



P390-4000 HS Clearcoat

DESCRIPTION: The VALUE-PRO™ P390-4000 HS Clearcoat is a modern, high solids urethane clearcoat for automotive refinish applications.

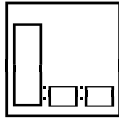
PRODUCTS:

Clearcoat:	P390-4000 HS Clearcoat
Hardener:	P315-3511 Hardener for Clearcoats
Thinner:	P830-2075 Medium Thinner P830-2085 Slow Thinner

SUITABLE FOR USE OVER: Refinish Basecoats
Direct Gloss Topcoats

SURFACE PREPRATION: Allow basecoat color to dry a minimum of 30 minutes and a maximum of 24 hours before clearing.

MIXING:



P390-4000 Clearcoat	4 parts
P315-3511 Hardener	1 part
P830-20xx Thinner	1 part

Pot Life: 3 hours at 70°F (21°C)

Additives:

SL814 Universal Flexibilizer 10% to RTS

SU4985 Universal Matting Agent see ONECHOICE® bulletin OC-2VOL

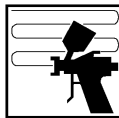
SPRAY GUN:



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.

APPLICATION:

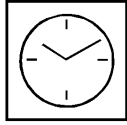


Apply 2 coats allowing 5-10 minutes at 70°F (21°C) flash time between coats.

Dry film build: 2.0-2.5 mils

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DRYING:



Air Dry:

Dust Free: 60-80 minutes at 70°F (21°C)

Tack: 2½-3½ hours

Tape: 12 hours

Polish / Into Service: 16 hours (overnight)

Force Dry:

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

Polish / Into Service: after 2 hours

IR:

12-15 minutes (medium wave)

Recoat:

Air Dry: after into service time

Force Dry: after 2 hours cool down time

After 24 hours the basecoat should be lightly sanded and reapplied before applying P390-4000.

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:

	P390-4000 : P315-3511: P830-20xx
Volume Ratio	4 : 1 : 1
Applicable Use Category	Clear Coating
VOC Regulatory (less water, less exemptions)	4.22 lbs./ US gal. (506 g/L)
VOC Actual	4.06 lbs./ US gal. (487 g/L)
Density	7.99 lbs./ US gal. (957 g/L)
Solids vol. %	39.5%
Solids wt. %	45.3%
Sq. ft. coverage / US gal. (1 mil. At 100% transfer efficiency)	633

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.

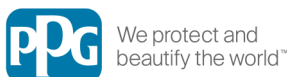
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