



PDS N5.11

April 2017

P190-5520 Clearcoat

PRODUCT DESCRIPTION

NEXA AUTOCOLOR® P190-5520 Clearcoat is a fast drying urethane clearcoat which provides good gloss and durability for 2K® Basecoat. It may also be used in an accelerated mode to reach a faster through cure.

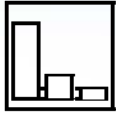






- *Easy application = consistent results*
- *Versatility = performance in multiple environments*

Products	
P190-5520	Clearcoat
P210-5260/-5275/-5290	Hardeners
P850-1692/-1693/-1694/-1695/-1696	2K Thinners
P275-5521	Accelerator
P273-1086	Fish-Eye Preventer

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

Clearcoat

PROCESS

MIX RATIO	STANDARD	ACCELERATED
	<p>P190-5520 Clearcoat 2 parts P210-52xx Hardener 1 part P850-16xx Thinner 5%</p>	<p>P190-5520 Clearcoat 2 parts P210-52xx Hardener 1 part P850-16xx Thinner 5% P275-5521 Accelerator *%</p> <p>*See chart for recommended levels</p>
POTLIFE 	<p>Sprayable Pot Life: 2-3 hours at 70°F (21°C) Viscosity: 16-18 second DIN 4 at 70°F (21°C)</p>	<p>Sprayable Pot Life: 2 hours at 70°F (21°C) Viscosity: 14-16 second DIN 4 at 70°F (21°C)</p>
SPRAYGUN & AIR PRESSURE 	<p>Fluid Tip: 1.4-1.6 mm HVLP: Maximum of 10 psi cap pressure Compliant: 29-40 psi at the gun</p> <p>For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures.</p>	<p>Fluid Tip: 1.4-1.6 mm HVLP: Maximum of 10 psi cap pressure Compliant: 29-40 psi at the gun</p> <p>For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures.</p>
APPLICATION 	<p>Apply: 2 single coats Total dry film build: 2.5 mils</p>	<p>Apply: 2 single coats Total dry film build: 2.5 mils</p>
FLASH TIME 	<p>Between coats: 5-10 minutes</p>	<p>Between coats: 5-10 minutes</p>
DRY TIMES  	<p>Air dry: At 70°F (21°C) Dust Free: 15-20 minutes To Handle: 6 hours Polish: 16 hours / overnight</p> <p>Force dry: At 140°F (60°C) 30 minutes</p> <p>No purge is necessary before force drying</p>	<p>Air dry: At 70°F (21°C) Dust Free: 10-15 minutes To Handle: 4 hours Polish: 8-10 hours</p> <p>Force dry: At 140°F (60°C) 20 minutes</p> <p>No purge is necessary before force drying</p>

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

ACCELERATED

Accelerated P190-5520		Mix Ratio by Weight (Cumulative Weight in Grams)			
RTS Clearcoat		1 Pint	1 Quart	2 Quart	1 Gallon
Accelerator	P275-5521	10 ml (.34 fl.oz.)	20 ml (.67 fl.oz.)	40 ml (1.35 fl.oz.)	80 ml (2.7 fl.oz.)

SUBSTRATES

P190-5520 Clearcoat can be applied over *Nexa Autocolor 2K* Basecoat color and properly cleaned and prepared factory finishes.

When using over plastic substrates, refer to "Plastics Painting Process" PDS N7.1.

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. Refer to selection guide below for the correct hardeners and to technical bulletin ABPTS010 Nexa Thinner Guide for the correct thinners to use for your job.

P210-5260	Low Temperature Hardener 65-75°F (18-24°C)
P210-5275	Mid Temperature Hardener 70-80°F (21-26°C)
P210-5290	High Temperature 80-95°F (27-35°C)
P850-1692	Thinner - Low Temperature
P850-1693	Thinner - Mid Temperature
P850-1694	Thinner - High Temperature
P850-1695	Thinner - Very High Temperature
P850-1696	Thinner - Ultra High Temperature

For optimum application, these paint systems should not be applied cold. Best results will be obtained by allowing adequate time for paint and substrate to reach a minimum of 70°F (21°C).

For blending of P190-5520 Clearcoat, refer to PDS N7.3 Blending Techniques.

In the event of fish-eyes, add 1-2 inner capfuls of P273-1086 Fish-Eye Preventer to 1 quart of P190-5520 ready-for-use.

RECOATABILITY

P190-5520 Clearcoat used with Hardeners P210-5260, P210-5275 and P210-5290 is fully recoatable after 16 hours air dry at 70°F (21°C) or in 8-10 hours if accelerated.

When force dried, P190-5520 Clearcoat is fully recoatable after cool down.

POLISHING

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

EQUIPMENT CLEANING

Approved PPG Cleaning Solvent

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RTS Combinations

	P190-5520 : P210-52xx + P850-169x	P190-5520 : P210-52xx : P850-169x + P275-5521
Volume Ratio	2 : 1 + 5%	2 : 1 + 5% + 2.7 RTS oz./gal
Applicable Use Category	Clear Coating (Multi-Stage)	Clear Coating (Multi-Stage)
VOC Regulatory (g/L) (less water, less exempts)	498-5.02	5.04-5.07
VOC Regulatory (lbs/Gal) (less water, less exempts)	4.16-4.19	4.21-4.23
Solids vol.%	42.5-43.3	41.9-42.7
Solids wt.%	49.1-49.7	48.7-49.1
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	682-695	672-685

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 specified in this process summary.

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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