

Designed for use with



AQUABASE PLUS[®] P190-6659 Express Clearcoat

PRODUCT DESCRIPTION

AQUABASE[®] Plus Express Clearcoat is a fast drying, 2-pack high solids acrylic urethane clearcoat which provides a fast and easy to apply high gloss, durable finish designed specifically for use over *Aquabase Plus* waterborne basecoat.

P190-6659 Express Clearcoat offers multiple bake options for use on up to 3 panels. There is a Super Express System with a 10 minute bake for a single panel / spot repair, an Express System with a 15 minutes bake for multiple panels and a Standard System with a 30 minute bake for even larger types of repairs.

P190-6659 can be used in two modes, a ONE-VIVIST[™] application where 1 light to medium flowing coat is followed immediately by a full coat with no flash-off between coats or a standard 2-coat application.

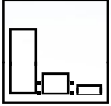
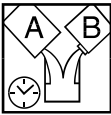


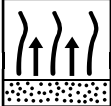



- **Easy Application = consistent result**
- **Fast Process Time = increased throughput**
- **Versatility = performance in multiple environments**
- **Durable, high gloss = customer satisfaction**

Products	
P190-6659	Express Clearcoat
P210-872/-875	Hardeners
P850-1692/-1693/-1694 P852-1689	Reducer
P273-1086	Fish-Eye Preventer

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

Express Clearcoat

PROCESS

MIX RATIO 	EXPRESS CLEARCOAT					
	Super Express System Spot / Panel Repair		Express System Medium Sized Repair		Standard System	
	Clearcoat P190-6659	3 parts	Clearcoat P190-6659	3 parts	Clearcoat P190-6659	3 parts
	Hardener P210-872	1 part	Hardener P210-872	1 part	Hardener P210-875	1 part
	Thinner P852-1689	0.6 parts	Thinner P850-169x	0.6 parts	Thinner P850-169x	0.6 parts
POTLIFE 	Pot Life: 20-30 minutes at 70°F (21°C)		Pot Life: 30-40 minutes at 70°F (21°C)		Pot Life: 40-50 minutes at 70°F (21°C)	
	Spray Viscosity: 18-20 seconds DIN4 at 70°F (21°C)		Spray Viscosity: 18-20 seconds DIN4 at 70°F (21°C)		Spray Viscosity: 18-20 seconds DIN4 at 70°F (21°C)	
SPRAYGUN & AIR PRESSURE 	Fluid Tip: 1.2-1.4 mm HVLP: Maximum of 10 psi cap pressure Compliant: 29-40 psi at the gun Refer to gun manufacturer's recommended air pressure.					
APPLICATION 	One Visit: Apply 1 light to medium flowing coat immediately followed by a second medium coat to give 2 mils of dry film thickness or Standard 2-Coat: Apply 2 single medium wet coats allowing flash time between each coat, to provide for 2-2.5 mils dry film thickness.					
FLASH TIME 	One Visit: On a single vertical panel, like a fender, allow 1 minute of flash time between the 1st and 2nd coats. For two or more panels, no flash time between coats is required. or Standard 2-Coat: Allow 3 to 5 minutes between coats depending on your spray booth conditions and/or hardener or thinner combination.					
DRY TIMES   	<u>Super Express System</u>		<u>Express System</u>		<u>Standard System</u>	
	Air Dry at 70° (21°C) Dust Free: 20-30 minutes Handle: 4 hours Polishing: 12-16 hours		Air Dry at 70° (21°C) Dust Free: 20-30 minutes Handle: 4 hours Polishing: 12-16 hours		Air Dry at 70° (21°C) Dust Free: 30-40 minutes Handle: 6 hours Polishing: 16 hours	
	Force Dry at 140°F (60°C) Metal Temperature 10 minutes		Force Dry at 140°F (60°C) Metal Temperature 15 minutes		Force Dry at 140°F (60°C) Metal Temperature 30 minutes	
	I-R Full Power: 8-15 minutes		I-R Full Power: 8-15 minutes		I-R Full Power: 8-15 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.

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GENERAL PROCESS NOTES

SUBSTRATES

P190-6659 Express Clearcoat can be applied over *Aquabase* Plus waterborne basecoat after following recommended drying procedures, properly prepared and cleaned original equipment finishes and fully cured refinish paints.

The use of a tack rag is recommended

PROCESS NOTES

CHOICE OF HARDENER AND THINNER

Hardener and thinner selection will depend mainly on temperature, but also on air movement and size of repair. Reducer selection guide are available online in bulletin ABPTS011 *Aquabase* Plus Thinner Guide or ABPTS010NR NEXA AUTOCOLOR® NR Thinner Guide.

P210-872	HS Plus Hardener - Low Temperature
P210-875	HS Plus Hardener - Mid Temperature
P852-1689	HS Plus Express Thinner
P850-1692	Thinner Low Temperature
P850-1693	Thinner Mid Temperature
P850-1694	Thinner High Temperature
P850-1695	Thinner Very 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

P100-2021	LV Flexible Additive	¼ up to ½ part to RTS quart
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SLV814	Universal Flexibilizer	¼ up to ½ part to RTS quart
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Note: P190-6659 does not require the use of P100-2021 but it is recommended. For very flexible or leading edge parts, the addition of P100-2021 or SLV814 will improve overall flexibility.

Fisheye Eliminator

SLV73	Fisheye Eliminator	1 oz. to RTS quart
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GENERAL PROCESS NOTES

Weight Activation Chart for P190-6659 High Solids Clearcoat

Final Ready for Use Volume	Cumulative Weight in Grams			
	P190-6659 Express Clearcoat	P210-87x Hardener	P850-169x Thinner	P852-1689* Express Thinner
½ Pint / 8 oz.	146.0	200.0	224.0	227.0
1 Pint / 16 oz.	293.0	399.0	448.0	454.0
1 Quart / 32 oz.	585.0	798.0	897.0	908.0
1.5 Quart / 48 oz.	880.0	1200.0	1348.0	1366.0
2 Quart / 64 oz.	1170.0	1596.0	1793.0	1817.0

*P852-1689 Express Thinner is for use with P210-872 only. Do not use with P210-875.

Note: Volume of RFU is 97% of the stated 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.

RECOATABILITY

P190-6659 Express Clearcoat used with Hardeners P210-872 fast, P210-875 medium and P210-877 slow are fully recoatable after 16 hours air dry at 70°F (21°C).

When force dried for the recommended times and metal temperatures, P190-6659 is fully recoatable after cooling down.

POLISHING

Polishing is not normally required. If, however, polishing is required to remove minor dirt nibs, sand with P1500 or finer and follow normal polishing procedures.

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 mixing ratio.
- Do not use hardeners or thinners that are not specific in this process summary.

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RTS Combinations	Express Thinner P190-6659 : P210-872 : P852-1689	Standard P190-6659 : P210-87x : P852-169x	Flexible (Premix P190- 6659 : P190- 2021 at 5:1) P190-6659 : P210-87x : P850-169x
Volume Ratio	3 : 1 : 0.6	3 : 1 : 0.6	3 : 1 : 0.6
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating (Flexible)
VOC Actual (g/L)	457	445	428
VOC Actual (lbs/Gal)	3.81	3.71	3.57
VOC Regulatory (g/L) (less water, less exempts)	463	449	451
VOC Regulatory (lbs/Gal) (less water, less exempts)	3.86	3.75	3.76
Density (g/L)	987	975	1015
Density (lbs/Gal)	8.24	8.14	8.47
Volatiles wt. %	47.2	46.5	50.9
Water wt. %	0.0	0.0	0.0
Exempt wt. %	0.9	0.9	10.1
Water vol. %	0.0	0.0	0.0
Exempt vol. %	1.1	1.1	7.9
Solids vol. %	46.1	46.4	46.9
Solids wt. %	52.8	53.5	49.1
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	739	744	752

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.

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 statement listed on label. Statement 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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