



## TECHNICAL DATA SHEET

### RCC-22 ULTRA SPEED CLEARCOAT – 30 MINUTE

RCC-22 4/1 30 Minutes Urethane Clear Coat is a water white, high quality clearcoat designed for small spot repairs and complete panel repairs over aftermarket basecoat systems. RCC-22 is a super fast dry clear that retains high gloss and DOI and is one of the fastest out of dust clears available today. Depending on temperature and air movement, RCC-22 can be polished to match the original finish after only **30 minutes air dry**. RCC-22 is easy to buff and can be buffed for several days. RCC-22 provides excellent durability and is resistant to environmental conditions such as sunlight and acid rain. RCC-22 can be applied in a variety of shop temperature and humidity conditions and when used as a cut in clear, RCC-22 cuts assembly times making it one of the most versatile clears in the marketplace.

#### Products

<b>RCC-22</b>	4/1 30 Minute UltraCure Acrylic Urethane Clearcoat
<b>RCH-2275</b>	4/1 Imperial Cure Clearcoat Activator - Normal
<b>RCH-2285</b>	4/1 Imperial Cure Clearcoat Activator - Slow
<b>RCH-2295</b>	4/1 Imperial Cure Clearcoat Activator - Very Slow

#### Application

##### Surface Preparation, Bare Substrates

Solvent wash surface with a good grade wax and grease remover and wipe dry with a clean cloth. Apply three single wet coats of An Corrosion Resistant Epoxy Primer•Sealer according to instructions on data sheet. Follow with two to three coats of RCP-50 Grey 2K Urethane Primer•Sealer•Surfacer.

##### Surface Preparation, Prepainted Substrates

Wash surfaces with a mild detergent and hot water. Rinse with clean water and wipe dry with a clean cloth. Solvent clean with an Wax and Grease Remover. Wipe dry with a clean cloth. Sand original paint and repair damaged areas with a good quality non-staining body filler. Apply 2-3 coats of RCP-50 Grey 2K Urethane Primer•Sealer•Surfacer as needed to fill voids and block sand with 180 to 280 grit treated sandpaper. Finish sand repaired area with 320 grit sandpaper using a DA Sander. For spot repairs, scuff sand area where basecoat and clearcoat will be blended with 320 to 600 grit sandpaper or nylon scuff pad. For overall refinishing, scuff sand the entire car with 320 sandpaper or fine scuff pad.

##### Sealer

Apply appropriate sealers such as An Corrosion Resistant Epoxy Primer•Sealer, RCP-50 Grey 2K Urethane Primer•Sealer•Surfacer or a 2K Urethane Sealer according to manufacturers instructions. Allow sufficient flash times for solvents to escape film before applying basecoat. Insufficient flash times will lead to retarded hardness development of the total system.

##### Basecoat

For best results, follow flash times and film thickness recommendations of the basecoat supplier. Note flash times vary between basecoats and are dependent on the shop temperature and air movement. Insufficient basecoat flash time may lead to movement of the basecoat metallic pigments and loss of clearcoat gloss.

##### Mixing Directions

4 Parts RCC-22	4/1 Ultra Speed Urethane Clearcoat
1 Part RCH-2275,RCH-2285,or RCH-2295	4/1 Ultra Speed Clearcoat Activator

Once catalyzed, RCC-22 is ready to spray. However, for specific shop conditions, RCC-22 can be reduced or retarded with up to 10% urethane grade reducer or High Grade Retarder. **CAUTION:** Care should be exercised in the addition of cure accelerators to urethane products, this is strongly discouraged. A significant reduction in potlife and a loss of clearcoat gloss can occur if accelerated.

## Fish Eye

The use of Fish Eye eliminator is strongly discouraged. If this additive is needed, the use of a Universal Fish Eye eliminator may be used. ½ Fluid Ounce per sprayable quart. Use no more than necessary, as it will directly affect the flow characteristics of the RCC – 22.

## Urethane Flex Additive

The use of an Urethane Flex additive may be needed when painting a bumper or during trim applications. **Caution** : The use of a flex additive may increase your dry times by 10-15 minutes, sanding / buffing by 2-3 hours and cure times by 45-60 minutes.

## Application

Adjust air pressure at the gun to 35-50 psi for siphon feed guns or 6-10 psi when using a HVLP/LVLP. Use less pressure to minimize over spray on small jobs. Apply 2-3 wet coats at a gun distance of 8-12 inches Back to Back. This is best performed as one pass down and back up with no flash time in between the 2 coats. Recommended dry film thickness is 1.8 to 2.5 mils. [Note : Panel by Panel application is recommended.](#)

## Recoat Time

Recoat times will vary with temperature and air movement. Applying additional coats beyond the recommended application is not recommended. If necessary to apply additional coats, wait 5-6 hours, lightly scuff and pre-clean the surface before applying additional Basecoat or Clearcoat.

## Blending Procedure

Before blending the Panel with clear, the blended area must be washed and scuff sanded thoroughly with a good quality wax and grease remover. Apply wet coats of clear to cover the repaired area and slightly beyond. Allow recommended flash times between coats. Extend the second coat 4 to 8 inches beyond the first coat. Begin application of the final coat 4 to 8 inches beyond the second coat and spray into the center of the painted area. Best results can be achieved by the addition of 10% to 50% of a urethane grade reducer in the last coat. Any dry edges remaining can be melted in immediately by misting with a second gun containing a Slow Temperature Urethane Reducer.

## Drying Schedule

Dry times are based on recommended film thickness and are dependent on ambient temperature. Excessive film thicknesses, low temperature and poor air movement will retard dry times.

<b>Air Dry</b>	<b>RCH-2275</b>	<b>RCH-2285</b>	<b>RCH-2295</b>
Flash Time	0 min	0 min	0 min
Dust Free	5 - 10 min	5 - 10 min	6 - 12 min
Polish	30 min	30 min	30 min to 1 hour
To Deliver	1 hour	1 hour	1 hour

### **Force Dry Times**

STRONGLY NOT RECOMMENDED

## Buffing

If buffing is needed to remove dirt, allow the clearcoat to dry 30 minutes to 1 hour, depending on film thickness, temperature and air movement, then wet sand with 1200-1500 grit sandpaper followed by 2000 grit sandpaper. When all 1500-2000 scratches are removed, buff with a fine grade liquid rubbing compound followed by a polish or glaze compound applied by hand or machine.

## Technical Data

Weight Solids		Mixing Ratio	4/1
Package	39.8%	Air Pressure @ Gun	45-50 psi
Ready to Spray	40.3%	Recommended Film Thickness	2.0 - 3.5 mils
Volume Solids		Flash Point	0°F TCC
Package	36.9%	Gloss	90+
Ready to spray	35.7%	DOI	Excellent
VOC @ Gun	3.6 lb/gal	Potlife	1 to 2 hours
Viscosity @ Gun	16-19 sec #2 Zahn	Coverage Ready to Spray	575 sq ft

## Performance Data

Flexibility	Excellent	Direct Impact	Excellent	Chip Resistance	Excellent
Salt Resistance	Excellent	Humidity Resistance	Excellent	Hardness	3H