

MC730 2.1 VOC Production Clear

Background

OMNI® MC730 2.1 VOC Production Clear is a value-minded clear coat designed for exceptional performance and throughput on spot and panel repairs. MC730 can be air dried or short baked offering speed and versatility. A choice of three hardeners and two reducers depending on job size and/or temperature requirements are also available.

Components

Clear	Hardener	Reducer
MC730 2.1 VOC Production Clear	MH737 Low Temp 65-75°F (18-24°C) MH738 Medium Temp 75-90°F (24-32°C) MH739 High Temp 90°F (32°C) and above	MR295 Medium 65-75°F (18-24°C) MR296 Slow 75-90°F (24-32°C)

Compatible Products

Can be applied over:

MBPX Omni Plus 3.5 VOC Acrylic Urethane Basecoat
MBX 3.5 VOC Acrylic Basecoat
MTX 2.8 Single Stage
MLX 2.8 VOC Acrylic Enamel

Preparation

Allow basecoat color to dry 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 MC730

Mixing



Ratios:

MC730	:	MH73X	:	(Optional) MR295/MR296
4	:	1	:	0.5*

**Up to 0.5 part of reducer may be added if needed*



Pot Life:

1.5 hours at 70°F (21°C)



Additives:

SLV4985	Low VOC Universal Flattening Agent, Refer to ONECHOICE® product bulletin OC-7.
SLV814	Universal Flexiblizer add 10% to RTS quart
SLV73	Fisheye Eliminator add 0.5 oz. RTS quart
MR297	Retarder - up to 10% of total reducer can be added
SL93LV	Accelerator add 2% to RTS quart

Air Pressure and Gun Setup



HVLP: 8 - 10 psi at the air cap

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.

Application



Coats: 2 - 3 medium wet coats

For optimum performance, final recommended film build is 2.0 – 2.5 mils dry.

Dry Times



Between Coats: 2 - 5 minutes at 70°F (21°C)



Air Dry:

	With MH737	With MH738	With MH739
Dust:	20 - 35 minutes	25 - 40 minutes	30 - 45 minutes
Tack:	70 - 90 minutes	80 - 100 minutes	80 - 100 minutes
Tape:	3 - 4 hours	3 - 4 hours	3 - 4 hours



Force Dry: 20 minutes at 120°F (49°C)



IR: 10 - 15 minutes, full power



Polish:

Air Dry:
3 - 4 hours at 70°F (21°C)
Force Dry:
After cool down



Recoat:

Air Dry:
4-6 hours or overnight at 70°F (21°C)
Force Dry:
After force cure and cool down

Must lightly scuff before recoating

Clean Up

Clean spray guns, gun cups, storage pots thoroughly with MR Reducer or MS151 0.21 VOC 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.

Properties

RTS Combinations:	MC730 : MH73x : MR29x	MC730 : MH73x : MR29x : SL93LV	MC730 : MH73x : MR29x : SLV814
Volume Ratio:	4 : 1 : 0.5	4 : 1 : 0.5 + 2%	4 : 1 : 0.5 + 10%
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating
VOC Actual (g/L)	143-157	140	134
VOC Actual (lbs./gal)	1.19-1.31	1.17	1.12
VOC Regulatory (less water less exempt) (g/L)	249	248	249
VOC Regulatory (less water less exempt) (lbs./gal)	2.08	2.07	2.01
Density (g/L)	1160-1177	1179	1182
Density (lbs./gal)	9.68-9.82	9.84	9.86
Volatiles wt. %	55.8-60.4	61.3	61.6
Water wt. %	0.0-0.1	0.0	0.0
Exempt wt. %	42.3-48.3	49.4	50.3
Water vol. %	0.0	0.0	0.0
Exempt vol. %	36.8-42.3	43.7	44.5
Solids vol. %	41.3-45.5	40.6	40.4
Solids weight %	39.6-44.2	38.7	38.4
Sq. Ft. Coverage 1 mil at 100% transfer	662-730	651	648

Limitations

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

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

