



PRECISION COATINGS, INC.

PRODUCT DATA

PC4 Series Acrylic Polyurethane Clearcoat

DESCRIPTION:

- Aliphatic polyurethane/acrylic clear coat
- Interior and Exterior surfaces
- Excellent protection for wood and metal substrates
- Spray, brush or roll application
- Low VOC available in 250 g/l, 2.8 lbs/gal, 3.5 lbs/gal & 4.3 lbs/gal systems
- Superior weathering, durability, and chemical resistance
- Decorative uses over PC4 Acrylic Polyurethane Topcoat system
- Gloss, semi-gloss, satin, eggshell, and matte finishes
- Anti-graffiti formulations available

TECHNICAL DATA:

% SOLIDS by volume	30% as packaged, 35% as applied
SPRAYABLE VOC (as applied)	250 g/l, 2.8 lbs/gal, 3.5 lbs/gal & 4.3 lbs/gal (less water & exempt compounds) available
COMPONENTS	PC4 clearcoat (resin) 4 parts / PC-04 (cure) 1 part
POT LIFE	3 hours @ 70° F, 21° C
SHELF LIFE	one year (unopened)
REDUCERS	optional: use PCI's 16050 VOC Exempt Reducer
FLASH POINT	65° F, 18° C
MIX RATIO	4:1 (4 parts PC4 clearcoat : 1 part PC-04 Activator)
RECOMMENDED DRY FILM THICKNESS	1.0 mils to 3.0 mils
COVERAGE	561 – 187 sqft at recommended DFT (no loss)

SURFACE PREPARATION:

PC4 Series Clearcoat may be applied over properly prepared substrates including steel, aluminum, galvanizing, decorative metals such as copper and brass, masonry block, and wood. Recommended preparation is as follows:

Steel, Brass, Copper – Clean the surface of all foreign material SSPC-SP1 and SSPC-SP2 or SSPC-SP3, 6, or 7. Clean to eliminate all oil, grease and soap film contamination.

Aluminum & Galvanizing – Clean the surface of all foreign material SSPC-SP1 and SSPC-SP2 or SSPC-SP3, 6, or 7. Clean to eliminate all oil, grease and soap film contamination.

Wood – Sand to appropriate smoothness. Clean to eliminate sanding dust and other contamination. Porous woods may require additional coats of clear.

Concrete & Masonry – Surface must be cured, clean, dry, and free of contamination and disintegrated or chalky materials. SSPC-SP13 may be used for surface preparation of concrete and masonry block.

PC4 Topcoat – PC4 Clearcoat may be applied directly over PC4 Acrylic Polyurethane Topcoat. Allow topcoat to flash 20 minutes before applying PC4 Clearcoat. After 24 hours, scuff sanding or a light abrasion may be required on the PC4 Acrylic Polyurethane Topcoat before clearcoating. Use 320 grit paper of finer.

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INSTRUCTIONS – MIX RATIO:

Stir or shake thoroughly to ensure uniform mixture. Mix 4 parts PC4 Acrylic Polyurethane Clearcoat with 1 part PC-04 Polyurethane Activator.

Reduction is not necessary. However, clearcoat may be reduced up to 10% by volume using PCI's 16050 VOC Exempt Reducer.

For faster cure times, add up to 8 oz of PCI's 12030 Urethane Accelerator per activated gallon of clearcoat.

For fisheyes or other related surface defects, add 1 oz of PCI's Fisheye Remover, #15000, per activated gallon of clearcoat.

APPLICATION: Apply using 40-55 PSI at the gun for siphon and gravity feed spray guns, 10 PSI max. for HVLP spray guns. Apply 1-3 medium wet coats until desired coverage and flow is reached. Allow a 5 to 10 minute flash time between coats of clear. Recommended film thickness is 1.0 to 3.0 mils DFT. May be brushed or rolled for field service applications. Use a natural bristle brush or ¼ inch to ¾ inch nap, phenolic core roller.

SPRAY GUN SET-UP & PRESSURE:

<u>Type</u>	<u>Fluid Tip</u>	<u>Spraying Pressure</u>
Siphon Feed	1.4mm – 1.7mm	40-65-PSI
Gravity Feed	1.3mm – 1.4mm	40-65 PSI
HVLP Siphon	1.6mm – 1.8mm	max. 10 PSI @ the air cap
HVLP Gravity	1.3mm – 1.5mm	max. 10 PSI @ the air cap
Airless Spray	.015" - .025"	2500 PSI 100 mesh filter
Brush – natural bristle		
Roller – ¼ to ¾ inch nap, phenolic core roller		

DRY TIMES:

PC4 Acrylic Polyurethane Clearcoat may be air dried or force dried

Dry times @ 70°F (21°C) and 50% RH

Dust Free	15 minutes
Tack Free	3 hours
Dry Time	24 hours
Recoat	May be recoated with itself at any stage. Sanding will become necessary after 24 hours.
Force Drying:	140° F for 20 min. Allow a 10 min. cool down time.

CLEAN UP:

Clean all spray equipment immediately after use. PCI's 17000 Gun Cleaner is a VOC exempt cleaner and is recommended for cleaning application equipment used to apply the PC4 system.

Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin.

DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on Precision Coatings, Inc. experience and research and is believed to be reliable. As PCI 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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