

## 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.

### JC630 4.2 Polyurethane Clearcoat

#### Clear

JC630 4.2 Polyurethane Clearcoat

#### Hardener

JH6360 4.2 Polyurethane Hardener-Fast  
 JH6370 4.2 Polyurethane Hardener-Medium  
 JH6380 4.2 Polyurethane Hardener-Slow  
 JH6390 4.2 Polyurethane Hardener-Extra Slow

### Compatible Substrates

Shop-Line Refinish Basecoats

### Preparation

Allow basecoat color a minimum of 30 minutes and a maximum of 24 hours before clearing. After 24 hours the basecoat should be lightly sanded before applying JC630.

### Mixing

#### Ratios



JC630 : JH63xx  
 4 : 1



Pot life is 1.5 - 2 hours at 70°F (21°C)

#### Additives

JX993 Flex Additive, 10% to RTS quart.  
 JX994 Fisheye Eliminator, ½ oz. per RTS quart.  
 SU4985 Universal Matting Agent, see ONECHOICE® Bulletin OC-2.

### Application

#### Coats



2 - 3 coats  
 For optimum performance, final recommended film build is 2.0 - 2.5 mils

#### Air pressure



HVLP 10 psi at the air cap  
 Conventional 50 - 60 psi at the gun

#### Gun setup

1.3 - 1.5 mm or equivalent

### Dry Times

#### Between coats



5 - 10 minutes at 70°F (21°C)

#### With JH6360 Hardener

Dust: 5 - 10 minutes  
 Tack: 30 - 50 minutes  
 Tape / Polish: 2 - 4 hours  
 Force dry: 15 minutes at 140°F (60°C)



#### With JH6370, JH6380, JH6390

Dust: 10 - 15 minutes  
 Tack: 50 - 60 minutes  
 Tape / Polish: 2 - 4 hours / 6 - 8 hours



#### Force dry:

20 minutes at 140°F (60°C), allow a cool down of 90 minutes to polish or to put into service.

**Recoat:** After force cure and cool down or 8 hours, overnight at 70°F (21°C) Must be lightly scuffed before recoating.

**IR (Infrared)** 12 - 15 minutes

### Clean Up

Clean spray guns, gun cups, storage pots thoroughly with JT501 General Purpose Solvent or other 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 gm/l)  
 Applied Less exempts 4:1 4.18 lbs /gal (501gm/l)

#### Solids by weight

34.7%

#### Dry Film build per coat

Applied (4:1) 1.0 - 1.5 mils

#### Square foot coverage at 1 mil

Applied (4:1) 560 sq. ft. / gal. @ 100% transfer

**Limitations**

*ShopLine* 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 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.

**Material Safety Data Sheet**

Material Data Safety Sheets for the PPG products mentioned in this publication are available through your PPG *Shop-Line* 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* Distributor for the most up-to-date information.

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