



PC6 Series **Waterborne Urethane Topcoat**

DESCRIPTION

Single component	Gloss, semi-gloss, satin, eggshell, matte
Waterborne urethane dispersion	Metallic, iridescent (pearl) and solid color
Interior and exterior surfaces	Excellent adhesion & chemical resistant
Field and shop application	Superior weathering and durability
Soap & Water Cleanup	No Isocyanates
Very Low Odor - Low VOC	LEED NC 2009 compliant

TECHNICAL DATA

% SOLIDS by volume	40%
COATINGS VOC (as packaged)	less than 100 g/l (less water & exempt compounds)
SPRAYABLE VOC (as applied)	less than 100 g/l (less water & exempt compounds)
RESIN TYPE	urethane dispersion
COMPONENTS	single component
SHELF LIFE	one year (unopened)
FLASH POINT	144° F (62° C)
RECOMMENDED DRY FILM THICKNESS	1.0 mils to 3.0 mils DFT
THEORETICAL COVERAGE	641 – 213 sq ft at recommended DFT (no loss)

SURFACE PREPARATION

Best results are achieved when PC6 Waterborne Urethane Topcoat is applied over a high performance primer such as PCI's DTM 1600 Series High Build Waterborne Primer or PCI's DTM 1300 Series High Build Modified Epoxy Primer.

PC6 Topcoat may be applied directly over properly prepared substrates including steel, aluminum, galvanizing, and decorative metals such as copper and brass. Substrates such as concrete, masonry, interior wood, MDF, drywall and previously coated surfaces should first be properly primed. Recommended preparation is as follows:

Steel – Clean the surface to ensure that the substrate is free of grease, dirt, wax, mildew and other contaminants and abrade with 220 grit sandpaper or finer (SSPC-SP1 and SSPC-SP2 or SSPC-SP3, 6, or 7). PCI's 02150 Metal Conditioner may be used to clean and treat steel substrates to eliminated oil, soap film, grease, and flash rusting.

Aluminum & Galvanizing – Clean the surface to ensure that the substrate is free of grease, dirt, wax, mildew and other contaminants and abrade with 220 grit sandpaper or finer (SSPC-SP1 and SSPC-SP2 or SSPC-SP3, 6, or 7). PCI's 02150 Metal Conditioner may be used to clean and treat aluminum and galvanizing to eliminate oil and soap film.

Concrete, Masonry, Wood, MDF, Drywall – Surface must be clean, dry and free of any dirt, dust, grease, oil, wax, mildew, disintegrated or chalky materials or other contaminants.

Coated surfaces – Physically abrade existing coated surfaces. The existing finish must be tightly adhered to the substrate and be free of grease, dirt, wax, mildew and other contaminants.

PRECISION COATINGS

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INSTRUCTIONS

Stir or shake thoroughly to ensure uniform mixture.

Reduction is not necessary. However, paint may be reduced up to 5% by volume using tap water.

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 1.0 to 3.0 mils DFT. For detailed metallic and iridescent application instructions, see Precision Metallic and Iridescent Guidance. Solid colors may also be brushed or rolled. Metallic colors are not recommended to be brushed or rolled.

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

**For solid colors only*

DRY TIMES

Dry times @ 70°F (21°C) and 50% RH

Dust Free	15 minutes
Dry to Touch	1 hour
Dry Time	24 hours
Full Cure	14 days
Recoat	Unlimited - no recoat time necessary Sanding will become necessary after 24 hours.

CLEAN UP

Clean all tools and spray equipment immediately after use with soap and warm water. Acetone may be used as a final rinse.

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 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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Technical Product Data



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PERFORMANCE DATA

TEST METHOD	SYSTEM (30 day, ambient temp. cure)	RESULTS
ASTM D-3359 Adhesion	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.2 mils DFT PC6 Waterborne Urethane Topcoat	100% retention (no tape off)
ASTM D-4587 QUV Resistance Accelerated Weathering	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.2 mils DFT PC6 Waterborne Urethane Topcoat	Gloss - 82% retention after 1000 hours delta E color change - 0.7 after 1000 hours No blistering, rusting, checking or cracking
ASTM B-117 Salt Fog	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.2 mils DFT PC6 Waterborne Urethane Topcoat	No face blistering after 100 hours No face corrosion after 100 hours
ASTM D-2287 Humidity Resistance	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.2 mils DFT PC6 Waterborne Urethane Topcoat	No blistering, cracking, softening or delamination after 100 hours Gloss - 88% retention after 100 hours
ASTM D-1308 Chemical Resistance 24 hour spot test	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.2 mils DFT PC6 Waterborne Urethane Topcoat	Water resistance – rating 5 no effect 2 % Sulfuric Acid (Acid Rain) – rating 5 no effect
ASTM D-4366 Pendulum Hardness	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.2 mils DFT PC6 Waterborne Urethane Topcoat	Glass = 100s PC6 Waterborne Urethane 94s
ASTM D-522 Flexibility	Cold Rolled Steel Q-Panel Solvent wipe 02150 Metal Conditioner 1.2 mils DFT PC6 Waterborne Urethane Topcoat	180 degree bend, 1/4" mandrel - pass

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