

PRO-FLO

4:1 Acrylic Urethane Clear



TECHNICAL DATA SHEET

EC100 PRO-FLO Clear is a user-friendly 4:1 acrylic urethane clearcoat designed for professional refinish shops and other production environments where speed and dependability are essential. EC100 provides excellent flow and leveling, gloss retention and distinctness of image. Exceptionally easy to use for either partial or complete refinish jobs, with superior resistance to shrinkage or die back, PRO-FLO remains easy to buff for days after application.

May be used with Kirker's single-stage urethane paint system or other manufacturer's basecoat and/or single-stage paint systems.

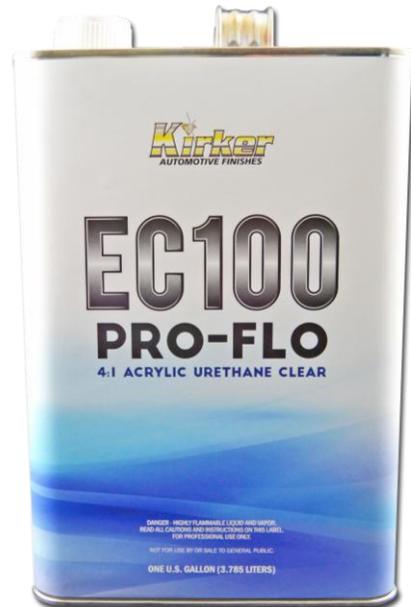
- National Rule Compliant
- Very user-friendly
- Fast drying, fast delivery
- Buffs easily days after application
- Beautiful gloss
- Long-lasting durability
- Excellent chemical and chip resistance

COATING TYPE:
Acrylic Urethane Clear

PRODUCT CODE:
EC100 (Gallon)

ACTIVATORS:
0065 Fast (Below 65°F)
0075 Medium (65°F – 85°F)
0085 Slow (Above 85°F)

REDUCERS:
Additional Reduction not recommended
UR-9065 / UR-8065 Fast (Low temp)
UR-9075 / UR-8075 Medium (Mid temp)
UR-9085 / UR-8075 Slow (High temp)
UR-9095 / UR-8095 Super slow (Very high temp)
UE-8000 Universal Zero-VOC Reducer



PHYSICALS:

Appearance:	Water white
Weight per Gallon:	7.75 lbs
Package Measure:	U.S. gallon (3.785 liters)
RTS viscosity:	17-19 sec. in #2 Zahn Cup
Packaged VOC:	4.8 lbs/gallon
Mix ratio:	4:1

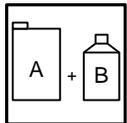


SURFACE PREP:

If applying clearcoat to existing finish, remove all traces of wax, grease, silicone, oil and other contaminants with detergent wash, followed with a solvent wash (such as Kirker's 650 Wax & Grease Remover). Sand existing finish to abrade with 600-800 grit. Re-clean with final wash cleaner (such as Kirker's 600 Surface Wash).

PRO-FLO Clear may be applied wet-on-wet over basecoats after sufficient flash time (approximately 15-20 minutes). If applying clearcoat to newly applied (but cured) paint, sand undercoat with 800 grit before recoating to ensure sufficient adhesion.

If using EC100 for partial refinish or repair work, be sure to mask all adjacent panels to prevent dry overspray.



MIXING:

Mix ratio: 4:1 by volume. Thoroughly mix four (4) parts EC100 PRO-FLO Clear with one (1) part of the appropriate Activator (0065, 0075, 0085), depending on air flow and shop temperatures. No additional reduction is required.

Temperature range	Less than 65° F	Between 65° F - 80° F	More than 80° F
Activator	0065 (fast)	0075 (medium)	0085 (slow)

If necessary, Kirker's UFE8 Universal Fish Eye Eliminator may be added to the mix (1/2 ounce of UFE8 per ready-to-spray quart of PRO-FLO Clearcoat).

Caution: Mix only as much material as you will need to complete the immediate job.



E1300 Clear	4 oz	12 oz.	24 oz.	36 oz.
0065, 0075, 0085	1 oz.	3 oz.	6 oz.	9 oz.
TOTAL MIXTURE	5 oz.	15 oz.	30 oz.	45 oz.



POT LIFE:

Approximately 2 hours at 70°F

Caution: Pot life of mixed components is significantly shorter at elevated temperatures and in humid conditions. These environmental factors also may affect flow and leveling during the application process.



GUN SETTINGS:

<u>GUN TYPE</u>	<u>TIP SIZE</u>	<u>AIR PRESSURE</u>
Conventional Siphon Feed:	1.4 mm – 1.6 mm	45-55 psi at the gun
Conventional Gravity Feed:	1.3 mm – 1.5 mm	45-55 psi at the gun
HVLP	1.3 mm – 1.4 mm	8-10 psi at the tip

Always refer to gun manufacturer's recommendations for additional details on suggested tip size, air pressure and other adjustments.



APPLICATION:

Apply EC100 in three (3) wet coats as necessary to achieve the desired build, allowing ten (10) minutes flash time between coats (+/- depending on air flow and temperature).

PRO-FLO may also be integrated into the final coat of Kirker's ULTRA-GLO single-stage urethane system for increased gloss and durability. This step is not necessary if planning to apply a separate clearcoat. Kirker's PRO-FLO clear and ULTRA-GLO colors may be mixed at any ratio, as long as care is taken to first properly mix both the paint and the clear with their correct activators, at the correct ratios.



DRY TIMES:

	<u>AIR DRY</u>	<u>FORCE DRY</u> (Bake for 40 minutes at 140° F after five-minute flash)
Dust free:	10 minutes	End of cycle
Tack free:	3 hours	End of cycle
Tape:	8 hours	20 minutes after cycle
Polish:	8-12 hours	20 minutes after cycle
Stripe:	Next day	20 minutes after cycle
Deliver:	Next day	20 minutes after cycle
Decal:	48 hours	20 minutes after cycle

Air-dry times may vary slightly depending on shop temperatures, airflow and total film thickness. All dry times listed are approximate, at 70°F.



CLEANUP:

Close all containers tightly after each use. Clean gun and spray equipment with gun wash or other appropriate solvent products immediately after application to prevent damage.

Shelf life of 0065, 0075 and 0085 Activators is limited once cans have been opened. These products are extremely susceptible to oxygenation and exposure to moisture. Therefore, containers should be closed tightly, with a clean seal, as quickly as possible. Also, activators should be stored at a consistent temperature to prevent the formation of condensation inside the can.



RECOAT WINDOW:

EC100 should not be recoated more than one hour after the completion of the previous coat. If more than one hour has elapsed, wait 6-8 hours (depending on air flow and temperature) before recoating. After 24 hours, EC100 may be recoated, but only after the surface has been abraded with 600-800 grit sandpaper to promote sufficient adhesion.



POLISH:

After eight (8) hours dry time or 40-minute bake cycle, EC100 may be sanded with 1500 grit or finer to abrade surface and/or remove dust nibs and other imperfections such as orange peel, then with 2000 grit or finer sand paper to remove all 1500-grit scratches.

Use a wool pad or foam pad in combination with a high-quality clearcoat finishing compound, following material manufacturer's instructions. Follow with a high-quality finishing glaze applied either by hand, or variable-speed buffer.



HEALTH / SAFETY PRECAUTIONS:

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY.

USE THIS PRODUCT ONLY WITH ADEQUATE VENTILATION: Wear appropriate, properly fitted fresh-air-supplied NIOSH/MSHA-approved respirator (TC-19C or equivalent) as directed by the manufacturer. Protect hands with impervious nitrile gloves. Always wear eye and face protection. Individuals with lung or breathing problems should neither use nor be exposed to this product, its vapors or spray mist. READ ALL WARNINGS ON ALL LABELS BEFORE USING.

This product is designed to be mixed with other components. Mixture will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. See Material Safety Data Sheet for additional health and safety information.

WARRANTY:

All recommendations for the use of Kirker products are based on tests and experience believed to be reliable. Since the methods of use, conditions of application, and the application itself are beyond our control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

FOR ADDITIONAL INFORMATION:



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