



PCC


ACRYLIC ENAMEL



85 / 86 Series — 5.0 VOC / 3.5 VOC

MIXING

Non-catalyzed:

 4 Mixed Color +  up to 1 Exempt Reducer PCR10/PCR20

Catalyzed:  8 Mixed Color

+  up to 2 Exempt Reducer PCR10/PCR20 +  1 Hardener PIH50

APPLICATION

- Adjust air pressure at the gun to 55 – 65 psi Conventional Pressure Feed (adjust pot pressure to 8 – 15 fluid ounces per minute delivery).
- For Conventional Pressure Feed, apply 2 medium coats at a gun distance of 8 – 10 inches. Spray to hiding.
- For HVLP, apply 1 full wet coat with 50% overlap, applying the second coat in a cross-coat method. Dry film thickness is 2.0 – 2.5 mils.

DRYING SCHEDULE

Dry times are based on the dry film thickness of 2.0 – 2.5 mils; thicker films will extend drying times.

Air Dry Times @ 75°F and 50% Relative Humidity:

	Unaccelerated	Accelerated (up to 3 oz. PCC440 per sprayable gal.)
Dust Free	2 hours	1 hour
Tack Free	3 hours	2 hours
Tape Free	4 hours	3 hours
Nib Sand	8 hours	4 hours

Forced Dry Times:

Temperature	Unaccelerated Tape Free	Tape Free (3 oz. PCC440 per sprayable gal.)
140°F	80 – 120 minutes	60 minutes
160°F	60 – 80 minutes	45 minutes
180°F	45 – 60 minutes	30 minutes

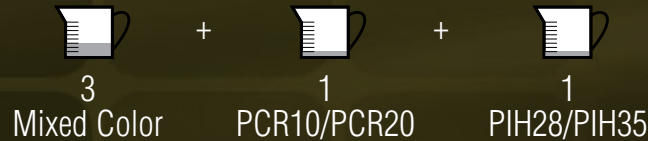
For more information, see the Product Data Sheet or call 1-800-526-6704.

PCC

ACRYLIC URETHANE

87 Series — 2.8 VOC / 3.5 VOC

MIXING



To speed cure times, add up to 3 oz. of PCA200 Accelerator.

APPLICATION

- Adjust air pressure at the gun to 55 – 65 psi Conventional Pressure Feed (adjust pot pressure to 8 – 15 fluid ounces per minute delivery).
- For Conventional Pressure Feed, apply 2 medium coats at a gun distance of 8 – 10 inches. Spray to hiding.
- For HVLP, apply 1 full wet coat with 50% overlap, applying the second coat in a cross-coat method. Dry film thickness is 2.0 – 2.5 mils.

DRYING SCHEDULE

Dry times are based on the dry film thickness of 2.0 – 2.5 mils; thicker films will extend drying times.

Air Dry Times @ 75°F and 50% Relative Humidity:

	Unaccelerated	Accelerated (1 oz. PCA200 per sprayable gal.)	Accelerated (3 oz. PCA200 per sprayable gal.)
Dust Free	1–2 hours	1 hour	40 minutes
Tack Free	4–5 hours	3 hours	2 hours
Tape Free	12 hours	4 hours	3 hours
Nib Sand	12+ hours	5 hours	4 hours

Forced Dry Times:

Temperature	Unaccelerated Tape Free	Tape Free (1 oz. PCA200 per sprayable gal.)	Tape Free (2 oz. PCA200 per sprayable gal.)
140°F	80–120 minutes	60 minutes	30 minutes
160°F	60–80 minutes	45 minutes	20 minutes
180°F	45–60 minutes	30 minutes	20 minutes

For more information, see the Product Data Sheet or call 1-800-526-6704.