PRIME™

Prime Premier Gloss ClearCoat - Tech Sheet

PCX - 45

PCX-45 Premier Gloss ClearCoat is a High Gloss clear with a wide range of refinishing applications. PCX - 45 is a very user friendly clearcoat under various shop conditions making it a great value for Collision Repair Centers. PCX - 45 ClearCoat is ideal for spot and overall refinish jobs

Features and Benefits

High solids
Versatile choice of 3 hardeners
Air dry or bake
Fits most shop conditions

Compatiable Substrates

Apply Basecoat as per manufacture's mixing and application instructions. Allow sufficient flash times before applying PCX - 45 ClearCoat. Inadequate flasf time will affect the performance of the clear.

Reducer

Not Recommended

Hardeners

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 - 45.
2. Use a tack cloth to remove any surface cotaminates that may have settled on basecoat.
3. Mix PCX - 45 and apply.

Mix Ratios

Standard Mix

PCX - 45	:	PH Hardeners
4	:	1

Pot Life 4 : 1   1 - 3 hours at 70°F (21°C)

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 - 45. 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 utilizied.

Flatenning Base can be used to adjust the gloss level of PCX - 45. 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 10 - 15 Minutes
2ND Coat 15 - 20 Minutes

Dry times at 70°C (21°C)

Out of Booth : 20 - 30 Minutes depending on Temperature
Deliver / Polishing : 6 Hours or Overnight depending on Temperature.

Force Dry at 130°F (60°C)

Purge Time	30 - 45 Minutes
Bake TIme	45 Minutes
Deliver / Polishing	After 1 hour coll down.

Polishing

Air Dry :	6 - 8 plus 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 16 - 24 hours at 70°F (21°C)

PCX - 45 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 temperatur

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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Techincal Information:

Clear:	PCX - 45
Hardeners:	PH - 540, PH - 550, PH - 560, PH - 580
Mixing Ratio:	4:1
Viscosity # 2 Zahn (RTS)	18 - 21 Seconds
Weight Solids (RTS):	42 - 45 %
Volume Solids (RTS):	26 %
Film Build:	1.1 - 1.5 mils per full coat
Coverage:	590 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 - 45	4.8	580.8	4.5	544.5
V.O.C. (RTS):				
PCX - 45 w/PH-550	4.2	508.2	3.2	387.2
PCX - 45 w/PH-560	4.2	508.2	3.2	387.2
PCX - 45 w/PH-580	4.2	508.2	3.2	387.2

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.

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