

Matte Urethane Clearcoat

Urethane Clearcoat (4:1)



TECHNICAL DATA SHEET

EC325 Matte Urethane Clearcoat is a premium-quality acrylic urethane system that dries to an even, smooth matte finish, making it an ideal choice for custom refinish and other applications where a reduced gloss is required. This easy-to-use material features exceptional flow and leveling as well as superior transparency, allowing the base color to show through.

In addition to its pleasing esthetic characteristics, Kirker's Matte Urethane Clearcoat also provides superior protection against weathering, chemicals and harmful UV. It also features exceptional flexibility, with superior scratch, chip and mar resistance.

EC325 may be used over Kirker's ULTRA-GLO single-stage urethane colors, SPECTRA Series urethane candy colors, or other manufacturer's color systems.

For greater versatility, Matte Urethane Clearcoat may be intermixed with EC100 PRO-FLO urethane clear at different ratios for different finishes ranging from matte to high semi-gloss.

COATING TYPE:

Acrylic Urethane Clear

PRODUCT CODE:

EC325 (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: | Clear liquid, slightly cloudy in container |
| Weight per Gallon: | 7.35 lbs. |
| Package Measure: | U.S. gallon (3.785 liters) |
| Packaged VOC: | 4.52 lbs/gallon (542 grams/liter) |
| Ready for Use VOC: | 4.41 lbs/gallon (529 grams/liter) |
| Mix ratio: | 4:1 |

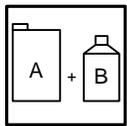


SURFACE PREP:

If applying Matte Urethane Clearcoat over an 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).

Matte Urethane Clearcoat may be applied wet-on-wet over Kirker's single-stage urethane colors or basecoats after sufficient flash time (approximately 30 minutes), but before 18 hours have elapsed. After maximum recoat window has passed, surface must first be abraded before clearcoat application.

If using EC325 for partial refinish or accent work, be sure to mask all adjacent panels to prevent dry overspray.



MIXING:

As with any reduced gloss material, be sure to thoroughly shake before opening, then stir up from the bottom of the can to ensure all flattening agents are evenly dispersed.

Mix ratio: 4:1 by volume. Thoroughly mix four (4) parts EC325 Matte Urethane Clearcoat 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 Matte Finish Clearcoat).

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

4:1

| | | | | |
|----------------------|--------------|---------------|---------------|---------------|
| EC325 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. |

ALTERNATE MIX RATIOS:

EC325 may be intermixed with any of Kirker's full-gloss clearcoats at different ratios for a variety of sheens to suit different needs. Following is a guide to demonstrate different blends of EC325 and EC100 PRO-FLO Urethane Clearcoat. If using any other clear, be sure both the Matte Finish Clear and full gloss clear are properly activated at the correct ratios, with the correct activators, before blending.

| FINISH | EC325 | EC100 | ACTIVATOR * |
|-----------------|-----------|---------|-------------|
| Matte | 4 parts | --- | 1 part |
| Eggshell | 3 ½ parts | ½ part | 1 part |
| Satin | 3 parts | 1 parts | 1 part |
| Low Semi-Gloss | 2 parts | 2 parts | 1 part |
| High-Semi-Gloss | 3 parts | 1 part | 1 part |
| Full Gloss | --- | 4 parts | 1 part |

* Both EC325 and EC100 use 0065, 0075 or 0085 activators.



POT LIFE:

Approximately 3 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 EC325 in two (2) medium wet coats as necessary to achieve the desired build, allowing ten (10) to fifteen (15) minutes flash time between coats (+/- depending on air flow and temperature).

Care should be taken to ensure uniform application and consistent spray technique when using Matte Urethane Clearcoat. Extreme differences in wet film build will result in variations in the gloss once the clear has dried. Shooting additional coats, or heavier, wetter coats, will result in an increased gloss level. Applying the material in lighter coats from an increased distance can further decrease the gloss to more of a flat finish.



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 |
| 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.



RECOAT WINDOW:

EC325 should not be recoated more than one hour after the previous coat. If more than one hour has elapsed, wait 6-8 hours (depending on air flow and temperature) before coating. After 18 hours, EC325 may be recoated, but only after the surface has been abraded with 600-800 grit sandpaper to promote sufficient adhesion.



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.



POLISH:

DO NOT sand, polish and/or wax this clearcoat. Doing so will increase the gloss, changing the appearance of the finish.



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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