

PDS N5.9.4

September 2015

P190-6800 HS EXPRESS CLEARCOAT

PRODUCT DESCRIPTION

P190-6800 HS Express Clearcoat is a high quality urethane clearcoat specifically developed for use over AQUABASE® Plus and 2K® 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.

Designed for use with

Aquabase
PLUS

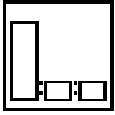
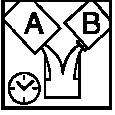


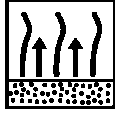


HS EXPRESS CLEARCOAT

PRODUCTS

<i>P190-6800</i>	<i>HS Express Clearcoat</i>
<i>P210-6875</i>	<i>HS Hardener-Normal</i>
<i>P210-6895</i>	<i>HS Hardener-Slow</i>
<i>P852-1683</i>	<i>Standard Accelerated Reducer</i>
<i>P850-1775</i>	<i>Slow Reducer</i>

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

MIX RATIO	HS EXPRESS CLEARCOAT	
	<p>Clearcoat P190-6800 4 Hardener P210-6875 / P210-6895 1 Thinner* P852-1683 / P850-1775 / SLV898 1</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 P852-16836 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>POTLIFE</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>SPRAYGUN & AIR PRESSURE</p> 	<p>Fluid Tip: 1.3 - 1.5 mm Spray Viscosity: 12 - 14 seconds DIN4 at 70°F (21°C)</p> <p>HVLP: Maximum of 10 psi cap pressure Compliant: 29 - 40 psi at the gun</p>	<p>Refer to gun manufacturer's recommended air pressure.</p>
<p>APPLICATION</p> 	<p>Apply: 2 medium wet coats</p> <p>Film Builds 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>FLASH TIME</p> 	<p>No flash required between coats</p>	
<p>DRY TIMES</p>  	<p>Air dry: 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>Force dry: N/A at 140°F (60°C) Metal Temperature</p> <p>Infrared: 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>

HS EXPRESS CLEARCOAT

SUBSTRATES

P190-6800 HS Express Clearcoat can be applied over *Aquabase Plus* Waterborne and 2K basecoats after allowing proper dry time and properly prepared and cleaned original equipment finishes and fully cured refinish paints.

OPTIONAL ADDITIVES

Flexible Additive

P100-2021	LV Flexible Additive	10% to ready to spray
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Note: When used on plastic parts, P190-6800 does not require the use of P100-2021. However, for very flexible or leading edge parts such as bumper covers and fascias, the addition of P100-2021 will improve overall flexibility. For flattening recommendations, see *OneChoice* bulletin OC-07.

Fisheye Eliminator

SLV73	Fisheye Eliminator	1 oz. per ready to spray quart
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RECOATABILITY

2 - 3 hours at 70°F (21°C) air dry or after force dry for 10 minutes at 120°F (49°C) metal temperature and cool down for one hour. P190-6800 must be sanded before recoating with primer, color or clear.

POLISHING

30 - 45 minutes at 70°F (21°C). Polishing is not normally required. If, however, polishing is required to remove minor dirt nibs, sand with P1500 or finer and follow normal polishing procedures.

PROCESS NOTES

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

Fading Out:

After spot repairing, use *OneChoice* SLV840 blending solvent and apply starting from the outside of the repair moving towards the center of the repaired area to lose the clearcoat blend edge.

EQUIPMENT CLEANING

Approved Cleaning Solvent

HS EXPRESS CLEARCOAT

PERFORMANCE SPECIFICATONS:

Use of recommended products in ready to spray mixes will be compliant under a Clear Coating VOC limit of 2.1 lbs./ gal. (250 g/L) in Canada and the US except parts of California.

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)	115-118	102-105	119-122	107-110
VOC Actual (lbs./ US Gal.)	0.96-0.99	0.85-0.88	0.99-1.02	0.89-0.92
VOC Regulatory (less water, less exempt) (g/L)	230-249	212-228	229-238	212-220
VOC Regulatory (less water, less exempt) (lbs./ US Gal.)	1.92-2.08	1.77-1.90	1.91-1.99	1.77-1.84
Density (g/L)	1073-1093	1073-1119	1080-1091	1106-1115
Density (lbs./ US Gal.)	8.95-9.12	8.95-9.34	9.02-9.10	9.23-9.30
Volatiles wt. %	61.5-65.2	62.5-66.1	59.9-63.3	60.9-64.1
Water wt. %	0.1	0.1	0.1	0.1
Exempt wt. %	50.4-54.6	52.8-56.8	48.6-52.4	50.8-54.5
Water vol. %	0.1	0.1	0.1	0.1
Exempt vol. %	48.6-52.9	50.0-54.4	46.7-50.1	48.8-51.4
Solids vol. %	33.6-37.5	33.5-37.4	36.0-39.0	36.0-39.0
Sq. Ft. Coverage / US Gal 1 mil at 100% transfer efficiency	539-602	538-600	577-626	577-626

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