



## ***PC4v21 Series-2.1 VOC Acrylic Polyurethane Clear Coat***

### **DESCRIPTION**

PC4v21 Clear Coat is an acrylic polyurethane clear coat designed for fleet refinishing, production shop refinishing and OEM applications. It is designed for overall clear coat applications for use over PC4v28 Acrylic Polyurethane Topcoat, waterborne basecoats and solvent borne basecoats. PC4v21 Clear Coat is highly productive offering fast air dry times, exceptional high gloss and depth of image (DOI) and easy application. PC4v21 Clear Coat is VOC compliant at less than 2.1 lbs per gallon.

### **SUITABLE SUBSTRATES**

- PC4v28 Acrylic Polyurethane Topcoat
- Waterborne Basecoats
- Solvent Borne Basecoats

### **MIXING**

4 Parts		1 Part
PC4v21 Clear Coat	+	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 fisheyes** or other related surface defects, add 1 capful of Precision Coating's 15000 Fisheye Remover per activated quart of clear coat.

### **RECOAT TIMES**

- PC4v28 Acrylic Polyurethane Topcoat: minimum 20 minutes, maximum 24 hours
- Waterborne basecoats: as recommended by the basecoat manufacturer
- Solvent borne basecoats: as recommended by the basecoat manufacturer

### **APPLICATION**

- Apply 2 medium wet coats
- Allow the 1<sup>st</sup> coat to flash 2 to 5 minutes for a wet on wet application of the 2<sup>nd</sup> coat

### **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 fl. oz. per minute

### **APPLICATION TECHNIQUES**

Adjust air pressure to 10 psi cap pressure for HVLP, 40 to 45 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. Apply at a gun distance of 6-8 inches.

## **PRECISION COATINGS**

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# Technical Product Data



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### BUFFING

Buffing is optional. After 24 hours of air dry or cool down from force dry, sand with 1500 grit or finer paper and buff with the appropriate compound.

### DRYING TIMES

Air Dry (68°F, 20°C)	Force Dry (140°F, 60°C)
Dust Free: 20 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

### 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 PC4v21 Clear Coat.

### PERSONAL PROTECTION

- Read all labels, directions and SDS / 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: Clear Coating	As Packaged		As Applied	
	Grams/Liter	Lbs/Gal	Grams/Liter	Lbs/Gal
Actual VOC	22.79	0.19	17.99	0.15
Regulatory VOC	71.97	0.60	49.18	0.41
	Lbs/Gal Solids	Lbs/Lbs Solids	Lbs/Gal Solids	Lbs/Lbs Solids
HAPs	none	none	none	none
	Wt. %	Vol. %	Wt. %	Vol. %
Volatiles	76.50	71.14	69.83	64.91
Water	none	none	none	none
Exempt Compounds	74.68	68.77	68.37	63.02
	Grams/Liter	Lbs/Gal	Grams/Liter	Lbs/Gal
Density	1237	10.31	1238	10.32

*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  2.5 mils DFT PC4v28Topcoat 1.3 mils PC4V21 Clear Coat	100% retention (no tape off)
ASTM D-4587 QUV Resistance Accelerated Weathering	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner  2.5 mils DFT PC4v28Topcoat 1.3 mils PC4V21 Clear Coat	Gloss - 97% retention after 2092 hours delta E color change - 0.36 after 2092 hours  No blistering, rusting, checking or cracking
ASTM B-117 Salt Fog	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner  2.5 mils DFT PC4v28Topcoat 1.3 mils PC4V21 Clear Coat	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  2.5 mils DFT PC4v28Topcoat 1.3 mils PC4V21 Clear Coat	No blistering, cracking, softening or delamination after 500 hours  Gloss - 99% retention after 500 hours
ASTM D-1308 Chemical Resistance 24 hour spot test	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner  2.5 mils DFT PC4v28Topcoat 1.3 mils PC4V21 Clear Coat	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  2.5 mils DFT PC4v28Topcoat 1.3 mils PC4V21 Clear Coat	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  2.5 mils DFT PC4v28Topcoat 1.3 mils PC4V21 Clear Coat	180 degree bend, 1/4" mandrel - pass

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