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Prime HS Universal ClearCoat - Tech Sheet

PCX - 25

PCX-25 HS Universal ClearCoat is a High Gloss, Fast Drying Clearcoat. PCX-25 is a very user friendly clearcoat under various shop conditions making it a great value for Collision Repair Centers. The remarkable Gloss Level provides continued Gloss Hold-Out achieving an accurate match to OEM Finish. The PCX-25 provides excellent durability and is resistant to environmental conditions such as sunlight and acid rain.



Features and Benefits

High solids
Versatile, choice of 4 hardeners
Air dry or bake
Fits most shop conditions

Reducer

Not Recommended

Compatible Substrates

Apply Basecoat as per manufacture's mixing and application instructions. Allow sufficient flash times before applying PCX - 25 ClearCoat. Inadequate flash time will affect the performance of the clear.

Hardeners

PH - 540 High Solids Hardener Fast Temperature
PH - 550 High Solids Hardener Medium Temperature
PH - 560 High Solids Hardener Slow Temperature
PH - 580 High Solids Hardener Very Slow Temperature

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Preperations



1. Allow final coat of basecoat to dry to touch prior to application of PCX - 25.
2. Use a tack cloth to remove any surface cotaminates that may have settled on basecoat.
3. Mix PCX - 25 and apply.

Mix Ratios



Standard Mix

PCX - 25	:	PH Hardners
4	:	1



Pot Life

4 : 1

8 - 10 hours at 70°F (21°C)

When using PH - 540 Fast Hardener may shorten pot life as much as 50% depending on atmospheric temperatures. Do not use below 65°F.

Additives



Fisheye Eliminators are not recommended, however, when used as suggested, it may help minimize the surface reaction to contamination. The use of this additive is not a substitute for proper cleaning and preparation.



Universal Retarder will slow the initial flash dry allowing slightly more time for the overspray to melt back into the surface when applying in high temperatures, high humidity or large surface areas.



Flex additive can be used to increase flexibility of PCX - 25. This can be helpful during installation and the life of a flexible part.



Accelerator may be helpful to assure proper curing in cold conditions. Excessive film build, loss of gloss, incomplete curing & shrinkage may be the end result when not properly utilized.



Flattenning Base can be used to adjust the gloss level of PCX - 25. For desired gloss levels, it is recommended to do a sprayout to make final determination.

Air Pressure & Gun Setup



HVLP

8-15 psi at the air cap

Compliant

29-45 psi at the gun

Gun Setup

1.3-1.4 mm or equivalent

Approx. Distance

5" - 7"

Inlet PSI

16 - 22 psi

Application



Apply

2-3 single coats

Total Recommended Dry Film : 2.0 - 2.5 mils

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Dry Times



Between Coats

1ST Coat 5 - 10 Minutes
2ND Coat 10 - 15 Minutes



Dry times at 70°C (21°C)

Out of Booth : 30 - 60 Minutes depending on Temperature
Deliver / Polishing : 12 - 24 Hours depending on Temperature.



Force Dry at 140°F (60°C)

Purge Time	15 Minutes
Bake Time	30 Minutes
Deliver / Polishing	After 1 hour coll down.



Polishing

Air Dry : 12 - 24 hours at 70°F (21°C)

Force Dy : After 1 hour cool down.



Recoat and Repair

Recoat : Recoat after force dry and cool down or 12 - 24 hours at 70°F (21°C)
PCX - 25 must be sanded before recoating with primer, color or clear

Repair : Repair when force dried after 1 hour cool down.

Note: All force dry times are quoted for metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature



Equipment Cleaning

Spray guns, gun cups, storage pots, etc., should be cleaned thoroughly after each use with any appropriate general purpose solvent.

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Technical Information:

Clear:	PCX - 25
Hardeners:	PH - 540, PH - 550, PH - 560, PH - 580
Mixing Ratio:	4:1
Viscosity # 2 Zahn (RTS)	17 - 19 Seconds
Weight Solids (RTS):	38 %
Volume Solids (RTS):	31 %
Film Build:	0.9 - 1.1 mils per full coat
Coverage:	490 sq. ft. per gallon @ 1 dry mil

V.O.C. as Delivered:	Regulatory V.O.C. lbs/gal	Regulatory V.O.C. g/l	Material V.O.C. lbs/gal	Material V.O.C. g/l
PCX - 25	4.5	546	3.4	403
V.O.C. (RTS):				
PCX - 25 w/PH-540	4.4	532.4	3.5	423.5
PCX - 25 w/PH-550	4.4	532.4	3.5	423.5
PCX - 25 w/PH-560	4.3	520.3	3.4	411.4
PCX - 25 w/PH-580	4.3	520.3	3.4	411.4

see SDS for this product

Disposal/Safety:

FOR INDUSTRY USE ONLY

Read SDS Before Use

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions.

The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.