

JE Acrylic Enamel / Activated

Background

SHOP-LINE® JE is a fast drying single stage acrylic enamel designed for today's economy minded collision centers.

Components

| Color | Hardener | Reducer |
|-------------------------------|--|--|
| JE Acrylic Enamel / Activated | JH6001 Acrylic Enamel Hardener JH6002 High Gloss Hardener | JR505/JR4070 Fast 55-65°F (13-18°C) JR506/JR4080 Medium 65-75°F (18-24°C) JR507/JR4090 Slow 75-85°F (24-29°C) JR508 Very Slow 85-95°F (29-35°C) |

Compatible Products

Can be applied over:

Cleaned, cured and sanded OEM and refinish coatings
JP37x Epoxy Primers
JP301 Plastic Adhesion Promoter
JP233 1K Acrylic Primer
JP202 2K Primer Surfacer
JP285 2K Urethane Surfacer
JP315 1K Acrylic Sealer
JP33x 2K Urethane Sealers

If desired, a clearcoat can be applied to provide additional long term durability.

Can be topcoated with:

JC60 Universal Clearcoat
JC620 Acrylic Urethane Clearcoat
JC630 4.2 Polyurethane Clearcoat
JC660 4.2 VOC Speed Clear
JC661 Hi-Gloss Multi-Panel Clear
JC6700 HS European Clearcoat
JC6800 HS European Speed Clear

Preparation

Surface Cleaning:

JX101 Wax and Grease Remover
JX992 Plastic Cleaner
SXA330 Wax and Grease Remover
SWX350 (H₂O-SO-CLEAN™)

Sanding

400 grit (machine or dry hand) or 500 grit (wet) on old finishes and primer surfacers

Mixing



Ratios

| JE | : | JR50x / JR40xx | : | JH600x |
|----|---|----------------|---|--------|
| 8 | : | 1 | : | 1 |



Pot Life

8 hours at 70°F (21°C)

Tinting

JE may be tinted up to 10% with *Shop-Line* mixing bases and equal parts J93 enamel mixing clear.



Additives:

JR509 Retarder, add 10% to RTS*
JX993 Flexible Additive, 10% to RTS quart
JX994 Fisheye Eliminator, 0.5 oz. to RTS quart
JX995 Accelerator, 1 oz. to RTS quart
JX996 Accelerator, 1 oz. to RTS quart

**Addition of retarder may result in a non-compliant ready to spray VOC. Verify local regulations prior to use.*

Application



Coats: 3 coats or until proper color is achieved

Air Pressure and Gun Setup



HVLP: 8 - 10 psi at the air cap
Conventional: 45 - 55 psi at the gun
Compliant: 29 - 40 psi at the gun

Gun Setup: 1.3 - 1.6 mm or equivalent

Note: For best overall results, refer to spraygun manufacturer's recommendations for inlet air pressures.

Dry Times



Between Coats: 5 - 10 minutes at 70°F (21°C)



Air Dry:
Dust: 30 minutes
Tack: 1 - 2 hours
Tape: 4 hours



Force Dry: 30 minutes at 140°F (60°C)



IR: 10 - 15 minutes



Polish:
Air Dry:
16 hours at 70°F (21°C) to polish and put into service.
Force Dry:
8 hours to polish and put into service.



Recoat:
Air Dry:
24 hours at 70°F (21°C)
Force Dry:
24 hours after force dry
Light sanding required after 3 days

Clean Up

Clean spray guns, gun cups, storage pots, etc., thoroughly with JR reducers, JT501 General Purpose Solvent or another appropriate clean up solvent after each use.

Follow EPA guidelines for proper storage and disposal of solvent-borne waste paint.

Properties

VOC

Package 4.50 lbs./ gal (539 g/L)

Applied Less exempts (8:1:1) 5.00 lbs./ gal (599 g/L)

Film Build Per Coat

Applied (8:1:1) 1.0 - 1.4

Sq. Ft. coverage at 1 mil

Applied (8:1:1) 560 - 570 sq. ft. /US gallon at 100% transfer



Limitations

Shop-Line products should not be combined with components of other product lines.

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 of 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

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

Material Data Safety Sheets for the PPG products mentioned in this publication are available through your PPG *Shop-Line* brand 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 *Shop-Line* brand distributor or visit www.ppgrefinish.com for the most up-to-date information.

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