PPG QUICKLINE™

QC-9000

LOW VOC SPEED CLEAR

Product Data Sheet



PPG QUICKLINE® QC-9000 Low VOC Speed Clear is a fast drying two-component urethane clearcoat designed to enhance productivity in air dry and low bake situations for today's automotive collision centers. QC-9000 offers ease of application, outstanding flow and leveling, and short bake cycle. It is extremely versatile and can be used for multi-panel and overall finishing.

Compatible Products

Apply over:

- QB *PPG Quickline* Basecoat

Substrate Preparation

- Wash all surfaces to be painted with car wash soap and water to remove water soluble contaminants, then apply the appropriate PPG ONECHOICE®.surface cleaner. Ensure that the substrate is thoroughly cleaned and dried before and after application work.
- Abrade (wet) with U.S. 500-600 / European P800-P1200 grade paper or abrade (dry) with U.S. 400-500 / European P600-P800 grade paper.
- Wash off residue and dry thoroughly before re-cleaning with appropriate *OneChoice* surface cleaner. The use of a *OneChoice* tack rag is recommended.
- For plastic substrates, refer to product bulletin for *OneChoice* Plastic Adhesion Promoter.

Application Guide

Mix ratio:

Standard

QC-9000 Low VOC Speed Clearcoat	4 parts
QH-9x00 Low VOC Speed Clear Hardener	1 part

Accelerated

QC-9000 Low VOC Speed Clearcoat	4 parts
QH-9x00 Low VOC Speed Hardener	1 part
SL93LV Low VOC Accelerator	2%

Hardeners:

QH-9100 Low VOC Speed Hardener - Fast	60-75ºF (16-24ºC)
QH-9200 Low VOC Speed Hardener - Medium	75-95ºF (24-35ºC)
QH-9300 Low VOC Speed Hardener - Slow	95ºF (35ºC) and above
QH-9400 Low VOC Speed Hardener - Extra Slow	98ºF (37ºC) and above

Pot Life:

- 2½-3 hours at 70ºF (21ºC) Standard mix (4:1)

2-2½ hours at 70ºF (21ºC) Accelerated mix (4:1:2%)

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Additives:

SL93LV Low VOC Accelerator	See above for ratio
SLV814 Universal Flexiblizer LV	3 : 1 : ½ (SLV814)
SLV814 with SL93LV	3 : 1 : ½ (SLV814 : 2% (SL93LV
SLV4985 Universal Flattening Agent	See OC-7 for mix ratios

Spray Gun Set up and Pressure

Fluid tip	1.3-1.4 mm
HVLP at the cap	8-10 psi
Compliant at the spray gun	29 psi

For best overall results, refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.

Application:

- 2 wet coats with 5-7 minutes between coats
- 2.0-2.4 mils total recommended dry film build

Flash Off

Between coats, 5-7 minutes at 70°F (21°C)

Drying Times

Standard

Dust-free	30-40 minutes at 70°F (21°C)
Tape time	12-16 hours at 70°F (21°C)
Air dry	4-6 hours at 70°F (21°C)
Force Dry	
Purge	None
QH-9100	15 minutes at 140°F (60°C)
QH-9200	20 minutes at 140°F (60°C)
QH-9300	20 minutes at 140ºF (60ºC)
QH-9400	20 minutes at 140°F(60°C)
With SL93LV	10 minutes at 140ºF (60ºC)

Accelerated

Dust-free	15-20 minutes at 70°F (21°C)
Tape time	6-8 hours at 70°F (21°C)
Air dry	2½-3 hours at 70°F (21°C)
Force Dry	10 minutes at 140ºF (60ºC)

IR (Infrared)

Medium Wave	5 minutes half bake, 10 minutes full
Short Wave	5 minutes

Recoating

- QC-9000 Low VOC Speed Clearcoat may be recoated after 4-6 hours air dry or force dry. QC-9000 must be cleaned, abraded and re-cleaned before recoating with primer, color or clear.

Note: all force dry times are quoted for metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature

Polishing

Air Dry: 4-6 hours at 70° F (21° C) 1½-2 hours at 70° F (21° C) with SL93LV

Force Dry: After cool down

QC-9000 can be lightly sanded with 1500-2000 grit sandpaper and compounded. Use a foam pad with a minor cutting compound to remove any minor imperfections.

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Technical Data

RTS Information	QC-9000 : QH-9x00	QC-9000 :QH-9x00 : SL93LV	QC-9000 : QH-9x00 : SLV814
Mixing Ratio	4: 1	4: 1: 2%	3: 1: ½
Coating Category	Clear Coating	Accelerated Clear Coating	Flexed Clear Coating
VOC actual (g/L)	129	127	116
VOC actual (lbs./U.S. gal.)	1.08	1.06	0.97
VOC regulatory (g/L) (less water less exempt)	244	243	246
VOC regulatory (lbs./U.S. gal.) (less water less exempt)	2.04	2.03	1.83
Density (g/L)	1100	1105	1118
Density (lbs./U.S. gal.)	9.18	9.22	9.33
Solids volume %	46.7	47.5	47.1
Solids weight %	39.2	38.3	39.7
Coverage at 1 mil at 100% transfer efficiency (sq. ft.)	613	602	634

Performance Guidelines

- Store in a cool dry place away from heat.

Health and Safety

See Safety Data Sheet and Labels for additional safety information and handling instructions.

- 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 and SDS of all the components, since the mixture will have the
- hazards of all its parts. Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained in the safe use of respirators per company and regulatory requirements.
- Store waterborne and solvent borne waste separately. A competent agent with appropriate certification must handle all hazardous waste. Waste must be disposed of in accordance with all federal, state, provincial and local laws and regulations.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

Emergency Medical or Spill Control Information: (412) 434-4515; In Canada (514) 645-1320

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