

ESC621

2.1 VOC Clear

Hot Temperature Option

For hot temperature applications or when longer melt-in times are required, ESH210 may be used as a slower hardener option in ESC621 clearcoat.

Application Guide:

Refer to the ESC621 2.1 VOC Clear **Technical Data Sheet DFE-09** for additional information on substrate preparation, spray equipment set up, and other information regarding the use and application of ESC621 Clearcoat.

Mixing Ratio: Note – Mixing ratio with ESH210 Hardener is different than ESC621 Clear with conventional hardener.



1 part ESC621 Clear
1 part ESH210 Hardener

Pot Life:



With ESH210: 8 hours @ 95°F (35°C) / 50% RH
NOTE: High heat and humidity will shorten pot life

Dry Times:



- Tack-Free: 2-3 hours @ 70°F (21°C), 90 minutes @ 95°F (35°C)
- Print Free: 3.5-4 hours @ 70°F (21°C), 2 hours @ 95°F (35°C)
- Tape Time: Overnight @ 70°F (21°C) depending on film thickness*, 4 - 6 hours @ 95°F (35°C)
- Overcoat/Recoat: 30 minutes minimum, 72 hours max @ 70°F (21°C), 48 hours maximum @ 95°F (35°C) before sanding is required

* Thicker films require longer dry times at all temperatures

Theoretical Coverage

556 sq. ft.

Theoretical coverage in sq. ft. per US gal. Ready-to-spray (RTS) giving 1mil (25µm) dry film thickness (assuming 100% transfer efficiency).

Physical Characteristics:

Total Solids By Weight (RTS)

33.46%

Total Solids By Volume (RTS)

34.71%

RTS Combinations:	ESC621 Clear	ESC621 : ESH210
Volume Ratio	Package (as is)	1 : 1
Applicable Use Category	Clear	Clear
VOC Actual	184.93 (g/L)	92.27 (g/L)
VOC Actual	1.54 (lbs/gal)	.77 (lbs/gal)
VOC Regulatory (less water less exempt)	291.53 (g/L)	203.7 (g/L)
VOC Regulatory (less water less exempt)	2.43 (lbs/gal)	1.70 (lbs/gal)
Density	1029 (g/L)	1162 (g/L)
Density	8.59 (lbs/gal)	9.70 (lbs/gal)
Volatiles wt.	55.90%	66.54%
Water wt.	0.06%	.03%
Exempt wt.	37.87%	58.55%
Water vol.	.07%	.04%
Exempt vol.	36.50%	54.46%

Health and Safety:

Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgcommercialcoatings.com (Safety, SDS Search) or your PPG Distributor.

For additional information regarding this product, see the SDS and LABEL information.

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PPG Industries
Commercial Coatings
19699 Progress Drive
Strongsville, OH 44149
1-800-647-6050

PPG Canada Inc.
2301 Royal Windsor Drive, Unit #6
Mississauga, Ontario L5J 1K5
1-888-310-4762