



PDS N6.30

April 2017

NEXA AUTOCOLOR® 2K® P190-6100 - Fast HS Clearcoat

PRODUCT DESCRIPTION

NEXA AUTOCOLOR® 2K® P190-6100 Fast HS Clearcoat is a premium quality high solids acrylic urethane clearcoat developed to improve productivity in air dry and low bake environments. Fast HS Clearcoat is designed for repairs up to four panels and offers fast flash, out of dust, and polish times without sacrificing appearance or durability.

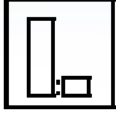






- *Easy application = consistent results*
- *Fast process = less booth time*
- *HS Clearcoat system = labor and materials savings*

Products	
P190-6100	Fast HS Clearcoat
P210-6270/-6285/-6295	2K Hardeners
P273-1086	Fish-Eye Preventer

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

2K Fast HS Clearcoat

PROCESS

MIX RATIO 	P190-6100 Clearcoat 4 parts P210-62xx Hardener 1 part
POTLIFE 	Sprayable Pot Life: 1.5 - 2 hours at 70°F (21°C) Viscosity: 12 - 14 seconds DIN 4 at 70°F (21°C)
SPRAYGUN & AIR PRESSURE 	Fluid Tip: 1.4 - 1.8 mm HVLP: 10 PSI cap pressure Compliant: 29 - 40 PSI at the gun For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures.
APPLICATION 	Apply: 2 medium wet coats Total Dry Film Build: 2.4 - 2.8 mils
FLASH TIME 	Between Coats: 3 - 5 minutes at 70°F (21°C)
DRY TIMES  	Air Dry: Dust Free: 25 - 30 minutes at 70°F (21°C) To Handle: 1.5 - 2 hours at 70°F (21°C) Tape Time: 4 - 6 hours at 70°F (21°C) Air Dry: 6 hours at 70°F (21°C) Force Dry: With P210-6270 10 minutes at 120°F (49°C) metal temperature With P210-6285/95 15 minutes at 140°F (60°C) metal temperature Note: No purge is necessary before force drying

All force dry times are quoted for surface temperature. Additional time must be allowed during force dry to allow surface to reach recommended temperature.

2K Fast HS Clearcoat

GENERAL PROCESS NOTES

SUBSTRATES

P190-6100 Fast HS 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

Hardener selection will depend mainly on temperature, but also on air movement and size of repair. (Refer to Hardener Selection Guide).

P210-6270	Hardener - Low Temperature 65 - 75°F (18 - 24°C)
P210-6285	Hardener - Mid Temperature 70 - 80°F (21 - 26°C)
P210-6295	Hardener - High Temperature 80 - 95°F (27 - 35°C)

RTS Clearcoat P190-6100			Mix Ratio by Weight (Cumulative Weight in Grams)			
Product		Ratio	1/2 Pint	1 Pint	1 Quart	2 Quart
Clearcoat	P190-6100	4	164	328	680	1362
Hardener	P210-62xx	1	212	420	876	1751

Note: These weights will product approximately 97.5% of the 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.

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

For blending of P190-6100 Fast HS 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 P190-6100 ready-for-use.

RECOATABILITY

P190-6100 Fast HS Clearcoat used with Hardeners P210-6270, P210-6285 and P210-6295 is fully recoatable after 4 to 6 hours air dry at 70°F (21°C).

When force dried, P190-6100 Fast HS 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

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

2K Fast HS Clearcoat

RTS Combinations

	P190-6100 : P210-62xx
Volume Ratio	4 : 1
Applicable Use Category	Clear Coating (Multi-Stage)
VOC Regulatory (g/L) (less water, less exempts)	458
VOC Regulatory (lbs/Gal) (less water, less exempts)	3.82
Solids vol. %	38.9
Solids wt. %	45.8
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	624

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.

HEALTH AND SAFETY

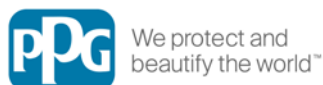
See Safety Data Sheet and Labels for additional safety information and handling instructions.

- 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.

For further information please contact:



Nexa Autocolor - USA
19699 Progress Drive
Strongsville, OH 44149

Nexa Autocolor - Canada
2301 Royal Windsor Drive Unit #6
Mississauga, Ontario L5J 1K5