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**P R O D U C T      D A T A**

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***PC3v100 Series  
Acrylic Polyurethane Topcoat*****DESCRIPTION:**

PC3 Acrylic Polyurethane Topcoat *v100 series* is an ultra low VOC coating with a sprayable VOC less than 100 grams per liter (less water & exempt compounds). PC3v100 series is a high performance aliphatic, acrylic polyurethane coating system designed for performance demanding markets such as OEM and aftermarket transportation, architectural applications, industrial and general metal applications, aviation, marine, specialty industrial maintenance, wood finishing, and engineered plastics applications. This is a conventional system employing the use of a long standing chemistry known throughout the industry for its superior weathering and exterior durability, chemical resistance and extreme protective properties. The PC3v100 system is available in an unlimited color range including metallics, iridescent (pearls), and solid colors, all available in full gloss, semi-gloss, satin, eggshell, and matte finishes.

**TECHNICAL DATA:**

|                                |   |
|--------------------------------|---|
| % SOLIDS by volume:            | 34 % as packaged, 38 % as applied             |
| COATINGS V.O.C. (as packaged): | max. 100g/l (less water & exempt compounds)   |
| SPRAYABLE V.O.C. (as applied): | max. 100g/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 PC3v100:1 part PC-03 Activator)  |
| RECOMMENDED DRY FILM THICKNESS | 1.5 mils to 3.0 mils                          |
| THEORETICAL COVERAGE:          | 406 - 203 sqft at recommended DFT (no loss)   |

**SURFACE PREPARATION:**

Best results are achieved when PC3v100 Series Topcoat is applied over two component primer such as PCI's DTM 1300 Series High Build Primer, DTM 1400 Series Non-Sanding Primer or DTM 3000 Series Polyurethane Primer.

PC3v100 Series Topcoat may be applied over properly prepared substrates including steel, aluminum, galvanizing, decorative metals such as copper and brass, previously coated surfaces, masonry block, and wood. Recommended preparation is as follows: Clean the surface of all foreign material SSPC-SP1 and SSPC-SP2 or SSPC-SP3. SSPC-SP13 may be used for masonry block. Physically abrade existing coated surfaces. PCI's 16200 Paint Prep may also be used to treat existing finishes, including polyurethane finishes. Paint Prep eliminates the need for abrasion before priming or painting. The existing finish must be tightly adhered to the substrate. PCI's 02150 Metal Conditioner may be used to clean and treat metal substrates prior to priming or painting to eliminate grease, oil, and flash rusting.

**BENEFITS:**

- Ultra low VOC, less than 100 grams/liter (less water & exempt compounds) as applied
- Excellent exterior weathering durability
- Mirror image high gloss (all gloss ranges available)
- Superior chemical resistance
- Exceptional color retention
- Excellent abrasion resistance
- Unlimited color offering including metallics and pearls
- All colors are lead and chromate free

# *PC3v100 Series*

## *Acrylic Polyurethane Topcoat*

### **INSTRUCTIONS – MIX RATIO:**

Stir or shake thoroughly to ensure uniform mixture. Mix 3 parts PC3v100 Acrylic Polyurethane Topcoat with 1 part PC-03 Polyurethane Activator.

**Reduction is not necessary.** However, paint 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 ready to spray gallon of topcoat.

**For fisheyes or other related surface defects,** add 1 oz of PCI's Fisheye Remover, #15000, per ready to spray gallon of topcoat.

**APPLICATION FOR “SOLID COLORS” & “METALLIC COLORS”:** 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. Recommended film thickness is 1.5 to 3.0 mils DFT. May be brushed or rolled for field service applications. Use a natural bristle brush or ¼ inch to ½ inch nap 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 ½ inch nap |                  |                           |

### **DRY TIMES:**

PC3v100 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.<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 PC3v100 system.

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

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*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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PRECISION COATINGS, INC.

# P R E F O R M A N C E     D A T A

## *PC3v100 Series Acrylic Polyurethane Topcoat*

| TEST METHOD  | SYSTEM (7 day, ambient temp. cure)  | RESULTS   |
|--|---|---|
| ASTM D-3359<br>Adhesion                                    | Cold Rolled Steel<br>Q-Panel<br>Solvent wipe 02150 Metal<br>Conditioner<br>1.4 mils DFT PC3v100/PC03<br>Topcoat | 100% retention (no tape off)  |
| ASTM D-4587<br>QUV Resistance<br>Accelerated<br>Weathering | Cold Rolled Steel<br>Q-Panel<br>Solvent wipe 02150 Metal<br>Conditioner<br>1.4 mils DFT PC3v100/PC03<br>Topcoat | Gloss - 96% retention after 2020 hours<br>delta E color change - 0.27 after 2020 hours<br>No blistering, rusting, checking or cracking                |
| ASTM B-117<br>Salt Fog                                     | Cold Rolled Steel<br>Q-Panel<br>Solvent wipe 02150 Metal<br>Conditioner<br>1.4 mils DFT PC3v100/PC03<br>Topcoat | No face blistering after 500 hours<br>No face corrosion after 500 hours   |
| ASTM D-2287<br>Humidity Resistance                         | Cold Rolled Steel<br>Q-Panel<br>Solvent wipe 02150 Metal<br>Conditioner<br>1.4 mils DFT PC3v100/PC03<br>Topcoat | No blistering, cracking, softening or delamination after 500 hours<br>Gloss - 97% retention after 500 hours   |
| ASTM D-1308<br>Chemical Resistance<br>24 hour spot test    | Cold Rolled Steel<br>Q-Panel<br>Solvent wipe 02150 Metal<br>Conditioner<br>1.4 mils DFT PC3v100/PC03<br>Topcoat | 87 octane unleaded gasoline - rating 5 no effect<br>10% Sulfuric Acid (Acid Rain) – rating 5 no effect  |
| ASTM D-5402<br>Chemical Resistance<br>solvent rubs         | Cold Rolled Steel<br>Q-Panel<br>Solvent wipe 02150 Metal<br>Conditioner<br>1.4 mils DFT PC3v100/PC03<br>Topcoat | Xylene - 200 double rubs no effect<br>Methyl ethyl ketone (MEK)-200 double rubs no effect<br>87 octane unleaded gasoline - 200 double rubs no effect. |
| ASTM D-522<br>Flexibility                                  | Cold Rolled Steel<br>Q-Panel<br>Solvent wipe 02150 Metal<br>Conditioner<br>1.4 mils DFT PC3v100/PC03<br>Topcoat | 180 degree bend, 1/4" mandrel - pass  |

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