

## MC770 2.1 VOC High Gloss Urethane Clear

### Background

MC770 is a two component 2.1 VOC high gloss urethane clear designed for production shops for use in either cross flow air dry or downdraft force cure spray booths. MC770 delivers very good gloss, DOI and buffability .

### MC770 2.1 VOC High Gloss Urethane Clear

#### Clear

MC770 2.1 VOC Polyurethane High Gloss Clear

#### Hardener

MH777 Fast Compliant Clear Hardener

MH778 Slow Compliant Clear Hardener

MH779 Extra Slow Compliant Clear Hardener

### Compatible Substrates

MBC / MBP / MBX Basecoats

MTK Acrylic Urethane, MTX 2.8 VOC Single Stage

MAE/MH101/MH202 Catalyzed Acrylic Enamel

### Preparation

Allow basecoat color a minimum of 30 minutes and a maximum of 24 hours before clearing. After 24 hours the basecoat should be lightly sanded and reapplied before applying MC770.

### Mixing

#### Ratios



MC770      MH77X  
4            :      1



Pot life is 1.5 - 2 hours at 70°F (21°C)

**Additives**    SLV814 ( see page 2 )  
                      SLV73    0.5 oz to RTS quart

### Clean Up

Clean spray guns, gun cups, storage pots thoroughly with General Purpose Solvent or other appropriate clean up solvent after each use. Follow EPA guidelines for proper storage and disposal of solvent-borne waste paint.

### Application

#### Coats



2 - 3 coats

#### Air pressure



HVLP                            8 - 10 psi at the air cap  
Conventional                50 - 60 psi at the gun

#### Gun setup

1.3 - 1.5 mm or equivalent

### Dry Times

#### Between coats



5 - 10 minutes at 70°F (21°C)

#### Air dry With MH777



Dust:    15 -20 minutes  
Tape:    6-8 hours

#### Air dry With MH778 / MH779



Dust:    20 - 30 minutes  
Tape:    6 - 8 hours

Polish:    6-8 hours at 70°F (21°C) to polish or  
              put into service

Recoat:    8 hours or overnight at 70°F (21°C)

#### Force dry

30 minutes at 140°F (60°C), allow a cool down  
of 90 minutes to polish, put into service or  
recoat.

#### IR (Infrared)

12 - 15 minutes

### Properties

#### Film build per coat

Applied (4:1)                            1.2 mils

## Properties

<b>RTS Combinations:</b>	<b>MC770 : MH77X</b>	<b>MC770 : MH77X : SLV814</b>	<b>MC770 : SLV4985 : MH77X</b>	<b>MC770 : SLV4985 : MH77X</b>	<b>MC770 : SLV4985 : MH77X</b>
<b>Volume Ratio:</b>	4 : 1	4 : 1 : ½	4 : 3 : 1	4 : 2 : 1	4 : 1 : 1
<b>Applicable Use Category</b>	Clear Ctg	Clear Ctg (Flexed)	Clear Ctg (Flat)	Clear Ctg (Eggshell)	Clear Ctg (Semi-gloss)
<b>VOC Actual (g/L)</b>	100	95	86	90	94
<b>VOC Actual (lbs/gal)</b>	0.84	0.79	0.72	0.75	0.79
<b>VOC Regulatory (less water less exempt) (g/L)</b>	247	237	246	247	247
<b>VOC Regulatory (less water less exempt) (lbs/gal)</b>	2.06	1.98	2.05	2.06	2.06
<b>Density (g/L)</b>	1111	1123	1155	1144	1130
<b>Density (lbs/gal)</b>	9.27	9.37	9.64	9.55	9.43
<b>Volatiles wt. %</b>	70.5	70.7	74.3	73.4	72.2
<b>Water wt. %</b>	0.0	0.0	0.0	0.0	0.0
<b>Exempt wt. %</b>	61.5	62.3	66.7	65.5	63.8
<b>Water vol. %</b>	0.0	0.0	0.0	0.0	0.0
<b>Exempt vol. %</b>	59.7	60.1	64.7	63.5	61.9
<b>Solids vol%</b>	28.7	29.0	25.3	26.1	27.2
<b>Sq Ft. Coverage/ US gal. Imil @ 100% transfer Efficiency</b>	460	465	405	418	436

### Precautionary Information:

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 of all components, since the mixture will have the hazards of all its parts. Spray equipment must be handled with due care and in accordance with manufacturer's recommendations. Follow label directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

### Medical Response:

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320.

### Material Safety Data Sheet:

Material Data Safety Sheets for the PPG products mentioned in this publication are available through your PPG Distributor. To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries is constantly improving its coating and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your Distributor for the most up-to-date information.