

# IKONIKOLOR PRO™

## High Performance Clear Coat – High Gloss

- Maximum DOI and color retention
- Buffable and repairable technology
- Long-lasting, flexible, highly durable
- Abrasion and chemical resistant finish



### PREMIUM HIGH GLOSS CLEAR COAT

IKONIKOLOR PRO High Performance Clear Coat is a quick drying and easy to apply clear coat for interiors and exteriors designed for over-coating Ikonikolor Pro base coats. This product has excellent filling characteristics, exceptional flexibility, brightness and specifically designed for large applications.

This product offers best in class flow-out, aesthetics, and hide in an endless color pallet.

Note: Clear Coat must be applied within 10 hours of the basecoat being applied at 70°F.

### TECHNICAL INFORMATION

**VEHICLE TYPE:** Acrylic polyurethane

**FINISH:** High gloss

**COMPONENTS:** Two

**MIX RATIO:** 2:1:30%

ex: 10oz:5oz:3oz

**SOLIDS BY WEIGHT:** 48 – 52% ± 4%

**COVERAGE:** Zero loss calculations

300 ft<sup>2</sup>/ half gal. @ 1 mil

**VOC:** <484 grams/liter

**FLASH POINT:** 113°F (for white)

*other colors will vary slightly*

**OVERCOAT TIMES:** 30 – 60 mins

**APPLICATION METHOD:** Spray equipment

**NUMBER OF COATS:** 2 minimum

**WET FILM THICKNESS:** 2 - 3 mils per coat

**DRY FILM THICKNESS:** 1.0 - 1.5 mils per coat

**APPLICATION TEMP:** 50°F Min / 90°F Max

**REDUCER:** Ikonikolor Pro Reducers

**VISCOCITY:** 16-18 Zahn #2

**GUN TIP SIZE:** 1.0-1.2mm

**AIR PRESSURE:** 25 - 35 psi

**CLEANER:** Ikonikolor Pro Reducers

**POT LIFE:** 2 hours

**ASSOCIATED PRODUCTS:** AnchorTech® Adhesives and Sealants, Ikonikolor Pro Epoxy and Urethane Primers, 92 Bio Blue® Hull Surface Prep, Ikonikolor Pro Reducers and Solvents, **Ikonikolor Pro 1001 High Performance Clear Coat High Gloss Activator**

### Mixing Instructions:

1. Mix part acrylic base material well. All solids must be properly dispersed.
2. Mix 2 parts of A base and 1 part of B activator together at 2:1 mix ratio.
3. Reduce with Ikonikolor Pro Reducer 30% depending on weather and application conditions and mix well
4. Induct mixture for at least 5 minutes prior to applying



**APPLICATION INFORMATION:** This product may be applied via conventional or HVLP spray equipment. Apply 2 medium wet coats allowing 45 minutes in between coats until recommended film thickness is achieved. Do not apply in the late afternoon when working outdoors as the wet film may be adversely affected by changes in temperature and humidity. When working in cooler temperatures (below 65 F) be sure the air and surface temperatures will remain at or above 50°F for at least 8 hours after application. Do not apply paint materials to surfaces less than 5°F above dew point, or to surfaces warmer than 125°F.

**NOTE:** This product allowed to cure for 24 hours or longer must be sanded with 320 grit sandpaper for proper adhesion.

**PREPARATION FOR PAINTING:** Verify if previous painted surface passes the 'coating compatibility testing'. If the previous coating passes the compatibility test proceed with the outlined steps for preparation. Coating performance, in general, is proportional to the degree of surface preparation. Follow recommendations carefully, avoiding shortcuts. Surface must be free of dirt, loose paint, rust, oil, grease, wax, soap, and any other foreign matter. Remove existing mildew with household bleach instead of ammonia. Prep areas to be painted Pettit 92 Bio-Blue Surface Prep and a scotchbrite® pad and rinse clean with water. Prior to coating application, the surface should be cleaned with Ikonikolor Pro Prep Solvent using the two-rag cleaning method.

**BARE FIBERGLASS/GELCOAT:** The entire surface to be painted regardless of age must be thoroughly prepped with Ikonikolor Pro Prep Solvent using the two-rag method. Sand the gel coat with 220 grit sandpaper to a dull appearance, solvent clean to remove residue. If the surface is rough or imperfections exist, it will have to be repaired. Fill all nicks and gouges with 7050 EZ Fair Epoxy Fairing Compound, sand flush when hard. Follow with a coat of Ikonikolor Pro Primer to smooth the surface and provide a uniform base. Sand all surfaces to final 320-400 grit profile. Entire surface should be wiped down with Ikonikolor Pro Prep Solvent using the two-rag method prior to application of Ikonikolor base coat. After the last coat of base has been applied, wait 30 mins before applying clear coat.

**NOTE:** Aged gelcoat must be primed due to porosity.

**2-PART PAINTED SURFACES:** The entire surface to be painted regardless of age must be thoroughly prepped with Ikonikolor Pro Prep Solvent using the two-rag method. In some cases, priming may not be necessary if the previous coating is in excellent condition. If priming is necessary, sand the previous 2-part painted surface with 220 grit sandpaper to a dull appearance, solvent clean to remove residue. If the surface is rough or imperfections exist, it will have to be repaired. Fill all nicks and gouges with 7050 EZ Fair Epoxy Fairing Compound, sand flush when hard. Follow with a coat of Ikonikolor Pro Primer to smooth the surface and provide a uniform base. Sand all surfaces to final 320-400 grit profile. Entire surface should be wiped down with Ikonikolor Pro Prep Solvent using the two-rag method prior to application of base coat. After the last coat of base has been applied, wait 30 mins before applying clear coat.

**BARE STEEL/ALUMINIUM:** Surface must be cleaned to a bright finish by sandblasting or grinding to minimum SSPC-SP10 Near White; remove blast residue with a clean dry air line and broom. Surface must hold a uniform 2-3 mil anchor profile. Aluminum needs to be prepared with non-ferrous media or grinding materials. Immediately apply two coats of 4700/4701 Pettit Protect Epoxy Primer. Allow to dry a minimum of 24 hours. Scuff the primer with 120-180 grit sandpaper. Apply 2-3 coats Ikonikolor Pro Epoxy Primer following instructions. Repeat application as needed until a smooth, uniform base is reached. Proceed with the first coat of this product. Sand all surfaces to final 320-400 grit profile. Entire surface should be wiped down with Ikonikolor Pro Prep Solvent using the two-rag method prior to application of base coat. After the last coat of base has been applied, wait 30 mins before applying clear coat.

**Coating Compatibility Testing:** To ensure long term coating performance the surface should be tested with two compatibility tests to confirm solvent compatibility and condition of existing coating.

**Test 1- SOLVENT COMPATIBILITY:** First, sand a 4"x4" area with 220 grit paper lightly to a dull finish. Next, saturate a small rag with Ikonikolor Pro reducer 1128 or Ikonikolor Pro Epoxy Reducer 199. Finally, tape the rag to the scuffed surface for 20-30 mins. Remove and inspect coating after 30 mins for detachment, coating degradation or softening.

**Test 2 – SYSTEM ADHESION COMPATIBILITY:** Perform a cross hatch adhesion test of existing coatings under ASTM 3359 Method B or C as appropriate.

**If either test fails, the coating must be removed completely, and the sanded surface retested for compatibility or Ikonikolor PRO 755 Express 1K Water-Based Primer may be applied as a transition coat.**

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Gun	Air Pressure	Nozzle
Conventional Gravity Feed	25-35 psi	0.8-1.1 mm
Conventional Pressure Pot	6-8 psi (Pot) 25-35 psi (gun)	0.8-1.2 mm at 8-10 oz/min

Dry Times	Overcoat Time	Touch Dry	Tape	Light Service/ Polish
90 Degrees	15 mins	30 mins	6 hours	30 hours
75 Degrees	30 mins	60 mins	8 hours	36 hours
60 Degrees	60 mins	120 mins	16 hours	48 hours

Temperature (F)	55	60	65	70	75	80	85	90+
Fast Reducer 1129								
Standard Reducer 1128								
Slow Reducer 1127								