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TECHNICAL DATA SHEET

KAC21 AUTOMOTIVE CLEAR

01192021



KAC21 is a premium automotive VOC compliant clear. It's distinct "water white" property eliminates concerns of color change, especially over white. KAC21 has outstanding buffing capabilities and a superior gloss for a glamour appearance. Developed specifically for markets with VOC legislation.



COMPONENTS

- KAC21
 - GH065/075/085
 - GH045W/GH055W
- 2.1 VOC Automotive Clear
Fast/Medium/Slow – Low VOC Activators
Very Fast/Super Fast - Winterized Activators



MIXING RATIO

Mix four (4) parts KAC21 clear with one (1) part selected activator. No reducer needed



POT LIFE

2 hours @ 77° F/25° C



CLEAN UP

Use NORTHSTAR Lacquer Thinner or zero VOC solvents. (Check local regulation)



PHYSICAL DATA

Solids wt. (as mixed) 32%
VOC as mixed 2.1 lbs/gal – 250 gms/ltr.
Color Water white



DRY / FLASH TIMES

Air Dry at 77° F/25° C 8-10 minutes
Flash between coats 30 minutes
Dust free 10-20 minutes
Tack free 12-24 hours (air dry) @77° F/25° C
Sand & Buff

Force Dry

Flash before force dry 15 minute flash
Force dry time 40 minutes @140° F/60° C
Sand & Buff After cooldown a 2 hour minimum



COLOR SANDING

Wet sand with 1500 to 2000 wet or dry paper, then buff with appropriate compounds and glazes to achieve a high gloss finish.



GUN SETUPS

Compliant

Gravity Feed 1.3 mm – 1.5 mm
Siphon Feed 1.3 mm – 1.5 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed 30 – 40 psi
Siphon Feed 35 – 45 psi
HVLP at cap 8 – 10 psi



SURFACE PREPARATION

Use NORTHSTAR Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.



APPLICATION AT 77° F/25° C

- Apply 2 medium wet coats over substrate to desired film thickness
- Allow 8-10 minutes between coats
- Scuff after 24 hours before recoating
- Clean gun after spraying is completed



SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

GreenTec