

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.

Components

Clearcoat

JC630 4.2 Polyurethane Clearcoat

Hardener

JH6360 4.2 Polyurethane Hardener - Fast 55-70°F (13-21°C)

JH6370 4.2 Polyurethane Hardener - Medium 60-75°F (16-24°C)

JH6380 4.2 Polyurethane Hardener - Slow 70-85°F (21-29°C)

JH6390 4.2 Polyurethane Hardener - Extra Slow 85°F+ (29°C+)

Compatible Products

Can be applied over:

JBP Shop-Line Plus Acrylic Urethane Basecoat

JB Acrylic Basecoat

JAU Acrylic Urethane Direct Gloss

JE Acrylic Enamel / Activated

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 JC630.

Mixing



Ratios:

JC630	:	JH63xx
4	:	1



Pot Life:

1.5 - 2 hours at 70°F (21°C)



Additives:

JX993

Flexible Additive, 10% to RTS quart

JX994

Fisheye Eliminator, 0.5 oz. per RTS quart

SU4985

Universal Matting agent, see ONECHOICE® product bulletin OC-2

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 full wet 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:

Dust:
Tack:
Tape:

With JH6360

5 - 10 minutes
30 - 50 minutes
2 - 4 hours

With JH6370/JH6380/JH6390

10 - 15 minutes
50 - 60 minutes
2 - 4 hours



Force Dry:

15 minutes at 140°F (60°C)

20 minutes at 140°F (60°C)



IR:

12 - 15 minutes

12 - 15 minutes



Polish:

Air Dry

2 - 4 hours at 70°F (21°C)

6 - 8 hours at 70°F (21°C)

Force Dry

90 minutes after cool down

90 minutes after cool down



Recoat:

Air Dry:

8 hours or overnight at 70°F (21°C)

Force Dry:

After force cure and cool down

Must lightly scuff before recoating

Clean Up

Clean spray guns, gun cups, storage pots, etc., thoroughly with JT501 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

VOC

Package	3.54 lbs./ gal (424 g/L)
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Applied Less exempts (4:1)	4.18 lbs./ gal (501 g/L)
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Volume Solids (4:1)	35.0%
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Weight Solids (4:1)	41.6%
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Film Build Per Coat

Applied (4:1)	1.0 - 1.5 mils
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Sq. Ft. coverage at 1 mil

Applied (4:1)	561 sq. ft. / gallon at 100% transfer
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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 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 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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