

P-C-15

Clear coat, air drying



A brand of BASF –
We create chemistry

Application:	ProClass - Clear coat especially for 90 Line basecoat.
Key Features:	Highly efficient clear coat - air drying. For a wide range of applications.
Remarks:	<p>Best results will be achieved using P-C-15 clear coat, air drying at the 20-80% humidity range and 15-35° celsius.</p> <p>5% of 93-IC 330 additive for basecoat must be added to all waterborne basecoat layers applied under the P-C-15 clear coat, air drying, including basecoat grey shades, 90-M 50 and all stages of a 3-stage application.</p> <p>93-IC 330 is unsuitable for use in mixing formulas which contain mixing base concentrates 80-M. Basecoat should be thoroughly dried before overcoating with P-C-15.</p>

Handling



Basecoat preparation:

- 1st step: Weigh the colour mixing formula as normal, stirring well when this is completed.
- 2nd step: Add 5% of 93-IC 330 additive for basecoat and then stir immediately. (Potlife max. 30 min)
- 3rd step: Dilute as normal using 93-E 3 adjusting base (or 93-E 3 slow version) and stir immediately.



Basecoat application:

- Apply using standard 90 Line application.

Safety advice:

The products are suitable for professional use only.

It cannot be ruled out that this product contains particles < 0.1 µm.

2004/42/IIIB(d)(420)419: The EU limit value for this product (product category: IIB.d) in ready to use form is max 420 g/litre of VOC. The VOC content of this product is 419 g/litres.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at www.glasurit.com or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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
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		1:1+20 %	
		Clear coat preparation	
	Mixing Ratio	100 % by volume	P-C-15 Clear coat, air drying
	Hardener	100 % by volume	P-H-425 ProClass Hardener
	Reducer	20 % by volume	P-R-125, -R-115 ProClass Reducer
	Spray viscosity at 20°C	DIN 4: 12-15 s	
	Potlife at 20°C	25 min	

Application:



Compliant gravity-feed spray gun



HVLP spray gun

Application pressure

2 bar

Nozzle pressure

0.7 bar

Nozzle size

1.2-1.4

1.3

Number of spray coats

 $\frac{1}{2} + 1$

Film thickness

40-50 µm

Application Remark

No flash off between spray coats.

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Drying at 20°C

Dust free: app. 10 min*
Handling time: app. 25 min*
Drying time:
app. 45 min: P-R-115*
app. 60 min: P-R-125*
* (at 20°C 55% RH, depending on
humidity)

Drying at 40°C

App. 10 min

Remark

P-R-115 is optimised for use on multiple vertical panels.

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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