



PDS N6.3.1

April 2017

NEXA AUTOCOLOR® 2K® P190-6330 - HS Production Clearcoat

PRODUCT DESCRIPTION

NEXA AUTOCOLOR® 2K® P190-6330 HS Production Clearcoat is a premium quality high solids acrylic urethane clearcoat specifically formulated to meet the demands of today's high production collision centers. With shorter cycle times, HS Production Clearcoat increases throughput which improves shop productivity while maintaining a premium quality finish.

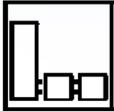
- *Easy application = consistent results*
- *Shorter cycle times - increased productivity*
- *HS Clearcoat system = labor and materials savings*

Products	
P190-6330	HS Production Clearcoat
P210-6270/-6285/-6295	2K Hardeners
P850-1692/-1693/-1694/-1695	Thinners
P273-1086	Fish-Eye Preventer

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

HS Production Clearcoat

PROCESS

MIX RATIO 	P190-6330 HS Production Clearcoat 3 parts P210-62xx Hardener 1 part P850-169x Thinner 1 part
POTLIFE 	Sprayable Pot Life: 3 - 4 hours at 70°F (21°C) Viscosity: 12 - 14 seconds DIN 4 at 70°F (21°C)
SPRAYGUN & AIR PRESSURE 	Fluid Tip: 1.4 - 1.8 mm HVLP: 10 PSI cap pressure Compliant: 29 - 40 PSI at the gun For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures
APPLICATION 	Apply: 2 medium wet coats Total Dry Film Build: 2.4 - 2.6 mils
FLASH TIME 	Between Coats: 5 - 10 minutes at 70°F (21°C)
DRY TIMES  	Air Dry: Dust Free: 45 - 60 minutes at 70°F (21°C) To Handle: 4 - 5 hours at 70°F (21°C) Tape Time: 7 - 9 hours at 70°F (21°C) Air Dry: 9 hours at 70°F (21°C) Force Dry: With P210-6270 10 minutes at 140°F (60°C) With P210-6285 15 minutes at 140°F (60°C) With P210-6295 20 minutes at 140°F (60°C) Note: No purge is necessary before force drying

All force dry times are quoted for surface temperature. Additional time must be allowed during force dry to allow surface to reach recommended temperature.

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GENERAL PROCESS NOTES

SUBSTRATES

P190-6330 HS Production Clearcoat can be applied over *Nexa Autocolor 2K* Basecoat color and properly cleaned and prepared factory finishes.

When using over plastic substrates refer to "Plastics Painting Process" PDS N7.1.

PROCESS NOTES

CHOICE OF HARDENER AND THINNER

Hardener and thinner selection will depend mainly on temperature but also on air movement and size of repair. Refer to selection guide below for the correct hardeners and to technical bulletin ABPTS010 Nexa Thinner Guide for the correct thinners to use for your job.

P210-6270	Hardener - Low Temperature 65 - 75°F (18 - 24°C)
P210-6285	Hardener - Mid Temperature 70 - 80°F (21 - 26°C)
P210-6295	Hardener - High Temperature 80 - 95°F (27 - 35°C)
P850-1692	Thinner - Low Temperature
P850-1693	Thinner - Mid Temperature
P850-1694	Thinner - High Temperature
P850-1695	Thinner - Very High Temperature

RTS Clearcoat P190-6330			Mix Ratio by Weight (Cumulative Weight in Grams)			
Product		Ratio	1/2 Pint	1 Pint	1 Quart	2 Quart
Clearcoat	P190-6330	3	136.2	272.4	544.8	1089.6
Hardener	P210-62xx	1	187.2	374.5	749.0	1498.0
Thinner	P210-169x	1	225.8	451.6	903.2	1806.4

Note: These weights will product approximately 97.5% of the volume stated to allow for mixing. If an exact quart, pint, half-pint, etc. is required, multiply all weights by 1.025.

For optimum application, these paint systems should not be applied cold. Best results will be obtained by allowing adequate time for paint to reach 70°F (21°C).

For blending of P190-6330 HS Production Clearcoat, refer to PDS N7.3 Blending Techniques.

In the event of fish-eyes, add 1- 2 inner capfuls of P273-1086 Fish-Eye Preventer to 1 quart of P190-6330 ready-for-use.

RECOATABILITY

P190-6330 HS Production Clearcoat used with Hardeners P210-6270, P210-6285 or P210-6295 is fully recoatable after 4 to 6 hours air dry at 70°F (21°C).

When force dried, P190-6330 is fully recoatable after cool down.

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GENERAL PROCESS NOTES

POLISHING

Polishing is not normally required. If however polishing is required to remove minor dirt nibs, wet sand with P1500 and follow normal polishing procedures.

EQUIPMENT CLEANING

Approved PPG Cleaning Solvent

RTS Combinations

	P190-6330 : P210-62xx : P850-169x
Volume Ratio	3 : 1 : 1
Applicable Use Category	Clear Coating (Multi-Stage)
VOC Regulatory (g/L) (less water, less exempts)	463-465
VOC Regulatory (lbs/Gal) (less water, less exempts)	3.86-3.88
Solids vol. %	41.0
Solids wt. %	48.0-48.1
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	658

VOC COMPLIANCE

To ensure accurate mixing, best performance & VOC compliance:

- Do not add extra hardener, thinner or change the recommended mixing ratio.
- Do not use hardeners or thinners that are not specific in this process summary.

HEALTH AND SAFETY

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

- 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 and SDSs of all the components since the mixture will have the hazards of all of its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

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

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statement listed on label. Statement and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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