

EC330 Satin Urethane Clearcoat is a premium-quality acrylic urethane system that dries to an even, smooth satin 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 Satin Urethane Clearcoat also provides superior protection against weathering, chemicals and harmful UV. It also features exceptional flexibility, with superior scratch, chip and mar resistance.

EC330 may be used over Kirker's ULTRA-GLO single-stage urethane colors, SPECTRA Series urethane candy colors, BLACK DIAMOND urethane basecoats or other manufacturer's color systems. For greater versatility, Satin Urethane Clearcoat may be intermixed with EC100 PRO FLO urethane clear at different ratios for different finishes ranging from matte to high semi-gloss.

- ◆ 2.1 VOC meets even the most stringent standards
- ◆ Very user friendly
- ◆ Fast drying, fast delivery
- ◆ Smooth satin finish
- ◆ Zero color distortion
- ◆ Long-lasting durability
- ◆ Excellent chemical and chip resistance

COATING TYPE:

Urethane Clearcoat (Low Gloss)

PRODUCT CODE:

EC330

ACTIVATORS:

0065

0075

0085

WEIGHT PER GALLON:

7.87 lbs

PACKAGE MEASURE:

1 US Gallon / 128 fl. oz. / 3.785 Liters

RTS VOC:

Will not exceed 2.1 lbs/gallon

RTS Viscosity:

17-19 seconds, #2 Zahn cup



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).

SATIN FINISH Urethane Clear may be applied wet-on-wet over basecoats and single-stage urethane topcoats after sufficient flash time (approximately 15-20 minutes). If applying clearcoat to newly applied (but cured) paint, sand with 800 grit before recoating to ensure sufficient adhesion.

If using EC330 for partial refinish or repair work, be sure to mask all adjacent panels to prevent dry overspray.

SATIN FINISH URETHANE CLEARCOAT

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MIXING

Mix ratio: 4:1 by volume. Thoroughly mix four (4) parts SATIN FINISH Urethane Clearcoat (EC330) with one (1) part Urethane Clearcoat Activator (0065, 0075 or 0085).

TO MIX	10 oz	25 oz	35 oz
CLEAR	8 oz	20 oz	28 oz
ACTIVATOR	2 oz	5 oz	7 oz

Additional reduction is not recommended for this system.

Always choose the appropriate activator based on the anticipated shop temperature and other conditions at the time of application.

BELOW 70°	70-80°	ABOVE 80°
FAST/Small jobs 0065	MEDIUM 0075	SLOW/Big jobs 0085

If necessary, Kirker's Fish Eye Eliminator (UFE8) may be added to the mix (1/2 fl oz. per ready-to-spray quart of Clear).

POT LIFE

Approximately two hours at 70°F.

Mix only as much material as is needed to complete the immediate job.

GUN SETTINGS

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

GUN TYPE	TIP SIZE	AIR PRESSURE
Conventional Siphon	1.4-1.6 mm	45-55 psi
Conventional Gravity	1.3-1.5 mm	45-55 psi
HVLP	1.3-1.4 mm	8-10 psi

APPLICATION

Apply EC330 in two (2) medium wet coats as necessary to achieve the desired build, allowing ten (10) minutes flash time between coats (+/- depending on air flow and temperature).

Care should be taken to ensure uniform application and consistent spray technique when applying SATIN FINISH Clearcoat. Extreme differences in the wet film build will result in variations in gloss once the clear has dried. Shooting additional coats, or heavier, wetter coats, will result in increased gloss. Applying this material in lighter coats, or from an increased distance, can further decrease the gloss.

DRY TIMES

Air-dry times may vary slightly depending on shop temperatures, airflow and total film thickness. All dry times listed are approximate, at 70-75°F.

DRY TIMES

	<u>AIR DRY</u>	<u>FORCE DRY</u> (bake 40 min. at 140°F)
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

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RECOAT WINDOW

EC330 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 18 hours, EC330 may be recoated, but only after the surface has been abraded with 600-800 grit sandpaper to promote sufficient adhesion.

POLISH

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

CLEANUP

Close all containers tightly after each use. Clean gun and spray equipment with Kirker's VOC Compliant Gun Wash (670) or other appropriate solvent products immediately after application to prevent damage.

HEALTH / SAFETY

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY. 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 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.

CONTACT FOR MORE INFO

(800) 307-7951 Toll Free
info@kirkerautomotive.com
www.KirkerAutomotive.com