



PC4v28 Series-2.8 VOC Acrylic Polyurethane Topcoat

DESCRIPTION

PC4v28 is a single stage acrylic polyurethane enamel designed for fleet refinishing, production shop refinishing and OEM applications. It is available in hundreds of factory packed OEM colors similar to original colors designed for overall application. PC4v28 is highly productive offering fast air dry times, high hiding and fast coverage. It has exceptional high gloss and depth of image (DOI) with excellent metallic control for quick and easy application. PC4v28 is VOC compliant at 2.8 lbs per gallon.

SUITABLE SUBSTRATES

- OEM Enamels
- Aged Refinishes
- Precision Coatings Primers & Primer/Sealers

MIXING

4 Parts
PC4v28 color + 1 Part
PC-04 Polyurethane Activator

- **Reduction is not necessary.** However, paint may be reduced up to 10% by volume using Precision Coating's 16050 VOC Exempt Reducer.
- **For faster cure times,** add 2 floz of Precision Coating's 12030 Urethane Accelerator per activated quart of topcoat.
- **For fisheyes** or other related surface defects, add 1 capful of Precision Coating's 15000 Fisheye Remover per activated quart of topcoat.

APPLICATION

- Apply 2 medium wet coats or until hiding is achieved
- Allow each coat to flash 5 to 10 minutes until hand slick
- Allow final coat to flash 20 minutes if optional PC4v250 Clear Coat is used

SPRAY GUN SET-UP & PRESSURE

<u>Type</u>	<u>Fluid Tip</u>	<u>Spraying Pressure</u>
HVLP Siphon	1.6mm – 1.8mm	max. 10 PSI @ the air cap
HVLP Gravity	1.3mm – 1.5mm	max. 10 PSI @ the air cap
Siphon Feed	1.4mm – 1.7mm	40 - 65-PSI
Gravity Feed	1.3mm – 1.4mm	40 - 65 PSI
Pressure Pot	1.1 mm- 1.3 mm	29 PSI - 58 PSI, 10-12 floz per minute

APPLICATION TECHNIQUES

Adjust air pressure to 10 psi cap pressure for HVLP, 40 – 65 psi for conventional gravity or siphon feed spray equipment. For pressure pot, adjust inlet atomizing pressure to 29 – 58 psi and apply at 10 – 12 fluid ounces per minute. Apply 2 medium wet coats or until hiding is achieved with a 50% overlap allowing each coat to become hand slick before the next coat is applied (approximately 5 – 10 minutes). Apply at a gun distance of 6-8 inches. A cross-coat method (horizontal one coat, vertical the next) may be used for metallic colors for uniform flake orientation. If additional flake orientation is needed, immediately apply a mist coat by increasing the gun distance to 10 – 12 inches. Recommended dry film thickness is 1.0 – 3.0 mils. For additional depth of image (DOI) PC4v250 Clear Coat can be applied as a separate coat.

PRECISION COATINGS

1940 E. Trafficway, Springfield, MO 65802
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DRYING TIMES

Air Dry (68°F, 20°C)	Force Dry (140°F, 60°C)
Dust Free: 15 minutes	To Handle: 20 minutes force dry and 20 minutes cool down
To Deliver: 18 – 24 hours overnight	To Deliver: 2 hours after cool down
To Recoat: Any stage	To Recoat: Any stage after cool down

CLEAN UP

Clean all spray equipment immediately after use. Precision Coating's 17000 Gun Cleaner is a VOC exempt cleaner and is recommended for cleaning application equipment used to apply the PC4v28 system.

PERSONAL PROTECTION

- Read all labels, directions and MSDS sheets prior to opening containers. Follow all precautions.
- Use appropriate Personal Protective Equipment while mixing, during application and until all vapors and spray mist are exhausted.
- For industrial use only by professional, trained painters.

COMPLIANCE STATEMENT

Coating Category: Single Stage Coating	As Packaged		As Applied	
	Grams/Liter	Lbs/Gal	Grams/Liter	Lbs/Gal
Actual VOC	187.12	1.56	150.05	1.25
Regulatory VOC	345.45	2.88	280.83	2.34
	Lbs/Gal Solids	Lbs/Lbs Solids	Lbs/Gal Solids	Lbs/Lbs Solids
HAPs	0.20	0.02	0.14	0.015
	Wt. %	Vol. %	Wt. %	Vol. %
Volatiles	68.73	68.73	65.44	64.99
Water	none	none	none	none
Exempt Compounds	52.44	45.71	52.78	46.57
	Grams/Liter	Lbs/Gal	Grams/Liter	Lbs/Gal
Density	1171	9.76	1185	9.88

DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on Precision Coatings experience and research and is believed to be reliable. As Precision Coatings has no control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.

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PERFORMANCE DATA

TEST METHOD	SYSTEM (7 day, ambient temp. cure)	RESULTS
ASTM D-3359 Adhesion	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 2.2 mils DFT PC4v28/PC04 Topcoat	100% retention (no tape off)
ASTM D-4587 QUV Resistance Accelerated Weathering	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 2.2 mils DFT PC4v28/PC04 Topcoat	Gloss - 93% retention after 2020 hours delta E color change - 0.71 after 2020 hours No blistering, rusting, checking or cracking
ASTM B-117 Salt Fog	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 2.2 mils DFT PC4v28/PC04 Topcoat	No face blistering after 500 hours No face corrosion after 500 hours
ASTM D-2287 Humidity Resistance	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 2.2 mils DFT PC4v28/PC04 Topcoat	No blistering, cracking, softening or delamination after 500 hours Gloss - 98% retention after 500 hours
ASTM D-1308 Chemical Resistance 24 hour spot test	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 2.2 mils DFT PC4v28/PC04 Topcoat	87 octane unleaded gasoline - rating 5 no effect 10% Sulfuric Acid (Acid Rain) – rating 5 no effect
ASTM D-5402 Chemical Resistance solvent rubs	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 2.2 mils DFT PC4v28/PC04 Topcoat	Xylene - 200 double rubs no effect Methyl ethyl ketone (MEK)-200 double rubs no effect 87 octane unleaded gasoline - 200 double rubs no effect.
ASTM D-522 Flexibility	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 2.2 mils DFT PC4v28/PC04 Topcoat	180 degree bend, 1/4" mandrel - pass

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