

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:** Best results will be achieved using P-C-15 Clear coat, air drying at the 20-80% humidity range and 15-35° Celsius.
5% of 93-IC 330 Additive for basecoat must be added to all 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. 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.
- 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.

		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 ProClass Reducer		
	Spray viscosity at 20°C	DIN 4:	12-15 s	Potlife at 20°C	25 min

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.



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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
Application pressure	bar	2
Nozzle pressure	bar	0.7
Nozzle size		1.2-1.4
Number of spray coats		1/2 + 1
Film thickness	µm	40-50
Application Remark	No flash off between spray coats	



Drying at 20°C

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

Drying at 40°C

25-30 min

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