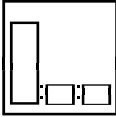
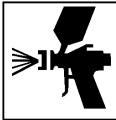
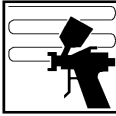
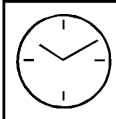




# P390-4003 Multi-Purpose Clear

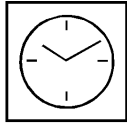
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<b>DESCRIPTION:</b>	The VALUE-PRO™ P390-4003 Multi-Purpose Clear is a fast drying two-component urethane clearcoat for automotive refinish applications.		
<b>PRODUCTS:</b>	Clearcoat:	P390-4003 Multi-Purpose Clear	
	Hardener:	P315-3531 Multi-Purpose Clear Hardener Fast P315-3532 Multi-Purpose Clear Hardener Med P315-3533 Multi-Purpose Clear Hardener Slow	
<b>SUITABLE FOR USE OVER:</b>	Refinish Basecoats		
<b>SURFACE PREPRATION:</b>	Allow basecoat color to dry a minimum of 30 minutes and a maximum of 24 hours before clearing.		
<b>MIXING:</b>		P390-4003 Clearcoat	4 parts
		P315-353x Hardener	1 part
		Pot Life:	1½-2 hours at 70°F (21°C)
		Additives:	
			SL814 Universal Flexibilizer 10% to RTS
			SU4985 Universal Matting Agent see ONECHOICE® bulletin OC-2VOL
<b>SPRAY GUN:</b>		HVLP:	8-10 PSI at the air cap
		Compliant:	29-40 PSI at the gun
		Gun Setup:	1.3-1.6 mm or equivalent
		Note:	For best overall results refer to spray gun manufacturer's recommendations for inlet air pressures.
<b>APPLICATION:</b>		Apply 2-3 coats allowing 5-10 minutes at 70°F (21°C) flash time between coats.	
		Dry film build:	2.4-3.5 mils
<b>DRYING:</b>		Air Dry: (P315-3531)	Dust Free: 5-10 minutes at 70°F (21°C) Tack: 30-50 minutes Tape / Polish : 2-4 hours Into Service: 8 hours (overnight)
		Force Dry:	15 minutes at 140°F (60°C) - Metal temperature

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## P390-4003 Multi-Purpose Clear Page 2

### DRYING: Cont'd



Air Dry:  
(P315-3532/3)

Dust Free: 10-15 minutes at 70°F (21°C)  
Tack: 50-60 minutes  
Tape: 2-4 hours  
Polish: 6-8 hours (overnight)  
Into Service: 8 hours (overnight)

Force Dry:

20 minutes at 140°F (60°C) - Metal temperature

IR:

12-15 minutes (medium wave)

Recoat:

Air Dry: after into service time  
Force Dry: after 2 hours cool down time

After into service time small defects may be sanded out and clearcoat reapplied.  
After 24 hours the basecoat should be lightly sanded and reapplied before applying P390-4003.

### EQUIPMENT CLEANING:

Spray guns, gun cups, storage pots, etc. should be cleaned thoroughly after each use with any appropriate PPG general purpose solvent.

### TECHNICAL DATA:

	<b>P390-4003 : P315-353X</b>
Volume Ratio	4 : 1
Applicable Use Category	Clear Coating
VOC Regulatory (less water, less exempts)	4.21 lbs./ US gal. (505 g/L)
VOC Actual	3.59 lbs./ US gal. (430 g/L)
Density	7.82 lbs./ US gal. (937 g/L)
Solids vol. %	35.5%
Solids wt. %	41.9%
Sq. ft. coverage / US gal. (1 mil. At 100% transfer efficiency)	569

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

**Important:** The contents of this package must 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 of all components since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

#### EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

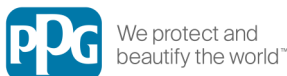
Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statements listed on label. Statements 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.

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