

PC210

2.1 VOC Production Clear

09192016

DESCRIPTION

PC210 is a premium automotive clear at 2.1 VOC which is required in certain areas requiring low VOC properties. Its fast air dry or fast baking capabilities make it a first choice for production shops with high volume turn over when utilizing a high heat quick bake or in shops that require an air dry quick turn-around. PC210 has outstanding buffing capabilities and a superior gloss for a glamour appearance. Truly a gun finish clear.

COMPONENTS

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|------------------|--|
| • PC210 | Clear coat |
| • HPC065/075/085 | Fast/Medium/Slow – Zero VOC Activators |

MIXING RATIO

Mix four (4) parts PC210 clear with one (1) part selected activator. No reduction recommended.

POT LIFE AT 77° F

2 hours

CLEAN UP

Use **NORTHSTAR** Lacquer Thinner or zero VOC solvents. (Check local regulation)

PHYSICAL DATA

Solids wt. (as mixed)	34%
VOC as mixed	2.1
Color	Water white

DRY / FLASH TIMES

Air Dry at 77° F

Flash between coats	5-10 minutes
Dust free	30 minutes
Tack free	10-15 minutes
Complete air dry @ 77° F	2-4 hours
Sand & Buff	2-4 hours (air dry) @77° F

Force Dry

Flash before force dry
Force dry time
Handle Time
Sand & Buff

0-5 minute flash
20 minutes @ 170° F
30 minutes after cooldown
30 minutes after cooldown at minimum 77° F

COLOR SANDING

Wet sand with 1500 to 2000 wet or dry paper, then buff with appropriate compounds and glazes to achieve a high gloss finish.

GUN SETUPS

Compliant

Gravity Feed
Siphon Feed

1.3 mm – 1.5 mm
1.3 mm – 1.5 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed
Siphon Feed
HVLP at cap

30 – 40 psi
35 – 45 psi
8 – 10 psi

SURFACE PREPARATION

Use **NORTHSTAR** Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.

APPLICATION AT 77° F

- Apply 2 medium wet coats over substrate to desired film thickness
- Allow 5-10 minutes between coats
- Scuff after 24 hours (air dry) or after bake cycle before recoating
- Clean gun after spraying is completed

SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.