

# Technical Product Data



## PC3v100 Acrylic Polyurethane Clear Coat

PRECISION COATINGS

### DESCRIPTION

Aliphatic polyurethane  
Superior weathering and durability  
Ultra low VOC, less than 1 gram per liter  
Fine finish quality  
Interior / exterior

Excellent protection for wood (interior)  
Non-yellowing  
Field and shop application  
Gloss, semi-gloss, satin, eggshell, matte  
LEED NC 2009 compliant

### USES

Adds depth of image in gloss  
Clear wood furniture finish

Protective surface for restaurants and hotels  
Anti-graffiti formulation available

### TECHNICAL DATA

% SOLIDS by volume	30% as packaged, 35% as applied
COATINGS VOC (as packaged)	0.12 g/l (less water & exempt compounds)
SPRAYABLE VOC (as applied)	0.07 g/l (less water & exempt compounds)
COMPONENTS	PC3v100 (resin) 3 parts / PC-03 (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	79° F, 26° C
MIX RATIO	3:1 (3 parts PC3 : 1 part PC-03 Activator)
RECOMMENDED DRY FILM THICKNESS	1.0 mils to 3.0 mils
THERORETICAL COVERAGE	561 – 187 sq ft at recommended DFT (no loss)

### SURFACE PREPARATION

PC3v100 Clear Coat may be applied over properly prepared substrates including steel, aluminum, galvanizing, selective decorative metals and interior wood. Good painting practices require that before applying coatings, a test or mock-up be performed to ensure the adhesion, appearance and color meet the expectations of all concerned. Recommended preparation is as follows:

**Steel** – 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** – 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.

**Galvanized Steel** – Preparation shall meet ASTM D6386 –10. Remove all contaminants per SSPC-SP1, check for the presence of chromates or other passivation treatments per SSPC-SP16. If passivation treatment exists, brush-off blast cleaning per SSPC-SP16 is required. Complete removal of chromates or other passivating treatments must be confirmed by testing (SSPC-SP16 or ASTM B 201) prior to coating application.

**Wood Interior Only** – Sand to appropriate smoothness. Clean to eliminate sanding dust and other contamination. Porous woods may require additional coats of clear. Not recommended for exterior wood.

**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.

**PC3v100 Topcoat** – PC3v100 Clear Coat may be applied directly over PC3v100 Acrylic Polyurethane Topcoat. Allow topcoat to flash 20 minutes before applying PC3v100 Clear Coat. After 24 hours, scuff sanding or a light abrasion may be required on the PC3v100 Acrylic Polyurethane topcoat before

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## **PC3v100 Acrylic Polyurethane Clear Coat**

clear coating utilizing 320 grit paper or finer. PC3V100 can be cut and buffed to achieve extreme high gloss, flaw free finish.

### **INSTRUCTIONS – MIX RATIO**

Stir or shake each container before mixing together. Mix thoroughly 3 parts PC3v100 Acrylic Polyurethane Clear Coat with 1 part PC-03 Polyurethane Activator.

Reduction is not necessary. However, clear coat may be reduced up to 10% by volume using acetone or 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 clear coat. For fisheyes or other related surface defects, add 1 oz of PCI's Fisheye Remover, #15000, per activated gallon of clear coat.

### **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.

### **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
Pressure Pot	1.1 mm- 1.3 mm	29 PSI - 58 PSI
Airless Spray	.015" - .025"	2500 PSI 100 mesh filter

### **DRY TIMES**

PC3v100 Acrylic Polyurethane Clear Coat 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:	30 minute flash time / 140° F for 20 min. / allow a 10 min. cool down time

### **CLEAN UP**

Clean all spray equipment immediately after use. Acetone may be used to clean spray equipment. PCI's 17000 Gun Cleaner is a VOC exempt cleaner and is recommended for cleaning application equipment used to apply the PC3v100 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.*

6-2016

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