

## 2.1 VOC HS Polyurethane Clear 4:1

### Product Numbers:

#2100-1 HS Clear – Gallon  
#2200-4 Activator Medium – Quart  
#2203-4 Activator Slow – Quart

**Gun Tip: 1.4 or 1.5**

### Mixing:

4:1

Mix 4 Parts of #2100 Clear to 1 Part #2102 or #2103 Activator

These two activators may be cocktailed/mixed to create your own dry times.

### Uses:

SPI's 2.1 HS Clear is water-like in color so it will not affect white blend jobs and may be used for spot repairs and all-overs alike. Our 2.1 HS clear has excellent long term UV holdout with high gloss and its new resin system requires only low temperature/low time baking cycles which lowers energy costs. 2.1 HS clear may be used over any basecoat after proper flash time.

2.1 HS may be used over catalyzed enamels or polyurethane coatings after a minimum of 8 hours but preferably over night to be safe.

### Drying Times:

HS 2.1 is two clear in one can. With the Slow Activator the first coat will flash in 5-15 minutes depending on air and substrate temperature. The Medium Activator makes this 2.1 clear dry like an MS clear for those smaller jobs and it's great in cooler weather for those small jobs. Regardless of activator it maintains its 2.1 VOC properties and solids so you have the best of both worlds.

### Spraying:

The best way to spray this clear is to adjust your gun so you lay the clear the way you want it to look. **Spray one wet coat.** If you're doing an all-over and it's hot you may spray two wet coats back to back if you desire. If you're spraying only a couple of panels spray your first coat then wait 15-30 minutes before applying your 2<sup>nd</sup> coat.

**Baking: Low Temperature Baking Clear**

Purge the booth for 5 minutes then bake for 110°-120° (never higher) for 10-30 minutes depending on activator used and your booth properties.

Never bake higher than 120°!

**Paint Booths Without Heat:**

In the summer after the last coat of clear is applied shut the booth fan off as soon as the overspray has been evacuated.

**Repairing:**

After 4 hours @ 70° or better you should be able to make repairs without any problems. If the clear was baked repairs should be made 60 minutes after the vehicle has cooled to room temperature.

**Buffing:**

Always let it set overnight. 2.1 HS will buff best in the first 3 days but still buffs good for the next 7 days.