

JC815 Low VOC Speed Clear

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.

Components

Clear JC815 Low VOC Speed Clear	Hardener JH8180 Low VOC Speed Clear Hardener - Standard JH8190 Low VOC Speed Clear Hardener - High Temp	Reducer JR555 Medium JR556 Slow Reducer selection available online SLTB-001 <i>Shop-Line</i> Low VOC Reducer Guide
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Compatible Products


Can be applied over:

JBPX *Shop-Line* Plus 3.5 VOC Acrylic Urethane Basecoat
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 JC815.

Mixing

	Ratios:	JC815	:	JH8180/JH8190	:	JR555/JR556
		4	:	1	:	0.5*
	Pot Life:	2 - 2.5 hours at 70°F (21°C)				
	Additives:	SLV4985	Low VOC Universal Flattening Agent, Refer to ONECHOICE® bulletin OC-7			
		SLV814	Universal Flexibilizer add 10% to RTS quart			
		SLV73	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.

Application



Coats: 2 - 3 medium wet coats

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

Dry Times



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

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

Dry Film Build Per Coat	Applied 4 : 1 : 0.5	1.2 mils
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Properties Continued

RTS Combinations:	JC815 : JH81X0	JC815 : JH81X0 : JR55X	JC815 : JH81X0 : JR55X : SLV814	JC815 /SLV4985: JH81X0
Volume Ratio:	4 : 1	4 : 1 : 0.5	4 : 1 : 0.5 +10%	FC01 - FC05
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating (Flexed)	Clear Coating (Matt)
VOC Actual (g/L)	141	128	121	97-110
VOC Actual (lbs/gal)	1.18	1.07	1.01	0.81-0.92
VOC Regulatory (less water less exempt) (g/L)	242	242-243	235	230-235
VOC Regulatory (less water less exempt) (lbs/gal)	2.02	2.02-2.03	1.96	1.92-1.96
Density (g/L)	1154	1170	1176	1195
Density (lbs/gal)	9.63	9.77	9.81	9.97
Volatiles wt. %	59.9-60.0	64.1-64.2	65.0	67.2-70.2
Water wt. %	0.0	0.0	0.0	0.0
Exempt wt. %	47.6-47.7	53.1-53.2	54.7-54.8	57.9-62.1
Water vol. %	0.0	0.0	0.0	0.0
Exempt vol. %	41.5-41.6	46.9	48.4-48.5	53.0-58.0
Solids vol. %	41.9-42.0	38.1-38.2	37.5-37.6	30.7-34.1
Solids wt. %	40.0-40.1	35.8-35.9	35.0	29.8-32.8
Sq. K. coverage / US Gal at 1 mil 100% transfer efficiency	672-674	611-614	602-603	492-547



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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