

I. COMPONENTS

- CC-421 PREMIUM MS URETHANE CLEAR COAT
 - CC-42S SLOW 4:1 ACTIVATOR
 - CC-42M MEDIUM 4:1 ACTIVATOR
 - CC-42F FAST 4:1 ACTIVATOR
 - CB-18 ACCELERATOR
- CB-008 SUPER SLOW REDUCER (HIGH TEMP.)


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-421- APPLICATION & MIXING CHARTS







Spray Settings

 Gun Settings	<u>Fluid Tip (HVLP)</u>	1.2-1.4 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 Ratio

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

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 st Coat: 5-10 min. After 2 nd Coat: 10-15 min.	After 1 st Coat: 5-10 min. After 2 nd Coat: 10-15 min.	 Dry to Deliver	1-2 Panels: 5-6 Hrs. 3 Panels-Overall: 6-8 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: 4-6 Hrs. 3 Panels-Overall: 6-8 Hrs.	25 min. Allow 45 min. cooldown	 Pot Life	2 Hours	2 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 **Wax and Grease Remover** or **Pre-Cleaning** solvent cleaner. Wipe down with a clean cloth and wipe down. When the surface is dry, you are ready for application.

V. Application Recommendations

<p>Number of Coats</p>	<p>Apply 2 Single Wet Coats. If heavy polishing and buffing is desired, a 3rd coat may be applied after flash time.</p>	<p>Use of Accelerator*</p>	<p>For slow film cure situations: $\frac{1}{4}$ to $\frac{1}{2}$ fluid oz. of accelerator CB-18 is recommended per sprayable quart of clear coat.</p>
<p>Film Thickness*</p>	<p>Each coat is around .9-1.0 mils without reduction. The film thickness should not exceed 3.5mils. If your buffing time is greater than 24 hours from application, we recommend applying a 3rd to coat for an easier buff application.</p>	<p>Wet Sand-Polish*</p>	<p>If buffing is desired, sand with 1200 grit sandpaper and work your way up to finer until the texture you want is reached. Buffing becomes more difficult as more time after its delivery time has passed.</p>

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-421** 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 = 1.0 mils
1 Medium(Light Coat) = .6 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.

VI. Regulatory/Product Information

Product Specifications 	% Solids Mix (RTS) (Ready-to-Spray)	38.0-38.6%	Product Viscosity RTS (Ready to Spray)		19-21 sec. #2 Zahn	
	Product Density:	lbs./gal.	VOC Content 	Product	VOC Actual	VOC Regulatory
	CC-421	7.52-7.90		CC-421	~4.37 lbs./gal (~525 g/l)	~4.60 lbs./gal (~552 g/l)
	CC-42 M,F,S	8.00-8.70	Product Description		Transparent liquid	
Cleaning and Product Disposal 	All products must be disposed of according to the regulations of the environmental health authorities. Clean equipment following all local and federal regulations.		Manufacturer Support and Information 		www.catamountcoatings.com Phone: (855) 294-3306 Email : support@catamountcoatings.com 117 A W 29 th St. Charlotte, North Carolina 28206	
Catamount Product Statement 	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.					