

3999 Series

2K HS Exterior Polyurethane Clearcoat

Suggested Topcoats

- Spectracron branded urethane topcoats

End Use Markets

- Heavy duty equipment
- Agricultural equipment
- Transportation
- Wheel coaters
- Building materials

Product Codes

- Q3999 – High gloss clear

SPECTRACRON® 3999 Series 2K Exterior Polyurethane Clearcoats are high solids clearcoats that are designed to give added UV protection on exterior substrates when applied over Spectracron 2K opaque polyurethane topcoats. The clearcoat is very easy-to-spray and combined with its excellent sag resistance properties, it produces an added depth of image.

Product Highlights

- Excellent exterior UV durability
- Outstanding depth of image
- Excellent corrosion resistance
- Excellent adhesion and sag resistance
- VOC 3.5 lbs./gal. (420 g/L)
- Contains no heavy metals

Physical Properties

Property	Blended Value
Solids % by weight	53.2 ± 5.0
Solids % by volume	47.9 ± 3.0
Weight / Gallon	8.4 lbs. /gal. (1004 g/L)
Coverage @ 1 mil, 100% TE	768 ft. ² /gal. (71 m ² /3.785L)
60° Gloss	95+
VOC (less exempts)	3.5 lbs./gal. (420 g/L)
VOC (actual)	3.5 lbs./gal. (420 g/L)
HAPS	<1.2 lbs./gal. (144 g/L)
Shelf life	2 years

Performance Properties

Test	Result*
Pencil hardness	B – HB
Conical mandrel (1/8")	Pass
Adhesion	5B
Salt Spray	1000 hours
Humidity	100 hours

*results obtained over iron phosphate CRS panels



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Substrate Protection

The surface must be clean and free of all surface contamination. A chemical pretreatment such as PPG Chemfos® KA Cleaner/Coater or a similar conversion coating will improve the performance properties of the coating system. See your PPG Representative for recommendations.

Cure Schedule

Paint film is not fully cured for 7 days. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.

Physical Properties

Air Dry Times¹

To Touch 2 hours

To Handle 6 hours

To Topcoat 1 hour to 3 days

Force Dry Times

Flash Time 15 min. (ambient)

Temperature Up to 140°F (60°C)

Time at Temperature 30 min.

Mix Directions

Blend Ratio² 5:1 with Q3501
4:1 with GXH1086

Pot Life 2.5 – 3.5 hours

Reduction Q30 or TFS Blends

Application Viscosity 20 – 25" #2 EZ Zahn

Line/Flush Clean Up TFS909 or Q60

Application

Equipment Conventional, airless, HVLP

Recommended Wet Film Build 2.5 mils
63 microns

Recommended Dry Film Build 1.5 mils
38 microns

Additional Information

In-Service Temperature: 300°F (149°C)

Do not apply at temperatures below 50°F (10°C)

Protect from freezing

Avoid moisture contamination of the B Component as moisture can cause gelling and affect performance

Not recommended for use on zinc rich surfaces

Add up to 6 ounces per blended gallon of *Spectracron* Urethane Accelerator (UA-11) to increase rate of cure. Do not exceed 6 ounces

Footnotes

1. Excess film thickness will retard dry times and affect the recoat window.
2. No-mixing or improper mixing can result in performance issues and curing issues

The technical data presented is information believed by PPG to be currently accurate; however, no guarantee of accuracy, comprehensiveness or performance is given or implied. Continuous improvements in coating technology may cause future technical data to vary from what is in this document. Product is intended for application by trained personnel in a factory or shop application. Do not attempt to use product without the current Safety Data Sheet. The performance of a product can fluctuate due to surface preparation technique, method of application, operating conditions, the material it is applied to or with, and use. It is strongly recommended that products be tested with respect to these factors prior to full scale use.

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