

JC780

2.1 VOC Polyurethane Speed Clear

Background

SHOP-LINE® JC780 is a two component 2.1 VOC high gloss polyurethane speed clear designed for production shops for use in either cross flow air dry or downdraft force cure spray booths. JC780 delivers very good gloss, DOI and buffability.

Components

Clearcoat

JC780 2.1 VOC Polyurethane Speed Clear

Hardener

JH7870 Polyurethane Hardener - Fast
 JH7880 Polyurethane Hardener - Slow
 JH7890 Polyurethane Hardener - Extra Slow

Compatible Products

Can be applied over:

JBPX *Shop-Line* Plus 3.5 VOC Acrylic Urethane Basecoats
 JBX 3.5 VOC Acrylic Basecoat
 JTX 2.8 VOC Acrylic Urethane Direct Gloss
 JLX 2.8 VOC Acrylic Enamel

Preparation

Allow basecoat color to dry a minimum of 30 minutes and a maximum of 24 hours before clearing. After 24 hours the basecoat should be lightly sanded and reapplied before applying JC780.

Mixing



Ratios:

| | | |
|--------------|---|---------------|
| JC780 | : | JH78xx |
| 4 | : | 1 |



Pot Life:

1.5 - 2 hours at 70°F (21°C)



Additives:

| | |
|---------|--|
| SLV4985 | Universal Flattening Agent, see ONECHOICE® product bulletin OC-7 |
| SLV814 | Universal Flexibilizer add 10% to RTS quart |
| SLV73 | Fisheye Eliminator, 0.5 oz. to RTS quart |
| SL93LV | Accelerator, add 2% to RTS quart |

Air Pressure and Gun Setup



HVLP:

8 - 10 psi at the air cap

Compliant:

29 - 40 psi at the gun

Gun Setup:

1.3 - 1.6 mm or equivalent

Note: For best overall results, refer to spraygun manufacturer's recommendations for inlet air pressures.

Application



Coats: 2 - 3 coats

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

Dry Times



Between Coats: 5 - 10 minutes at 70°F (21°C)



Air Dry:

With JH7870
Dust: 10 - 15 minutes
Tape: 2 - 4 hours

With JH7880 / JH7890
15 - 20 minutes
2 - 4 hours



Force Dry: 15 minutes at 140°F (60°C)



IR: 12 - 15 minutes



Polish:

Air Dry

2 - 4 hours or overnight at 70°F (21°C) to polish or to put into service

Force Dry

60 - 90 minutes cool down to polish and put in service



Recoat:

Air Dry

8 hours or overnight at 70°F (21°C)

Force Dry

60 - 90 minutes cool down to recoat

Must lightly scuff before recoating.

Clean Up

Clean spray guns, gun cups, storage pots, etc., thoroughly with JR reducers, JT571 0.21 VOC General Purpose Solvent or another appropriate clean up solvent after each use. Follow EPA guidelines for proper storage and disposal of solvent-borne waste paint.

Properties

Dry film build per coat

Applied (4:1) 1.0 - 1.5 mils

Square ft. coverage at 1 mil

Applied (4:1) 476 - 480 sq. ft. gal. at 100% transfer

| Properties | | | |
|---|-----------------------|------------------------------------|------------------------------------|
| RTS Combinations: | JC780 : JH78xx | JC780 : JH78xx : SL93LV | JC780 : JH78xx : SLV814 |
| Volume Ratio: | 4 : 1 | 4 : 1 + 2% | 4 : 1 : ½ |
| Applicable Use Category | Clear Coat | Clear Coat | Clear Coat |
| VOC Actual (g/L) | 104 | 98-102 | 99 |
| VOC Actual (lbs/gal) | 0.87 | 0.82-0.85 | 0.82 |
| VOC Regulatory (less water less exempt) (g/L) | 249 | 236-244 | 240 |
| VOC Regulatory (less water less exempt) (lbs/gal) | 2.08 | 1.97-2.04 | 2.00 |
| Density (g/L) | 1111 | 1117-1118 | 1122 |
| Density (lbs/gal) | 9.27 | 9.32-9.33 | 9.36 |
| Volatiles wt. % | 69.4 | 69.2-69.6 | 69.8 |
| Water wt. % | 0.0 | 0.0 | 0.0 |
| Exempt wt. % | 60.0 | 60.4-60.5 | 61.0 |
| Water vol. % | 0.0 | 0.0 | 0.0 |
| Exempt vol. % | 58.3 | 58.4-58.5 | 58.8 |
| Solids vol % | 28.7 | 29.6-30.2 | 29.0 |
| Solids wt. % | 29.6 | 30.4-30.8 | 29.3 |



Limitations

Shop-Line 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 use. 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 of 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

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

Material Data Safety Sheets for the PPG products mentioned in this publication are available through your PPG *Shop-Line* brand 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* brand distributor or visit www.ppgrefinish.com for the most up-to-date information.

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