

## MC270 4.2 VOC Production Clear

### Background

OMNI™ MC270 is a two component 4.2 VOC production clearcoat that is ideal for value conscious body shops who require quick air dry performance with good buffability or force dried shorter bake times. MC270 can be used with a choice of four hardeners depending on job size and/or temperature requirements.

### Components

#### Clearcoat

MC270 4.2 VOC Production Clear

#### Hardener

MH276 Fast Hardener Fast 55-70°F (13-21°C)  
MH277 Medium Hardener Medium 60-75°F (16-24°C)  
MH278 Slow Hardener Slow 70-85°F (21-29°C)  
MH279 Extra Slow Hardener 85°F+ (29°C+)

### Compatible Products

#### Can be applied over:

MBP *Omni* Plus Acrylic Urethane Basecoat  
MBC Acrylic Basecoat  
MTK Acrylic Urethane  
MAE Acrylic Enamel with Hardener

### 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 MC270.

### Mixing



#### Ratios:

<b>MC270</b>	:	<b>MH27X</b>
<b>4</b>	:	<b>1</b>



#### Pot Life:

1.5 - 2 hours at 70°F (21°C)



#### Additives:

MX193 Flexible Additive	10% to RTS quart
MX194 Fisheye Eliminator	.5 oz. to RTS quart
SU4985 Universal Matting Agent, See ONECHOICE® product bulletin OC-2	
M148 Flattening Agent	Flat 51 oz. to RTS gal.
	Eggshell 45 oz. to RTS gal.
	Semi-gloss 42 oz. to RTS gal.

### 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.

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## Application

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**Coats:** Apply 2 - 3 full wet coats

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

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## Dry Times

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



**Air Dry:**

	<b>With MH276</b>	<b>With MH277, MH278, MH279</b>
Dust:	5 - 10 minutes	10 - 15 minutes
Tack:	30 - 50 minutes	50 - 60 minutes
Tape:	2 - 4 hours	2 - 4 hours



**Force Dry:** 15 minutes at 140°F (60°C)

20 minutes at 140°F (60°C)



**IR:** 12 - 15 minutes

12 - 15 minutes



**Polish:**

**Air Dry**  
2 - 4 hours at 70°F (21°C)  
**Force Dry**  
90 minutes after cool down

6 - 8 hours at 70°F (21°C)  
90 minutes after cool down



**Recoat:**

**Air Dry:**  
8 hours or overnight at 70°F (21°C)  
**Force Dry:**  
After force cure and cool down  
Must lightly scuff before recoating

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## Clean Up

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Clean spray guns, gun cups, storage pots, etc., thoroughly with MR Reducer, MS251 Multi Purpose Solvent or another appropriate clean up solvent after each use.

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

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## Properties

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### VOC

Package	3.54 lbs./ gal (424 g/L)
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Applied Less exempts (4:1)	4.18 lbs./ gal (501 g/L)
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Volume Solids (4:1)	35.0%
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Weight Solids (4:1)	41.6%
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### Film Build Per Coat

Applied (4:1)	1.0 - 1.5 mils
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### Sq. Ft. coverage at 1 mil

Applied (4:1)	561 sq. ft. / gallon at 100% transfer
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**Limitations**

*Omni* products should not be combined with components of other product lines.

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**Precautionary Information:**

The contents of this package may have to be blended with other components before the product can be use. 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.

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**Medical Response:**

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

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**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 *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](http://www.ppgrefinish.com) for the most up-to-date information.

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