

Designed for use with


**PDS N5.9.4**

October 2018

## AQUABASE PLUS<sup>®</sup> P190-6800 HS Express Clearcoat

### PRODUCT DESCRIPTION

AQUABASE<sup>®</sup> Plus P190-6800 HS Express Clearcoat is a high quality urethane clearcoat specifically developed for use over *Aquabase Plus* and NEXA AUTOCOLOR<sup>®</sup> 2K<sup>®</sup> basecoats. This clearcoat, with its no bake requirements and zero flash between coats, dramatically reduces cycle times while maintaining the quality and appearance required by high production shops.

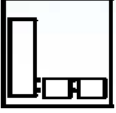





HS Express Clearcoat is designed for use on repairs of 1-4 panels offering extremely fast flash, polish and air dry times without sacrificing durability or appearance.

Products	
P190-6800	HS Express Clearcoat
P210-6875/-6895	Hardeners
P852-1683 / P850-1775	Reducers
SLV898	Low VOC Retarder

**THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY**

# HS Express Clearcoat

## PROCESS

<p><b>MIX RATIO</b></p> 	<p><b>Clearcoat</b> P190-6800 4 parts  <b>Hardener</b> P210-6875 / P210-6895 1 part  <b>Thinner*</b> P852-1683 / P850-1775 / SLV898 1 part</p> <p>*Thinner selection may be dependent on temperature and or size of repair. For use in extreme temperatures +95°F / +35°C, SLV898 may be used as a replacement up to one full part for P852-1683 or P850-1775 thinners. For VOC data and additional information, see ONECHOICE® product bulletin OC-17. Refer to PAINTMANAGER™ program software for exact mix by weight volumes.</p>
<p><b>POTLIFE</b></p> 	<p>With P852-1683: 1-1½ hours at 70°F (21°C)                  With P850-1775 / SLV898: 2 hours at 70°F (21°C)</p> <p>Note: Pot life will be shortened with increased temperatures</p>
<p><b>SPRAYGUN &amp; AIR PRESSURE</b></p> 	<p><b>Fluid Tip:</b> 1.3-1.5 mm  <b>Spray Viscosity:</b> 12-14 seconds DIN4 at 70°F (21°C)  <b>HVLP:</b> Maximum of 10 psi cap pressure  <b>Compliant:</b> 29-40 psi at the gun</p> <p>For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures</p>
<p><b>APPLICATION</b></p> 	<p><b>Apply:</b> 2 medium wet coats</p> <p><b>Film Builds</b></p> <p>Minimum Dry: 2.0 mils                  Maximum Dry: 3.0 mils                  Recommended wet film build per coat: 2.0-2.5 mils                  Recommended dried film build per coat: 1.0-1.5 mils</p>
<p><b>FLASH TIME</b></p> 	<p><b>No flash required between coats</b></p>
<p><b>DRY TIMES</b></p> 	<p><b>Air dry:</b></p> <p>Dust Free: 10-15 minutes at 70°F (21°C)                  Air Dry to re-assemble: 1 hour at 70°F (21°C)                  Polishing: 30-45 minutes at 70°F (21°C)</p> <p><b>Force dry:</b> N/A</p> <p><b>Infrared:</b> N/A</p> <p>*For in-service delivery at low temperatures (below 60°F / 16°C) or inclement weather conditions, allow P190-6800 a minimum of 4 hours air dry at shop temperature (above 60°F / 16°C or above) or bake for 10 minutes at 120°F (49°C) metal temperature and cool for one hour prior to putting into service.</p>

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

P190-6800 HS Express Clearcoat can be applied over *Aquabase* Plus waterborne basecoat and *Nexa Autocolor 2K* basecoat colors after allowing proper dry time and properly prepared and cleaned original equipment finished and fully cured refinish paints.

The use of a tack rag is recommended

### PROCESS NOTES

#### CHOICE OF HARDENER

Hardener and thinner selection will depend mainly on temperature, but also on air movement and size of repair.

P210-6875	HS Hardener - Normal
P210-6895	HS Hardener - Slow
P852-1683	Standard Accelerated Reducer
P850-1775	Slow Reducer

For optimum performance, paint systems should not be applied cold. For best results, allow adequate time for paint to reach 70°F (21°C).

### OPTIONAL ADDITIVES

#### Flexible Parts

P100-2021	LV Flexible Additive	¼ up to ½ part to RTS quart
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SLV814	Universal Flexibilizer	¼ up to ½ part to RTS quart
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**Note:** P190-6800 does not require the use of P100-2021 but it is recommended. For very flexible or leading edge parts, the addition of P100-2021 or SLV814 will improve overall flexibility.

#### Fisheye Eliminator

SLV73	Fisheye Eliminator	1 oz. to RTS quart
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### RECOATABILITY

P190-6800 HS Express Clearcoat is recoatable after 2—3 hours air dry at 70°F (21°C) or after force dry for 10 minutes at 120°F (49°C) metal temperature and cool down for one hour.

P190-6800 HS Express Clearcoat must be sanded before recoating with primer, sealer or clear.

### PROCESS NOTES

#### Fading Out:

After spot repairing, use ONECHOICE® SLV840 or SXA840 Uniform Finish Blender solvent and apply starting from the outside of the repair moving towards the center of the repaired area to lose the clearcoat blend edge.

### POLISHING

Minor dirt nibs can be removed after recommended air dry or force dry and cool down cycles. Sand with P1500 or finer and follow normal polishing procedures.

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## GENERAL PROCESS NOTES

### EQUIPMENT CLEANING

Use approved cleaning solvent

RTS Combinations	P190-6800 : P210-68xx : P852-1683	P190-6800 : P210-68xx P850-1775	P190-6800 : P210-68xx : P852-1683 + P100-2021	P190-6800 : P210-68xx : P850-1775 + P100-2021
Volume Ratio	4 : 1 : 1	4 : 1 : 1	4 : 1 : 1 + 10%	4 : 1 : 1 : +10%
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating (flexed)	Clear Coating (flexed)
VOC Actual (g/L)	114-119	101-105	117-122	105-110
VOC Actual (lbs/Gal)	0.95-0.99	0.84-0.88	0.98-1.02	0.88-0.92
VOC Regulatory (g/L) (less water, less exempts)	229-249	210-228	226-238	211-221
VOC Regulatory (lbs/Gal) (less water, less exempts)	1.91-2.08	1.75-1.90	1.89-1.99	1.76-1.84
Density (g/L)	1078-1082	1104-1110	1085-1090	1110-1115
Density (lbs/Gal)	9.00-9.03	9.22-9.26	9.06-9.09	9.27-9.30
Volatiles wt. %	63.0-65.2	63.9-66.1	61.2-63.3	62.1-64.1
Water wt. %	0.1	0.1	0.1	0.1
Exempt wt. %	52.4-54.6	54.7-56.9	50.4-52.3	52.5-54.5
Water vol. %	0.1	0.1	0.1	0.1
Exempt vol. %	50.4-52.3	51.9-53.8	48.3-50.1	49.7-51.4
Solids vol. %	34.2-36.3	34.1-36.2	36.0-37.9	36.0-37.9
Solids wt. %	34.8-37.0	33.9-36.1	36.7-38.8	35.9-37.9
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	548-582	546-581	577-608	577-608

### 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.

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## 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.

For further information please contact:

Nexa Autocolor - USA  
19699 Progress Drive  
Strongsville, OH 44149

Nexa Autocolor - Canada  
2301 Royal Windsor Drive Unit #6  
Mississauga, Ontario L5J 1K5

