

# PPG Clear Coat - 2.1 VOC



SC310 PPG 2.1 VOC Clear Coat is a two component clears designed for production shops for use in either cross flow air dry or downdraft force cure spray booths. Products deliver very good gloss, DOI, and buffability.

## Product Listings:

- SC310 - 2.1 VOC Polyurthane High Gloss Clear
- SH311 - 2.1 Fast Hardener
- SH312 - 2.1 Slow Hardener
- SH313 - 2.1 Extra Slow Hardener

## Application Directions

### **Basecoat Instructions:**

Apply basecoat as per manufacturer's instructions. Allow appropriate flash time before applying PPG 2.1 VOC Clear Coat.

### **Mixing Ratio 4:1:**

Mix 4 parts PPG 2.1 VOC Clear Coat with 1 part of the associated 2.1 hardener.  
Pot life is 1½ – 2 hours at 70°F (21°C)

### **Application:**

- Apply 2-3 coats with 5-10 minutes flash between coats.
- Dry film build per coat should be approximately 1.0-1.5 mils.
- HVLP spray gun 8-10 PSI at the air cap
- Conventional spray gun 29-40 PSI at the gun
- For best results, refer to the spray gun manufacturer's recommendations for inlet air pressure.

### **Dry Times:**

#### **Air Dry with PPG 2.1 Fast Hardener**

- Out of Dust: 15-20 minutes
- Tape time: 6-8 hours

#### **Force Dry with PPG 2.1 Fast Hardener**

- 30 minutes at 140°F (60°C)
- Allow 90 minutes to cool down, polish and put into service
- IR: 12-15 minutes

#### **Air Dry with PPG 2.1 Slow or Extra Slow**

- Out of Dust: 20-30 minutes
- Tape time: 6-8 hours

### **Clean Up:**

Use approved general purpose solvent and follow EPA guidelines for proper storage and disposal of solvent borne waste paint

# PPG Clear Coat - National Rule



## **Properties:**

- VOC Applied: (4:1): 2.06 lbs./gal. (247 g/L)
- Total Solids by weight: 18.1%
- Total Solids by volume: 17.8%
- RTS weight solids % range: 30-30.5
- RTS volume % range: 29.2-29.8
- Sq. Ft. Coverage / US Gal (Applied 4:1) 1 mil, 100% transfer efficiency: 460 /gal

See Safety Data Sheet (SDS) and labels for additional information and handling instructions. Emergency medial or spill control information: US 412-434-4515 or Canada 514-645-1320 The contents of this package may have to be blended with other components before the product can be used. Before opening the package, be sure you understand the warning messages on the labels of all components since the mixture will have the hazards of all its parts. Spray equipment must be handled with due care and in accordance with manufacturer's recommendations. Follow label direction for respirator use. Wear eye and skin protection. Observe all applicable precautions.