

## JC815 Low VOC Speed Clear (National Rule)

### Background

SHOP-LINE® JC815 Low VOC Speed Clear is a fast drying, two component 2.1 VOC speed clearcoat developed for production shops. It is designed for use in either cross draft or downdraft spray booths. JC815 can be air dried or short baked offering speed and versatility. This product sheet for use in National Rule areas only.

### Components

**Clear**  
JC815 Low VOC Speed Clear

**Hardener**  
JH8180 Low VOC Speed Clear  
Hardener - Standard  
JH8190 Low VOC Speed Clear  
Hardener - High Temp

**Reducer**  
JR505 Fast Reducer  
JR506 Medium Reducer  
JR507 Slow Reducer  
JR508 Very Slow Reducer

Reducer selection information available  
online SLTB-001NR *Shop-Line* Reducer  
Selection Guide National Rule

### Compatible Products

#### Can be applied over:

JBP *Shop-Line* Plus Acrylic Urethane Basecoat  
JB *Shop-Line* Basecoat  
JAU Direct Gloss Acrylic Urethane  
JE 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 JC815.

### Mixing



**Ratios:**

<b>JC815</b>	:	<b>JH8180/JH8190</b>	:	(Optional) <b>JR50x</b>
<b>4</b>	:	<b>1</b>	:	<b>0.5*</b>



**Pot Life:**

2 - 2.5 hours at 70°F (21°C)



**Additives:**

SU4985	Universal Mastting Agent, Refer to ONECHOICE® bulletin OC-2
JX993	Flex Additive add 10% to RTS quart
JX994	Fisheye Eliminator add 0.5 oz. 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.

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## Application

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**Coats:** 2 - 3 medium wet coats

For optimum performance, final recommended film build is 2.0 – 2.5 mils dry.

## Dry Times

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**Between Coats:** 3 - 5 minutes at 70°F (21°C)



**Air Dry:** Dust: 15 - 20 minutes  
Handleable: 2 hours  
Tape: 3 hours



**Force Dry:** 20 minutes at 140°F (60°C)



**IR:** 15 minutes



**Polish:** **Air Dry**  
4 - 6 hours at 70°F (21°C) to polish and put into service  
**Force Dry**  
90 minutes after cool down to polish and put into service



**Recoat:** **Air Dry**  
12 - 16 hours at 70°F (21°C)  
**Force Dry**  
90 minutes after cool down  
Must lightly scuff before recoating

## Clean Up

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

## Properties

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<b>Dry Film Build Per Coat</b>	<b>Applied 4 : 1 : 0.5</b>	<b>1.2 mils</b>
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## Properties Continued

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RTS Combinations:	JC815 : JH81X0	JC815 : JH81X0 : JR50X	JC815 : JH81X0 : JR50X : JX993	JC815 /SU4985: JH81X0
Volume Ratio:	4 : 1	4 : 1 : 0.5	4 : 1 : 0.5 +10%	FC01 - FC05
Applicable Use Category	Multi-Stage Clear Coating	Multi-Stage Clear Coating	Specialty Ctg. Clear Ctg. (Flexed)	Specialty Ctg. Clear Ctg. (Matt)
VOC Regulatory (less water less exempt) (g/L)	242	310-327	337-350	404-443
VOC Regulatory (less water less exempt) (lbs/gal)	2.02	2.59-2.73	2.81-2.92	3.37-3.71
Solids vol. %	41.9-42.0	38.1	38.2	36.5-37.5
Solids wt. %	40.0-40.1	37.3-37.4	38.1-38.2	38.7-38.8
Sq. Ft. coverage / US Gal at 1 mil 100% transfer efficiency	672-674	611	613	585-602



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### Limitations

*Shop-Line* products should not be combined with components of other product lines.

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### 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.

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### Medical Response:

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

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### 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](http://www.ppgrefinish.com) for the most up-to-date information.

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