

TECH SHEET

AC-9050 ALLKANDY.COM THE “WET WET” HIGH SOLID

AC-9050 “WET WET” Clear is a water white, high quality clearcoat designed for larger repairs and complete refinishing over most aftermarket basecoat systems. AC9050 dries fast and retains high gloss and DOI. AC9050 provides excellent durability and is resistant to environmental conditions such as sunlight and acid rain. AC9050 can be buffed to match the original finish after 5-14 hours air dry and can be buffed for several days. With AH-6470, AH-6480, or AH-6490 hardeners, AC-9050 can be applied in a variety of shop temperatures and humidity conditions.

Products

AC-9050 ALLKANDY... THE “WET WET” HIGH SOLID
AH-6470 4+1 Activator Fast
AH-6480 4+1 Activator Medium
AH-6490 4+1 Activator Slow
AR-2040 Uni Reducer Fast
AR-2050 Uni Reducer Medium
AR-2060 Uni Reducer Slow

Application

Surface Preparation, Bare Substrates

Solvent wash surface with a good grade wax and grease remover such as AS-2900 and wipe dry with a clean cloth.

Apply three single wet coats of AP-8300 Series Epoxy Primer according to instructions on data sheet. Follow with two to three coats of AP-8020 Production Prime.

Surface Preparation, Prepainted Substrates

Wash surfaces with a mild detergent and hot water. Rinse with clean water and wipe dry with a clean cloth. Solvent clean with AS-2900 Clean Ease. Wipe dry with a clean cloth. Sand original paint and repair damaged areas with a good quality non-staining body filler. Apply 2-3 wet coats of AP-8020 Production Prime as needed to fill voids and block sand with 180 to 280 grit treated sandpaper. Finish sand repaired area with 320 grit sandpaper using a DA Sander. For spot repairs, scuff sand area where basecoat and clearcoat will be blended with 320 to 600 grit sandpaper or nylon scuff pad. For overall refinishing, scuff sand the entire car with 320 grit sandpaper or fine scuff pad.

Sealer

Apply appropriate sealers such as AP-8300 Series Epoxy Primer or AP-8020 Production Prime according to manufacturer's instructions. Allow sufficient flash times to allow the solvents to escape film. Insufficient flash times will lead to retarded hardness development of the total system.

Basecoat

For best results, follow flash times and film thickness recommendations of the basecoat supplier. Note: flash times vary

between basecoats and are dependent on the shop temperature and air movement. Insufficient basecoat flash time may lead to movement of the basecoat metallic pigments and loss of clear coat gloss.

Mixing Directions

4 Parts AC-9050 THE "WET WET" HIGH SOLID

1 Part AH-6470, AH-6480, or AH-6490 4+1 Activator

Once catalyzed, AC--9050 is ready to spray. However, for specific shop conditions, AC-9050 can be reduced or retarded

with up to 10% urethane grade reducer or AR-2100 Retarder. In cold weather, the use of AH-6470 is recommended,

however, in place of AH-6470, the addition of a urethane cure accelerator, such as AS-X99, will speed overnight cure.

CAUTION: care should be exercised in the addition of cure accelerators to urethane products. A significant reduction in

pot life and a loss of clear coat gloss can occur if over accelerated.

Application

Adjust air pressure at the gun to 45-50 psi for siphon feed guns or 6-10 psi when using a HVLP. Use less pressure to

minimize over spray on small jobs. Apply 2-3 wet coats at a gun distance of 8-12 inches allowing each coat to become

hand slick before applying the next coat. Recoat times will vary with temperature and air movement between 10 and 30

minutes. Apply each coat of clear within 30 minutes flash of the previous coat to prevent possible recoat lift.

Recommended dry film thickness is 1.8 to 2.5 mils.

Blending Procedure

Before blending the Panel with clear, the blended area must be washed and scuff sanded thoroughly with a good qual i t y

wax and grease remover such as AR-2900. Apply wet coats of clear to cover the repaired area and slightly beyond. Allow

recommended flash times between coats. Extend the second coat 4 to 8 inches beyond the first coat.

Begin application

of the final coat 4 to 8 inches beyond the second coat and spray into the center of the painted area. Best results can be

achieved by the addition of 10% to 50% of a urethane grade reducer in the last coat. Any dry edges remaining can be

melted in immediately by misting with a second gun containing a medium temperature urethane reducer.

Drying Schedule

Dry times are based on recommended film thickness and are dependent on ambient temperature.

Excessive film

thicknesses, low temperature and poor air movement will retard dry times.

Air Dry AH-6470 AH-6480 AH-6490

Dust Free 10-15 min 10-15 min 20-30 min

Tack Free 20-30 min 25-35 min 45-60 min

Buffable 3-5 hours 4-6 hours 8-10 hours

To deliver 5 hours 6 hours 10 hours

Force Dry Times

Allow 10-15 minutes flash time of final coat of clear when using infrared or radiant heat. Note: The use of AH-6470 is not

recommended with bake.

Temperature AH-6480 AH-6490

110°F 45 min 60 min

120°F 45 min 60 min

140°F 30 min 45 min

Buffing

If buffing is needed to remove dirt, allow the clearcoat to dry the recommended time then wet sand with 800-1000 grit sandpaper followed by 1500 grit sandpaper. When all 800-1000 scratches are removed, buff with a fine grade liquid rubbing compound followed by a polish or glaze compound applied by hand or machine.

Technical Data

Weight Solids Mixing Ratio 4:1

Package 45.5% Air Pressure @ Gun 35-50 psi

Ready to Spray 45.2% Recommended Film Thickness 1.8 - 2.5 mil

Volume Solids Flash Point 72°F TCC

Package 40% Gloss 90+

Ready to spray 41% DOI Excellent

VOC @ Gun 3.81 lbs/gal Pot Life 3 to 5 hours

Viscosity @ Gun 16-19 sec #2 Zahn Coverage Ready to Spray 515 sq ft

Performance Data

Flexibility Excellent... Direct Impact Excellent ...Chip Resistance Excellent

Salt Resistance Excellent ...Humidity Resistance Excellent... Hardness 3H

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