INNOVATING REPAIR SOLUTIONS

Designed for use with

Aquabase PLUS

PDS N5.9.4

October 2018

AQUABASE PLUS®
P190-6800 HS Express Clearcoat
(National Rule)

For National Rule Markets

PRODUCT DESCRIPTION

AQUABASE® Plus P190-6800 HS Express Clearcoat is a high quality urethane clearcoat specifically developed for use over *Aquabase* Plus and NEXA AUTOCOLOR® 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.

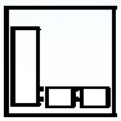
Products	
P190-6800	HS Express Clearcoat
P210-6875/-6895	Hardeners
P852-1683 / P850-1693/-1694/-1695-/1696	Reducers

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

HS Express Clearcoat

PROCESS

MIX RATIO



Clearcoat	P190-6800	4 parts
Hardener	P210-6875/-6895	1 part
Thinner*	P852-1683 / P850-1693/4/5	1 part

*Thinner selection may be dependent on temperature and or size of repair. For use in extreme temperatures +95°F / +35°C, P850-1696 may be used as a replacement up to one full part for P852-1683 or P850-169x thinners. Refer to PAINTMANAGER™ program software for exact mix by weight volumes.

POTLIFE

With P852-1683:	1-1½ hours at 70°F (21°C)
With P850-169x	2 hours at 70°F (21°C)

Note: Pot life will be shortened with increased temperatures

SPRAYGUN & AIR PRESSURE

Fluid Tip:	1.3-1.5 mm
Spray Viscosity:	12-14 seconds DIN4 at 70°F (21°C)
HVLP:	Maximum of 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

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

FLASH TIME

No flash required between coats

DRY TIMES

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)

Force dry: N/A

Infrared: N/A

*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.

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. For more information on choosing the correct thinner see ABPTS010NR *Nexa Autocolor* NR Thinner Guide available at the PPG Refinish website.

P210-6875	HS Hardener - Normal
P210-6895	HS Hardener - Slow
P852-1683	Standard Accelerated Reducer
P850-1693	Thinner Mid Temperature
P850-1694	Thinner High Temperature
P850-1695	Thinner Very High Temperature
P850-1696	Thinner Ultra High Temperature

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

P100-2020	Flexible Additive	¼ up to ½ part to RTS quart
SL814	Universal Flexibilizer	¼ up to ½ part to RTS quart

Note: P190-6800 does not require the use of a flexible additive but it is recommended. For very flexible or leading edge parts, the addition of P100-2020 or SL814 will improve overall flexibility.

Fisheye Eliminator

SL73	Fisheye Eliminator	1 oz. to RTS quart

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.

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GENERAL PROCESS NOTES

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.

EQUIPMENT CLEANING

Use approved cleaning solvent

RTS Combinations	P190-6800 : P210-68xx : P852-1683	P190-6800 : P210-68xx : P850-169x	P190-6800 : P210-68xx : P852-1683 + P100-2020	P190-6800 : P210-68xx : P850-169x + P100-2020
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	237-242	139-140	252-255
VOC Actual (lbs/Gal)	0.95-0.99	1.98-2.02	1.16-1.17	2.10-2.13
VOC Regulatory (g/L) (less water, less exempts)	229-249	367-383	256- 268	370-386
VOC Regulatory (lbs/Gal) (less water, less exempts)	1.91-2.08	3.06-3.20	2.14-2.24	3.09-3.22
Density (g/L)	1078-1082	1018-1025	1075-1079	1020-1026
Density (lbs/Gal)	9.00-9.03	8.50-8.55	8.97-9.00	8.51-8.56
Volatiles wt.%	63.0-65.2	60.8-63.3	60.8-62.9	58.7-61.0
Water wt. %	0.1	0.1	0.1	0.1
Exempt wt. %	52.4-54.6	37.4-39.8	47.8-49.8	34.0-36.1
Water vol. %	0.1	0.1	0.1	0.1
Exempt vol. %	50.4-52.3	35.2-37.1	45.8-47.5	32.0-33.7
Solids vol. %	34.2-36.3	34.1-36.2	36.0-37.9	36.0-37.9
Solids wt. %	34.8-37.0	36.7-39.2	37.1-39.2	39.0-41.3
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	548-582	547-581	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.

EMERGENTY 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 descried are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only an dare not to be construed as representations or warrantied 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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