



HiQ Clearcoat (TC-410)

Version 1.0

PRODUCT DESCRIPTION

■ Outline

HiQ Clearcoat TC-410 is a fast dry urethane clearcoat designed for quick repairs where speed is essential. TC-410 dries out of dust in as fast as 10 minutes and can be lightly polished on the same day.

TC-410 is easy to apply and a high gloss acrylic urethane system with excellent durability.

■ Suitable Substrates

- HiQ basecoat colors
- OEM finishes
- Aged refinishes

■ Product Configuration

Product Name	Pack(ℓ)	Contents(ℓ)	Storage
HiQ Clearcoat (TC-410)	4.0	4.0	12 months
HiQ Urethane Hardener (CCH-200, 230, 250)	1.0	1.0	6 months
Reducer : Not used	-	-	-

* Standard temperature of storage is 20°C.

■ Mixing Viscosity

12~14 sec. Viscosity(A+B) Ford Cup #4 at 77°F (25°C)

■ Pot Life

2 hours at 77°F (25°C) using CCH-200

■ Hardener

	Temperature			
	5~15°C	10~25°C	20~35°C	30°C or above
Spot repair	CCH-250	CCH-200	CCH-200	CCH-230
1~2 panel repair	CCH-250	CCH-200	CCH-230	CCH-230
Multi panel repair	CCH-250	CCH-200	CCH-230	Non applicable

APPLICATION GUIDE

■ Use

Surface Preparation



Apply clearcoat after applying basecoat and wiping off the dust in the fully-dried condition.

Mixing Ratio



Product Name	Mixing Ratio
HiQ Clearcoat (TC-410)	4
HiQ Urethane Hardener (CCH-200, 230, 250)	1
Reducer : Not used	0

* Mix by volume.

Spray Condition



2.0~3.0 bar (gravity feed)
2~3 wet coats keeping 20~25cm from the surface
Fluid tip : 1.2~1.5mm, D.F.T.=40~60 μ m



3.0~4.0 bar (siphon feed)
2~3 wet coats keeping 20~25cm from the surface
Fluid tip : 1.4~1.6mm, D.F.T.=40~60 μ m



0.6~0.7 bar (at nozzle)
2 wet coats keeping 20~25cm from the surface
Fluid tip : 1.3~1.5mm, D.F.T.=40~60 μ m



Flash time : 3 min
Set time : 5 min

Protective Equipment



Use fresh air mask or charcoal respirator to avoid inhaling or being exposed to fumes.

■ Drying Times

	Temp. Time		Temp. Time		Remark
Set time	25°C	5 min			
Time to handle	25°C	1.5 hrs	60°C	30 min	
Time to stripe	25°C	1.5-2 hrs	60°C	30 min	
Thorough dry	25°C	6 hrs	60°C	1 hr	
IR dry time	-	-	-	-	Not recommended
Time to polish	25°C	1.5 hrs	60°C	30 min	

(*) If coats are thicker, the drying schedule will be delayed.

ADDITIONAL INFORMATION

■ Recoatability

- 1) Recoatable time : 2 hours at ambient temperature after force dry
- 2) Sand and wipe off the dust with DR-180 before recoating.



Dry sand P800



Wet sand P400 - P500

■ Blending



Product : HiQ Blending Reducer (DR-500)

Spray pressure : 2 bar

Number of coats : 1~2 coats

- Procedure :
- 1) Apply TC-410 clearcoat.
 - 2) On the second application, apply wider than the first application area.
 - 3) Dilute TC-410 with DR-500 by the portion of 1:1 and apply once wider than the previous application area.
 - 4) Melt the edge of the previous coat using DR-500.

■ VOC Content

VOC content of 4.9lbs/gal (600g/liter)

■ Notice

1. Completely eliminate the moisture of spray equipment before use because two-component urethane coats react with moisture. Cleanse immediately after application not to have any leftover on spray equipment.
2. Put a lid on the product after apply and keep it away from direct sunlight and moisture.

■ Health and Safety

1. Be well-informed of MSDS before use.
2. Follow all the directions labeled on the container.
3. For safety reasons, work in the fully-ventilated place.
4. Wear safety glasses, coveralls and latex gloves when mixing and applying.

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