

MC250 Urethane Clearcoat

Background

OMNI® MC250 is a two component clearcoat that is ideal for value conscious body shops who require quick air dry performance with good buffability. MC250 can be used with a choice of three hardeners depending on job size and/or temperature requirements.

Components

Clearcoat

MC250 Urethane Clearcoat

Hardener

MH255 Spot Clear Hardener 55-65°F (13-18°C)

MH256 Overall Clear Hardener 75-85°F (24-29°C)

MH257 High Temperature Hardener 85-95°F (29-35°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 MC250.

Mixing



Ratios

| MC250 | : | MH25X |
|-------|---|-------|
| 4 | : | 1 |



Pot Life:

1.5 - 2 hours at 70°F (21°C)



Additives

MX193 Flexible Additive 10% to RTS quart

MX194 Fisheye Eliminator Up to .5 oz. to RTS quart

SU4985 Universal Matting Agent, see ONECHOICE® product bulletin OC-2.

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 full wet coats

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

Dry Times



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



Air Dry:

Dust: 10 - 15 minutes
Tack: 30 - 50 minutes
Tape: 2 - 4 hours

With MH255

With MH256 / MH257

10 - 15 minutes
50 - 60 minutes
2 - 4 hours



Force Dry:

30 minutes at 140°F (60°C)

30 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:
After cool down

6 - 8 hours at 70°F (21°C)
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

Clean Up

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.

Properties

VOC

| | |
|----------------------------|--------------------------|
| Package | 3.57 lbs./ gal (428 g/L) |
| Applied Less exempts (4:1) | 4.14 lbs./ gal (496 g/L) |
| Volume Solids (4:1) | 35.4% |
| Weight Solids (4:1) | 42.0% |

Film Build Per Coat

| | |
|---------------|----------------|
| Applied (4:1) | 1.0 - 1.5 mils |
|---------------|----------------|

Sq. Ft. coverage at 1 mil

| | |
|---------------|------------------------------|
| Applied (4:1) | 568 sq. ft. at 100% transfer |
|---------------|------------------------------|

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.



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