

2.1 VOC Production Clear P390-4006

Description P390-4006 2.1 VOC Production Clear is a fast drying, easy to use spot and panel clearcoat developed for production shops. A choice of three hardeners and thinners offers greater flexibility for job size and temperature requirements.

Products	Clearcoat:	P390-4006	2.1 VOC Production Clear
	Hardeners:	P315-4600	2.1 Clear Hardener - Fast
		P315-4601	2.1 Clear Hardener - Medium
		P315-4602	2.1 Clear Hardener - Slow
	Reducers:	P830-2034	Compliant Reducer - Fast
		P830-2035	Compliant Reducer - Medium
		P830-2036	Compliant Reducer - Slow


Suitable for use over:
 VALUE-PRO™ VBX Basecoat Allow 30 minutes flash time before clearcoating.
 Value-Pro VBPX Basecoat VBX/VBPX basecoats must be clear coated within 24 hours.

Surface Preparation:
 Refer to the data sheet for Value-Pro VBX and VBPX basecoats

	Mixing	By Volume:	Additives
	Clearcoat P390-4006 Hardener P315-450x Reducer P830-203x Pot Life:	4 Parts 1 Part 0.5 Parts (optional) Up to 0.5 part of reducer may be added if needed. 1.5 hours at 70°F (21°C)	SLV73 Fisheye Eliminator ½ oz. per RTS quart SLV814 Flexible Additive, see page 2 SLV4985 Matting Agent, Refer to ONECHOICE® product bulletin.

	Application	
	HVLP: 8 - 10 psi at the air cap Conventional: 45 - 55 psi at the gun Compliant: 29 - 40 psi at the gun Gun Setup: 1.3 - 1.5 mm or equivalent	Note: For best overall results, refer to spraygun manufacture's recommendations for inlet air pressures.

	Coats	Flash Time
	2-3 medium wet coats (2.0 - 2.5 mils dry film)	2-5 minutes between coats @ 70°F/21°C

Drying	Air Dry:	<u>With P315-4600</u>	<u>With P315-4601</u>	<u>With P315-4602</u>
	Dust:	20-35 minutes	25-40 minutes	30-45 minutes
	Tack:	70-90 minutes	80-100 minutes	80-100 minutes
	Tape:	3-4 hours	3-4 hours	3-4 hours
	Polish:	Air dry: 3-4 hours Force dry: After cool down		
Force Dry:	20 minutes at 120°F (49°C)			
Recoat:	4-6 hours or overnight at 70°F (21°C)			
IR (Infrared):	10-15 minutes, full power			

Process Notes

For *Value-Pro* VBX and VBPX Basecoats, the maximum time to clearcoat is 24 hours. If left longer, scuff thoroughly and apply additional basecoat before applying clearcoat.

Clean up equipment immediately after use, using *Value-Pro* P830-2077 General Purpose Solvent or another suitable solvent. Dispose of waste in accordance with applicable regulations.

Properties

	P390-4006 : P315-460x : P830-203x	P390-4006 : P315-460x : P830-203x : SLV814
RTS Combinations:		
Volume Ratio:	4 : 1 : ½	4 : 1 : ½ +10%
Applicable Use Category	Clear Coating	Clear Coating (Flexible)
VOC Actual (g/L)	143-157	134
VOC Actual (lbs./gal)	1.19-1.31	1.12
VOC Regulatory (less water less exempt) (g/L)	249	1241
VOC Regulatory (less water less exempt) (lbs/gal)	2.08	2.01
Density (g/L)	1160-1177	1182
Density (lbs./gal)	9.68-9.82	9.86
Volatiles wt. %	55.8-60.4	61.6
Water wt. %	0.0-0.1	0.0
Exempt wt. %	42.3-48.3	50.3
Water vol. %	0.0	0.0
Exempt vol. %	36.8-42.3	44.5
Solids vol. %	41.3-45.5	40.4
Solids weight %	39.6-44.2	38.4
Sq Ft. Coverage / U.S. gal. 1 mil. @ 100% transfer efficiency	662-730	648

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

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION:

USA (412) 434-4515; CANADA (514) 645-1320; MEXICO 91-800-00-214