-Varina,, North Carolina            27526</p>	
<b>Catamount Product Statement</b> 	<p>Product is intended for professional use only. The information on this data sheet is based on the current state of knowledge on the performance and properties of this product. Any product use for the purpose of anything other than what is explicitly explained or recommended is done at the risk of the product user. It is the responsibility of the user to fulfill the demands of the local and federal rules and legislation. It is important to read the Safety Data Sheet(SDS) and the Technical Data Sheet(TDS) for best understanding of product application. All advice given about our product or process is correct to the best of our knowledge. The quality or condition of the intended substrate or the addition of any product not manufactured by CCG Products for application is not in our control. Therefore, unless specifically agreed upon in writing, we do not accept any liability for any loss or damage arising from improper use of our product. It is the user's responsibility to verify that this data sheet is updated and current prior to using this product. Actual physical data is based on application and the data provided serves as a guideline for theoretical values. If a warranty is issued, it will be offered on replacement on product if fault is found with the product. All brand names in this data sheet are trademarks and/or licensed to CCG Products Inc.</p>					