



## GENERAL INFORMATION

U.S. Chemical & Plastics' 50 Production Urethane Clearcoat is a versatile high performance 2-coat urethane clearcoat formulated to maximize vehicle output. Use for spot, panel and multi-panel refinishing. USC's 50 Production Urethane Clearcoat delivers excellent flow, leveling and UV resistance with high gloss and DOI.



### 1. COMPONENTS

- 50 Production Urethane Clearcoat 4.2 VOC
- 52 Production Urethane Clearcoat Fast Activator
- 53 Production Urethane Clearcoat Medium Activator
- 54 Production Urethane Clearcoat Slow Activator



### 2. MIX RATIO

- 4 Parts USC 50 Production Urethane Clearcoat 4.2 VOC
  - 1 Part USC 52 Fast, 53 Medium or 54 Slow Activator
- \*Combine components by volume. Mix thoroughly and strain before using.



### 3. POT LIFE

- > 5 Hours (@ 78°F / 25.6°C)



### 4. SURFACE PREPARATION

- Make repairs as needed. Mask vehicle to protect from overspray. Apply basecoat color to repair area and allow to dry according to paint manufacturer's recommendations.



### 5. APPLICATION

- 2 medium wet coats



### 6. FLASH / DRY TIMES (@ 72°F / 22°C)

Flash between coats	8-10 minutes
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#### Dry Time to Buff

After last coat	3-4 hours to lightly polish when using 52 Fast Activator
Bake	20 minutes @ 140° F / 60° C

\*NOTE: Excessive film build and cool temperatures will extend dry times.



### 7. SPRAY GUN SET UP

Reduced Pressure	1.3mm - 1.5mm
HVLP	1.3mm - 1.4mm

#### AIR PRESSURES

- Refer to spray gun manufacturer's recommendations for regulatory compliance



### 8. TECHNICAL INFORMATION

VOC	4.2 lbs./gallon
Weight Solids	35.0%
Volume Solids	28.4%
Theoretical Coverage	455 sq. ft. @ 1.0 mil
Recommended Dried Film Thickness	2.0 mils

\*NOTE: US Regulations allow for the use of exempt compounds for VOC calculations.



### 9. HEALTH & SAFETY

- Read all warnings, first aid and safety for all components before using. Keep out of reach of children and animals. Wear a properly fitting NIOSH/MSHA approved respirator. Select positive pressure supplied respirator (TC-19C or equivalent) for isocyanates. Follow the respirator manufacturer's directions for use. Protect hands with impervious rubber gloves. Wear face, skin and eye protection. USC products are for industrial use by professional, trained painters.

Confirm compliance with national, state, and local air quality rules before use.