



## PDS N5.10C

November 2016

# P190-6730 HS PLUS CLEARCOAT

## PRODUCT DESCRIPTION

NEXA AUTOCOLOR® 2K® P190-6730 HS Plus Clearcoat is a 2-pack high performance, low VOC Acrylic Urethane Clear which provides a fast, easy to apply high gloss and very durable finish.

## VOC COMPLIANCE

When used according to the recommendations set out in this datasheet, these products will comply with 2.1/ U.S. Gal VOC limits for basecoat clearcoat finishes.

- *Easy Application = consistent results*
- *Versatility = Performance in multiple environments*
- *Durable, high gloss = Customer satisfaction*
- *HS Plus System = Labor and material savings*
- *Fast Process Times = Increased throughput*

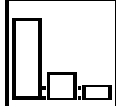
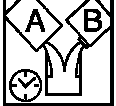





# **HS PLUS CLEARCOAT**

## **PRODUCTS**

<b><i>P190-6730</i></b>	<b><i>HS Plus Clearcoat</i></b>
<b><i>P210-6575</i></b>	<b><i>HS Plus Mid Temp Hardener 70-80°F (21-26°C)</i></b>
<b><i>P210-6585</i></b>	<b><i>HS Plus High Temp Hardener 80-95°F (27-35°C)</i></b>
<b><i>P850-1775</i></b>	<b><i>HS Plus Mid-Temp Reducer</i></b>

**THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY**

# PROCESS

MIX RATIO	Standard System		Express System	
	<b>Clearcoat</b> P190-6730  <b>Hardener</b> P210-6585  <b>Thinner</b> P850-1775	3 parts  1 part  10 %	<b>Clearcoat</b> P190-6730  <b>Hardener</b> P210-6575  <b>Thinner</b> P850-1775	3 parts  1 part  10 %
<b>POTLIFE</b> 	<b>Pot Life:</b> 2-3 hours at 70°F (21°C)  <b>Viscosity:</b> 15-17 seconds DIN4 at 70°F (21°C)		<b>Pot Life:</b> 3-4 hours at 70°F (21°C)  <b>Viscosity:</b> 15-17 seconds DIN4 at 70°F (21°C)	
<b>SPRAYGUN &amp; AIR PRESSURE</b> 	<b>Fluid Tip:</b> 1.3-1.6 mm  <b>HVLP:</b> Maximum of 10 psi cap pressure <b>Compliant:</b> 29-40 psi at the gun  Refer to gun manufacturer's recommended air pressure.			
<b>APPLICATION</b> 	<b>Apply:</b> 2 single coats  <b>Dry film build per coat:</b> 2.0-2.5 mils			
<b>FLASH TIME</b> 	<b>Between coats:</b> 5-10 minutes  <i>No flash-off is necessary before force drying.</i>			
<b>DRY TIMES</b>   	<u>Standard System</u>  <b>Air Dry at 70° (21°C)</b> Dust Free: 15-25 minutes Handle: 3-5 hours Polishing: 12-16 hours  <b>Force Dry at 140°F (60°C)</b> Bake: 20 minutes		<u>Express System</u>  <b>Air Dry at 70° (21°C)</b> Dust Free: 20-30 minutes Handle: 4-6 hours Polishing: 16 hours  <b>Force Dry at 140°F (60°C)</b> Bake: 30 minutes	

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

# HS PLUS CLEARCOAT

## Weight Activation Chart for HS Plus Clearcoat P190-6730

Volume of RFU / Paint Required	Cumulative Weight		
	P190-6730 Clearcoat	P210-65xx Hardener	P850-1775 Thinner
1/2 Pint	205.0	252.0	275.0
1 Pint	410.0	504.0	550.0
1 Quart	819.0	1009.0	1100.0
2 Quart	1638.0	2018.0	2200.0

**Note:** These weights will produce approximately 97.% of the volume stated to allow for mixing. If an exact quart, pint, half-pint, etc. is required, multiply all weights by 1.025. All weights have been rounded off to whole numbers.

## SUBSTRATES

HS Plus Clearcoat P190-6730 can be applied over 2K and AQUABASE<sup>®</sup> Plus Basecoats after allowing proper dry time.

When using over plastic substrates, please refer to Plastic Application Process (PDS N7.1C).

## RECOATABILITY

### HS Plus System

HS Plus Clearcoat P190-6730 used with HS Plus Hardeners, P210-6575 or P210-6585, is fully recoatable after 16 hours air dry 70°F (21°C).

HS Plus Clearcoat (P190-6730) when force dried for recommended time is fully recoatable after cooling down.

## 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).

For blending of HS Plus Clearcoat (P190-6730), refer to PDS N7.3C.

In the event of fish-eyes add 1-2 inner capfuls of P273-1086 Fish-Eye Preventer to 1 quart of HS Plus Clearcoat Ready-for-Use.

## 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.

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## EQUIPMENT CLEANING

Approved PPG Cleaning Solvent

## VOC COMPLIANCE

To ensure accurate mixing, best performance & VOC compliance:

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

<b>RTS Combinations</b>	<b>Standard System</b> P190-6730 : P210-65xx + P850-1775	<b>Flexible System</b> (Premix P190-6730 : P100-2021 at 5:1 ratio) P190-6730/P100-2021 : P210-65xx + P850-1775	<b>Very Flexible System</b> (Premix P190-6730 : P100-2021 at 2:1 ratio) P190-6730/P100-2021 : P210-65xx + P850-1775
Volume Ratio	3 : 1 + 10%	3 : 1 + 10%	3 : 1 + 10%
Applicable Use Category	Clear Coating	Clear Coating (Flexed)	Clear Coating (Flexed)
VOC Actual (g/L)	127	132	137
VOC Actual (lbs./ US Gal.)	1.06	1.10	1.14
VOC Regulatory (less water, less exempt) (g/L)	247	243	241
VOC Regulatory (less water, less exempt) (lbs./ US Gal.)	2.06	2.03	2.01
Density (g/L)	1191-1192	1188-1190	1185-1186
Density (lbs./ US Gal.)	9.94-9.95	9.91-9.93	9.89-9.90
Volatiles wt. %	65.2-65.3	62.8	60.3
Water wt. %	0.0	0.0	0.0
Exempt wt. %	54.6	51.7	48.9
Water vol. %	0.0	0.0	0.0
Exempt vol. %	48.5-48.6	45.8-45.9	43.1-43.2
Solids vol. %	36.8	38.9	41.1
Sq. Ft. Coverage / US Gal 1 mil at 100% transfer efficiency	590	624	659

For further information please contact:

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