

*Technical Data Sheet*KEY724 KEY KOMBO 2.1 V.O.C. ACRYLIC URETHANE CLEARCOAT 4:1 RATIO

PRODUCT DESCRIPTION:

KEY724 is a new generation 2.1 V.O.C. Acrylic Urethane Clearcoat. Key Kombo is a very high solid low V.O.C. coating designed for use where low V.O.C. regulations exist. This is a premium clear coating that is easy to spray and is compatible with all acrylic and polyester color systems. KEY724 is one of the most user friendly 2.1 V.O.C. clears available. The Key is the activator, Spot/Panel, Overall or a Kombo of both.

FEATURES:

1. Premium European resin system
2. Clear color - no yellowing
3. Extra gloss and depth of image
4. Compatible with all acrylic and polyester color systems
5. Excellent cure through time
6. Excellent gloss retention and durability

RECOMMENDED SUBSTRATES:

1. All acrylic and polyester basecoat systems
2. Waterborne basecoat systems
3. Cured polyurethane enamel
4. Cured acrylic urethane enamel
5. Properly prepared gelcoat

MIXING INSTRUCTIONS:

2.1 V.O.C. Sprayable

4 parts - KEY724 Clear

1 part - KEY788 Activator for spot/panel or KEY789 Activator for larger jobs.

APPLICATION INSTRUCTIONS:

1. Apply color as per manufactures instructions.
2. Mix KEY724 according to mixing instructions with appropriate activator.
3. KEY724 can be applied in two (2) wet coats with 5 - 10 minutes flash between coats.
4. Can be baked at 130 F for 10 - 20 minutes.

DRY TIMES:

1. Dust Free: 5 - 10 minutes @ 70 F
2. Tack Free: 5 - 10 minutes @ 70 F
3. Buff Time: Air Dry – 2 - 3 hours. Buff times can be longer using slower activators for temperature.
4. Force Dry: Purge 0-5 minutes, bake @ 130 F for 10 - 20 minutes
5. Pot Life: 1 1/2 hours

RECOMMENDED SPRAYING INSTRUCTIONS:

1. For best results use a good quality HVLP gravity feed gun with 1.3 - 1.4 fluid tip.
2. Apply at 50 - 55 PSI.
3. Open fan adjustment to achieve maximum atomization.

CLEANING:

Use good quality lacquer thinner (KEY5/10/15/20/25) or urethane reducer (KEY80/81/82/83) to thoroughly clean all equipment. Clean equipment immediately after use. Do not allow catalyzed clear to remain in gun longer than 1 1/2 hours.

TECHNICAL DATA:

Color	Clear
Pot Life	1 1/2 hours at 72 F
Coverage 1 mil	665 Sq. Ft.
Mix Ratio	4:1
Spray Viscosity	18 – 21 seconds Zahn #2
Flash Point	9 F
Recommended Film	2 - 2.5 mil DFT
Gloss	93 plus
Solids by Weight	36%
Solids by Weight (Sprayable)	45%
Sprayable V.O.C.	2.1lbs./gal.
V.O.C.	2.3 lbs./gal. Before activator or reducer