



PC4 Acrylic Polyurethane Clear Coat

DESCRIPTION

Aliphatic polyurethane
Interior and exterior surfaces
Ferrous and non-ferrous substrates
Field and shop application
Product finish
Fleet finish

Gloss, semi-gloss, satin, eggshell, matte
Chemical resistant
Superior weathering and durability
Decorative uses over PC4 Topcoat
Excellent protection for interior wood
Adaptable for OEM applications

TECHNICAL DATA

% SOLIDS by volume	30% as packaged, 35% as applied
COATING VOC (as packaged)	250 g/l, 2.8, 3.5, 4.3 lbs./gal. (less water & exempt compounds)
COATING VOC (as applied)	250 g/l, 2.8, 3.5, 4.3 lbs./gal. (less water & exempt compounds)
COMPONENTS	PC4 Clear Coat (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 PC3v100 : 1 part PC-04 Activator)
RECOMMENDED DRY FILM THICKNESS	1.0 mils to 3.0 mils
THEORETICAL COVERAGE	561 – 187 sq ft at recommended DFT (no loss)

SURFACE PREPARATION

PC4 Clear Coat may be applied over properly prepared substrates including steel, aluminum, galvanizing, decorates metals such as copper and brass, masonry block and interior wood. Good painting practices dictate that before applying coatings a test or mock-up be performed to ensure that the adhesion, appearance and color are compatible with the substrate and meet the expectations of the owner. Recommended preparation is as follows:

Steel – Clean the surface of all foreign material SSPC-SP1 followed by SSPC-SP2, SP3, SP6, SP7, SP11, SP14 or SP15. Precision's 02150 Metal Conditioner may be used to clean and treat steel substrates to eliminate oil, soap film, grease, and flash rusting.

Aluminum - Remove all contaminants per SSPC-SP1 and abrade using hand tool, power tool or SSPC-SP16 to obtain a profile equivalent to 220 grit sandpaper.

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.

Concrete, Masonry, MDF, Drywall – Surface must be clean, dry and free of any dirt, dust, grease, oil, wax, mildew, disintegrated or chalky materials or other contaminants. PC4 is not recommended for floors.

Previously Coated Surfaces - Surface must be clean, dry, and free of any dirt, dust, grease, oil, wax, mildew, disintegrated or chalky materials or other contaminants. Aged coatings should be abraded to achieve an acceptable profile to provide adequate adhesion for the primer and topcoat.

PRECISION COATINGS

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PC4 Acrylic Polyurethane Topcoat

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INSTRUCTIONS – MIX RATIO

Stir or shake each container before mixing together. Mix thoroughly 4 parts PC4 Acrylic Polyurethane Topcoat with 1 part PC-04 Polyurethane Activator.

Reduction is not necessary. However, paint 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 topcoat. For fisheyes or other related surface defects, add 1 oz of PCI's Fisheye Remover, #15000, per activated gallon of topcoat.

APPLICATION FOR "SOLID COLORS" & "METALLIC COLORS"

Environmental Conditions: Air and surface temperature must be above 50° Fahrenheit and no more than 95° Fahrenheit. Surface temperature must be at least 5°F (3°C) above the dew point.

Application: Solid colors may be applied by spray, roller and brush application. Metallic colors should be applied by spray application only. Allow a 5 to 10 minute flash time between coats if spray applied. PC4 should be applied to achieve a recommended dry film thickness between 1.0 to 3.0 mils. For detailed metallic and iridescent application instructions, see Precision Coatings' Guidance: "Metallic and Iridescent Finishes."

SPRAY GUN SET-UP & PRESSURE

Type	Fluid Tip	Spraying Pressure
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*	.011" - .015"	2500 PSI 100 mesh filter

**For solid colors only, not recommended for application of metallics.*

DRY TIMES

PC4 Acrylic Polyurethane Topcoat 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

TEMPERATURE RESISTANCE (Dry)

Continuous	200° F
Intermittent	250° F

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 PC4 Acrylic Polyurethane Topcoat.

Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin. 10/2016

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