

JC630 4.2 Polyurethane Clearcoat

Background

SHOP-LINE® JC630 is a two component 4.2 VOC polyurethane clearcoat that is designed to maximize speed and appearance and may be used in either cross flow, air dry or downdraft force cure spray booths.

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Clear

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Hardener

JH6360 4.2 Polyurethane Hardener-Fast
 JH6370 4.2 Polyurethane Hardener-Medium
 JH6380 4.2 Polyurethane Hardener-Slow
 JH6390 4.2 Polyurethane Hardener-Extra Slow

Compatible Substrates

Shop-Line Refinish Basecoats

Preparation

Allow basecoat color a minimum of 30 minutes and a maximum of 24 hours before clearing. After 24 hours the basecoat should be lightly sanded before applying JC630.

Mixing

Ratios



JC630 : JH63xx
 4 : 1



Pot life is 1.5 - 2 hours at 70°F (21°C)

Additives

JX993 Flex Additive, 10% to RTS quart.
 JX994 Fisheye Eliminator, ½ oz. per RTS quart.
 SU4985 Universal Matting Agent, see ONECHOICE® Bulletin OC-2.

Application

Coats



2 - 3 coats
 For optimum performance, final recommended film build is 2.0 - 2.5 mils

Air pressure



HVLP 10 psi at the air cap
 Conventional 50 - 60 psi at the gun

Gun setup

1.3 - 1.5 mm or equivalent

Dry Times

Between coats



5 - 10 minutes at 70°F (21°C)

With JH6360 Hardener

Dust: 5 - 10 minutes
 Tack: 30 - 50 minutes
 Tape / Polish: 2 - 4 hours
 Force dry: 15 minutes at 140°F (60°C)



With JH6370, JH6380, JH6390

Dust: 10 - 15 minutes
 Tack: 50 - 60 minutes
 Tape / Polish: 2 - 4 hours / 6 - 8 hours



Force dry:

20 minutes at 140°F (60°C), allow a cool down of 90 minutes to polish or to put into service.

Recoat: After force cure and cool down or 8 hours, overnight at 70°F (21°C) Must be lightly scuffed before recoating.

IR (Infrared) 12 - 15 minutes

Clean Up

Clean spray guns, gun cups, storage pots thoroughly with JT501 General Purpose Solvent or other clean up solvent after each use.
 Follow EPA guidelines for proper storage and disposal of solvent-borne waste paint.

Properties

VOC

Package 3.54 lbs /gal (424 gm/l)
 Applied Less exempts 4:1 4.18 lbs /gal (501gm/l)

Solids by weight

34.7%

Dry Film build per coat

Applied (4:1) 1.0 - 1.5 mils

Square foot coverage at 1 mil

Applied (4:1) 560 sq. ft. / gal. @ 100% transfer

Limitations

ShopLine products should not be combined with components of other product lines

Precautionary Information:

The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Spray equipment must be handled with due care and in accordance with manufacturer's recommendations. Follow label directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

Medical Response:

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320.

Material Safety Data Sheet

Material Data Safety Sheets for the PPG products mentioned in this publication are available through your PPG *Shop-Line* Distributor. To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries is constantly improving its coating and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your *Shop-Line* Distributor for the most up-to-date information.

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