

## P R O D U C T      D A T A

### *PC4 Series Acrylic Polyurethane Clearcoat*

**DESCRIPTION:**

- Aliphatic polyurethane/acrylic clear coat system
- 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 or finer.

# PC4 Series Acrylic Polyurethane Clearcoat

## **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.<br>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.

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