



KBS MAXX CLEAR

TDS/DIRECTIONS & APPLICATION INFORMATION

KBS
MAXX

KBS MAXX Clear is a superior performance, two-component, low VOC, low HAPs polyurethane clear coat specifically designed for the automotive, agricultural, fleet refinishing, marine, and heavy industrial equipment markets.

KBS MAXX Clear offers excellent gloss retention as well as superior impact resistance, while providing fast drying characteristics.

To achieve expert results, please take the time to carefully read and understand the following directions before you begin your restoration project. These directions are meant to be general guidelines only and do not cover every application or environmental situation. If you have remaining questions or concerns, please contact us for technical assistance.

ALWAYS WEAR PROTECTIVE GLOVES AND SAFETY GLASSES. ALWAYS WORK IN A WELL-VENTILATED AREA. Please heed all warning and caution notices on all KBS products.

SURFACE PREP:

Do not apply if surface temperature is below 45°F or above 110°F, or if the surface temperature is within 5°F of the dew point. Clean the surface well with KBS Klean. The surface should be clean of all grease, dirt, oil, rust, and foreign material which would be detrimental to proper adhesion and desired performance of the coating system being applied.

Clear Coating Over an Automotive Base Coat:

Apply base coat as per manufacturers directions. Allow to dry which is normally about one hour.

Note: If the surface being clear coated will be consistently exposed to sunlight, please be sure your automotive base coat is UV stable.

Clear Coating Over Cured Coatings:

Clean surface with KBS Klean diluted 10 parts hot water to 1 part KBS Klean. If needed, scuff with 600-1200 grit sandpaper and repeat cleaning process. Rinse & allow to thoroughly dry.

Note: If the surface being clear coated will be consistently exposed to sunlight, please be sure your base coat is UV stable.

Clear Coating Bare Metals:

For ferrous metals, clean with KBS Klean at a dilution rate of 10 parts hot water to 1 part KBS Klean (10% strength) with the use of a soft non-abrasive cleaning pad. Rinse the KBS Klean solution immediately making sure you do not let it sit on the surface and dry in a way that minimizes any water stains.

For aluminum, clean with KBS Klean at a dilution rate of 25 parts hot water to 1 part KBS Klean (4% strength) with the use of a very soft non-abrasive cleaning pad. Wipe the surface and

do not soak. Rinse the KBS Klean solution immediately making sure you do not let it sit on the surface and dry in a way that minimizes any water stains.

Clear Coating Wood:

Wood surfaces should be smooth and dry with the wood having a low moisture content. All existing failed coatings should be removed, sand smooth and remove dust. Thin initial coat of KBS MAXX Clear 30-50% with KBS #1 Thinner and apply a single covering coat to seal the wood. Allow to cure 24 hours. The wood will generally need to be sanded smooth again as KBS MAXX Clear will tend to raise the wood grain with the first coat. Sand the surface smooth with fine grade of sand paper (280-320). Apply at least an additional full coat for general applications and at least a minimum of 3 coats for marine or industrial users.

Clear Coating Fiberglass or Carbon Fiber:

Clean the surface with KBS Klean diluted 10 parts hot water to 1 part KBS Klean. Scuff with 600-1200 grit sandpaper and repeat cleaning process. Rinse and allow to thoroughly dry.

SURFACE PRIMER:

Use the KBS 3-Step System of Klean, RustBlast, and RustSeal for the ultimate in surface prep and rust prevention. Coat over RustSeal with KBS MAXX, BlackTop, or some other solid color UV stable topcoat (Not KBS MAXX Clear). KBS MAXX Clear may be applied over KBS MAXX and most epoxy and/or urethanes. Follow manufacturers topcoat guidelines.

MIXING AND MIX RATIO:

Always mix KBS MAXX Clear Base thoroughly. Use of a mechanical mixer (**Red Devil Speed Demon Paint Mixer or similar mixing blade attached to drill**) is highly recommended.

After the KBS MAXX Clear Base has been mixed well and smooth in consistency, in a mixing cup/container, carefully measure 3 parts mixed up KBS MAXX Clear Base. Add 1 part MAXX Activator. Mix thoroughly. Use of a mechanical mixer (**Red Devil Speed Demon Paint Mixer or similar mixing blade attached to drill**) is highly recommended.

KBS MAXX Clear and MAXX Activator are pre-thinned and ready to brush, roll, or spray, but you can also add KBS #1 Thinner or Xylene as needed at this point and then mix well using a mechanical mixer (**Red Devil Speed Demon Paint Mixer or similar mixing blade attached to drill**).

APPLICATION CHARACTERISTICS:

Mix Ratio:	Mix 3:1 (Base Component : Activator)
Reducer:	Ready to Apply. KBS #1 Thinner or MAK may be added if needed.
Pot Life:	Doubles in viscosity in 30 minutes.
Dry Times:	Touch: 30 minutes Through Dry: 1 – 2 Hours Hard: 3 – 4 Hours Recoat: 30 minutes to 3 days with no scuffing
Force Cure:	Allow 15 minutes to Flash, 20-30 minutes @ 140°-180°F
Full Cure:	A Function of Time, Temperature, and Film Build. This Product will not reach Full Cure for 7 days.
Note: Test Performed @ 77° F 50% Relative Humidity	

APPLICATION:

KBS MAXX Clear can be applied by Brush or Roller and also using spray equipment such as Conventional Electrostatic, Conventional suction spray gun, HVLP, Air Assisted Airless, or Airless.

Conventional Electrostatic:	Air Pressure: 40 - 60 psi	Fluid Pressure: 15 -20 psi	Cap: Medium Visc. Tip: 1.2 - 1.5 mm
Conventional Spray:	Air Pressure: 40 - 60 psi	Fluid Pressure: 15 - 20 psi	Cap: Medium Visc. Tip: 1.2 - 1.5 mm
HVLP Spray:	Air Pressure: 15 - 20 psi	Fluid Pressure: 15 - 20 psi	Cap: Medium Visc. Tip: 1.2 - 1.5 mm
Air Assisted Airless:	Air Pressure: 15:1 ratio pump or larger @ 80-100 psi	Atomizing Air: Adjust as needed	Cap: Medium Visc. Tip: 0.09 - 0.13"
Airless:	Pressure: 1500 psi min.	Tip: 0.09 - 0.11"	
Brush and/or Roll: Utilize a natural bristle brush, high-density foam roller, or low nap mohair roller and reduce/thin with KBS #1 Thinner. When brushing or rolling KBS MAXX Clear, for best results, do not overwork the brush or roller as this can cause the KBS MAXX Clear to cure too quickly possibly leaving visible brush marks or roll marks. It is best to brush or roll an area with KBS MAXX Clear and move on immediately versus brushing or rolling an area over and over again. If you brush or roll over an area over and over again forcing the solvents out, you run the risk of the brush marks or roller marks not flowing out as well they are designed to flow out.			
Note: The above parameters are to be used as a guideline only. Customer specific equipment may require a different set-up.			

CLEAN UP:

KBS # 1 Thinner, Xylene, or lacquer thinner for cleanup. KBS MAXX Clear must be cleaned up immediately before it dries. Once cured, KBS MAXX Clear cannot be removed by any solvent. Wear protective gloves to avoid skin contact.

DRY TIME / CURE:

Air Dry: Curing is a function of Time, Temperature, and Film Build. Air dry in 30 minutes to touch, thorough dry in 1-2 hours, dry hard in 3-4 hours. Tested @ 77° F @ approx. 70% relative humidity.

NOTE: The above information is supplied as a guideline to our customers. The user must be aware of the cleaning, pretreatment, application, and testing requirements for their specific job!

PHYSICAL PROPERTIES:

Volume Solids:	60.5 +/- 2.0%
QUV 313B:	1000 hours
Weight Solids:	67.4 +/- 2.0%
Pencil Hardness:	2H @ 72 Hours
Skydrol:	24 hours 150°F - no discoloration
10%-Sodium Hydroxide:	Excellent
Weight Per Gallon:	8.76 +/- 0.2 lbs/gallon
Impact Direct/Indirect:	160 inch-pounds
Theoretical Coverage:	970 sq ft/gal @ 1 mil dft
Dry Heat Resistance:	1 hour at 250°F, less than 1.0 DE
VOC:	2.8 lbs/gallon mixed
Recommended Film Thickness:	1.5 – 2.0 mils DFT
Viscosity:	27 - 33 seconds #2 Zahn cup (mixed)
Salt Spray (B117): Q-Steel panels prepared with KBS MAXX Clear of 3.0 – 4.0 dft	2000 hrs.

CHEMICAL RESISTANCE:

MEK, 100 Double Rubs:	Pass @ 24 hours
10%-Hydrochloric Acid:	Excellent
Lubricating and Cutting Oils	Excellent
10%-Acetic Acid:	Excellent
Skydrol:	24 hours 150°F - no discoloration
10%-Sodium Hydroxide:	Excellent
Water Immersion:	Excellent
JP 5:	Pass at 70°F for 7 days

Made in the USA.

Information contained herein is to our knowledge true and accurate, but all recommendations or suggestions are made without guarantee. Since application lies outside our control, we cannot accept any liability for the results. User shall determine the suitability of the product for its intended use, and user assumes all risk and liability whatsoever in connection therewith.

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