



HiQ CLEAR COAT TC-330

Version 24.03

PRODUCT DESCRIPTION

■ Outline

HiQ Clearcoat TC-330 is a highly efficient clearcoat designed to speed up productivity in both air dry and low bake paint operations without sacrificing quality appearance or durability. TC-330 is especially developed for repairs of up to 3 panels. TC-330 offers extremely fast flash, polish and air dry times with good quality.

TC-330 is an easy-to-apply, high gloss acrylic urethane system with excellent durability.

■ Suitable Substrates

- HiQ basecoat colors (metallic/solid/pearl)
- Bodyian basecoat colors (metallic/solid/pearl)
- WATER Q waterbased system (metallic/solid/pearl)
- OEM finishes
- Thoroughly dried two-component coats (urethane, epoxy, etc.)

■ Product Configuration

Product Name	Pack(ℓ)	Contents(ℓ)	Storage
HiQ Clearcoat (TC-330)	4.0	4.0	12 months
HiQ Urethane Hardener (CCH-200, 230, 250)	1.0	1.0	6 months
HiQ Urethane Reducer DR-421 Series	4ℓ , 16ℓ	4ℓ , 16ℓ	24 months

* Standard temperature of storage is 20°C.

■ Mixing Viscosity

14~16 sec. Viscosity(A+B) Ford Cup #4 at 77°F (25°C)

■ Pot Life

3 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-270	CCH-250	CCH-200	CCH-230
1~2 panel repair	CCH-270	CCH-200	CCH-230	CCH-230

Multi panel repair	CCH-250	CCH-200	CCH-230	Non applicable
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Reducer

	Temperature			
	5~15°C	10~25°C	20~35°C	30°C or above
Spot repair	DR-421W	DR-421WS	DR-421S	DR-421S
1~2 panel repair	DR-421W	DR-421WS	DR-421S	DR-421S
Multi panel repair	DR-421W	DR-421WS	DR-421S	DR-421R

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-330)	3
HiQ Urethane Hardener (CCH-200, 230, 250, 270)	1
HiQ Urethane Reducer DR-421 Series	0.3

* Mix by volume.

Spray
Condition



1.8~2.5 bar
2 wet coats keeping 15~20cm from the surface
Fluid tip : 1.3~1.4mm, D.F.T.=50~60μm



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
Time to dust free	25°C	40~50 min			
Time to polish	25°C	4~5 hrs	60°C	20 min	
Time to handle	25°C	6~8 hrs	60°C	20 min	
Time to stripe	25°C	6~8 hrs	60°C	20 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-600)

Spray pressure : 2 bar

Number of coats : 1~2 coats

- Procedure :
- 1) Apply TC-330 clearcoat.
 - 2) On the second application, apply wider than the first application area.
 - 3) Dilute TC-330 with D6-500 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-600.

■ VOC Content

VOC content of 4.6lbs/gal (560g/liter)

■ Notice

1. For 2K products, short pot life, delayed drying time or unreactive substance can occur depending on hardener volume. Thus please mix base(A) and hardener(B) according to the proper mixing ratio.
2. Stir thoroughly before use.
3. Avoid direct sunlight during delivery, storage and handling. Store in a cool, dry dark place under room temperature(5°C-35°C).
4. Keep container tightly closed and store upright. When spilled, absorb contents with sand.
5. During application(including touch-up application), color difference may occur depending on mixing ratio, painting tools and application method. It may occur in same color product and same LOT No.
6. Please check whether color difference occurred or not. If possible, apply the same LOT No. product in consistent application method.
7. Putty marks might appear when you directly apply over the lacquer coating. As time goes by, it can peel off.
8. Completely eliminate the moisture of spray equipment before use.
Cleanse immediately after application not to have any leftover on spray equipment.
9. Suitable condition for application and hardening is 10°C or above.
10. Surface temperature must be at or above 3°C to avoid moisture condensation.



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11. Do not mix with other paint products.
12. Proceed a test application before applying on a precedent or an old paint film
(check adhesion, color spread and transparency).
13. Please refer to technical data sheet before system application(primer, midcoat and topcoat).
14. Please do not apply paint above 85% RH or below 5°C because it may influence physical properties.
15. Contents must not flow into drain, river and soil.
16. Hardener must be stored under room temperature, avoid direct sunlight and keep away from humidity.
17. To prevent environmental pollution, dispose contents after complete use and dispose the residue through waste disposal company authorized by the ministry of environment.
18. Beware of ingestion, inhalation and contact of animals and plants.
19. Use masking tape, covering tape, vinyl or newspapers to cover areas that should not be painted.

■ Health and Safety

1. Be well-informed of MSDS before use.
2. Keep out of the reach of infants and children. Do not apply a product to baby products and food containers.
3. Do not use a product for any other uses. (Sniffing is prohibited. Do not use as a fuel.)
4. If on skin or eye, wash thoroughly with running water and get a medical treatment.
5. Do not apply a product in an enclosed area.
In order to prevent suffocation during application and drying, use power blower to keep the area fully ventilated. Workers must wear gas mask and safety gears all the time.
6. Contents include organic solvents and can cause health problems such as headache, dizziness and dermatitis.
Do not ingest or inhale the product and avoid skin contact.
Wear safety glasses, coveralls and latex gloves when mixing and applying.
7. Keep away from fire and heat during application or storage because it is flammable and has risk of fire.
Beware of spark from impact, droppage and friction while handling.
8. Storing a product with combustible substances such as stained clothes or paper may cause fire by spontaneous ignition. Thus do not pile products with combustible substances.
Keep it in a non-flammable container filled with water, then put a lid on and dispose it.
9. Please contact our customer service or refer to GHS-MSDS and technical data on the website for further details.

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