INNOVATING REPAIR SOLUTIONS

Designed for use with Aquabase PLUS

PDS N5.9.6C

June 2018

AQUABASE® PLUS
P190-6930 Performance Clearcoat

PRODUCT DESCRIPTION

AQUABASE® Plus P190-6930 Performance Clearcoat is designed specifically for use with *Aquabase* Plus Waterborne Basecoat. This clearcoat reduces cycle times while maintaining the quality and appearance required by high production shops.

From an environmental standpoint, the low 2.1 VOC of P190-6930 Performance Clearcoat along with the high solids resin also decreases clearcoat material usage and therefore greatly reduces the overall VOC emissions and is compliant in all North American refinish markets.

Products	
P190-6930	Performance Clearcoat
P210-6975	Mid-Temperature Hardener
P850-6910/-6911/-6912/-6914 P850-1772/-1775	Thinners
P100-2021	LV Flexible Additive
SLV814	Universal Flexibilizer
SLV73	Fish Eye Eliminator
SL93LV	Accelerator

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

Performance Clearcoat

PROCESS

MIX RATIO

P190-6930	Clearcoat	3 parts
P210-6975	Hardener	1 part
P850-691x	Thinner	1 part
P850-177x	Thinner	

P850-6914 is the required retarder for all markets

POTLIFE

Sprayable Pot Life:	2 hours at 70°F (21°C)*
Viscosity:	16 seconds Din #4 at 70°F (21°C)

*Pot life will be shortened with increased temperatures

SPRAYGUN & AIR PRESSURE

Fluid Tip:	1.3 - 1.5 mm
HVLP:	10 PSI cap pressure
Compliant:	29 - 40 PSI at the gun*

Note: Refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.

APPLICATION

Apply:	2 medium wet coats
Film Builds:	
Minimum Dry:	2.0 mils
Maximum Dry:	3.5 mils
Recommended wet film build per coat:	2.0 - 2.5 mils
Recommended dry film build per coat:	1.0 - 1.5 mils

FLASH TIME

Between coats:	3 - 5 minutes

DRY TIMES

Air Dry:	
Dust Free:	80 - 100 minutes at 70°F (21°C)
Air Dry to Re-assemble:	4 hours at 70°F (21°C)
Force Dry:	
Bake:	25 minutes at 140°F (60°C)* (Metal Temperature)
Tape Time:	3 - 4 hours
Infrared:	N/A

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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Performance Clearcoat

GENERAL PROCESS NOTES

SUBSTRATES

P190-6930 Performance 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 SX1070 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. (Refer to Selection Guide on page 5)

P210-6975	Mid Temperature Hardener
P850-6910	Low Temperature Thinner
P850-6911	Mid Temperature Thinner
P850-6912	High Temperature Thinner
P850-6914	High Temp-Humidity Thinner
P850-1772	Fast Reducer
P850-1775	Slow Reducer

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
SLV814	Universal Flexibilizer	¼ up to ½ part to RTS quart

Note: When used on plastic parts, P190-6930 does not require the use of P100-2021. However, 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

Accelerator

SL93LV	Accelerator	2% to RTS quart

RECOATABILITY

P190-6930 Performance Clearcoat is recoatable after 6 - 8 hours at 70°F (21°C) air dry or after force dry for 25 minutes at 140°F (60°C) metal temperature and cool down for one hour.

P190-6930 Performance Clearcoat must be sanded before recoating with primer, sealer or clear.

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Performance Clearcoat

GENERAL PROCESS NOTES

PROCESS NOTES

Fading Out:
After spot repairing, use ONECHOICE® SLV840 or SXA840 Uniform Finish Blender solvent and apply starting from the outside of the repair moving towards the center of the repaired area to lose the clearcoat blend edge.

POLISHING

Minor dirt nibs can be removed after recommended air dry or force dry and cool down cycles. Sand with P1500 or finer and follow normal polishing procedures.

EQUIPMENT CLEANING

Use approved cleaning solvent

RTS Combinations	P190-6930 : P210-6975 : P850-691x/ P850-177x	P190-6930 : P210-6975 : P850-691x/ P850-177x+ SLV73	P190-6930 : P210-6975 : P850-691x/ P850-177x + SL93LV	P190-6930 : P210-6975 : P850-691x/ P850-177x + P100-2021/SLV814
Volume Ratio	3 : 1 : 1	3 : 1 : 1 + 1 oz. / RTS qt.	3 : 1 : 1 + 2%	3 : 1 : 1 + up to ½ part
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating	Clear Coating (Flexed)
VOC Actual (g/L)	35 - 137	34 - 127	34 - 128	36 - 137
VOC Actual (lbs/Gal)	0.29 - 1.14	0.28 - 1.06	0.28 - 1.07	0.30 - 1.14
VOC Regulatory (g/L) (less water, less exempts)	73 - 232	73- 223	73 - 218	77 - 229
VOC Regulatory (lbs/Gal) (less water, less exempts)	0.61 - 1.94	0.61 - 1.86	0.61 - 1.86	0.64 - 1.91
Density (g/L)	1154 - 1210	1152 - 1210	1154 - 11.65	1155 - 1165
Density (lbs./Gal)	9.63 - 10.10	9.61 - 10.10	9.63 - 10.12	9.64 - 10.12
Volatiles wt.%	57.7 - 59.9	59.1 - 61.1	58.8 - 60.8	56.2 - 61.2
Water wt.%	0.0	0.0	0.0	0.0
Exempt wt.%	46.0 - 57.1	48.3 - 58.3	47.9 - 58.0	45.2 - 58.2
Water vol.%	0.0	0.0	0.0	0.0
Exempt vol.%	40.9 - 52.8	43.0 - 54.1	42.4 - 53.7	40.1 - 53.8
Solids vol.%	43.4	42.2	42.6	41.7 - 44.4
Solids wt.%	40.1 - 42.3	38.9 - 40.9	39.2 - 41.2	38.8 -43.8
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	696	677	683	669 - 712

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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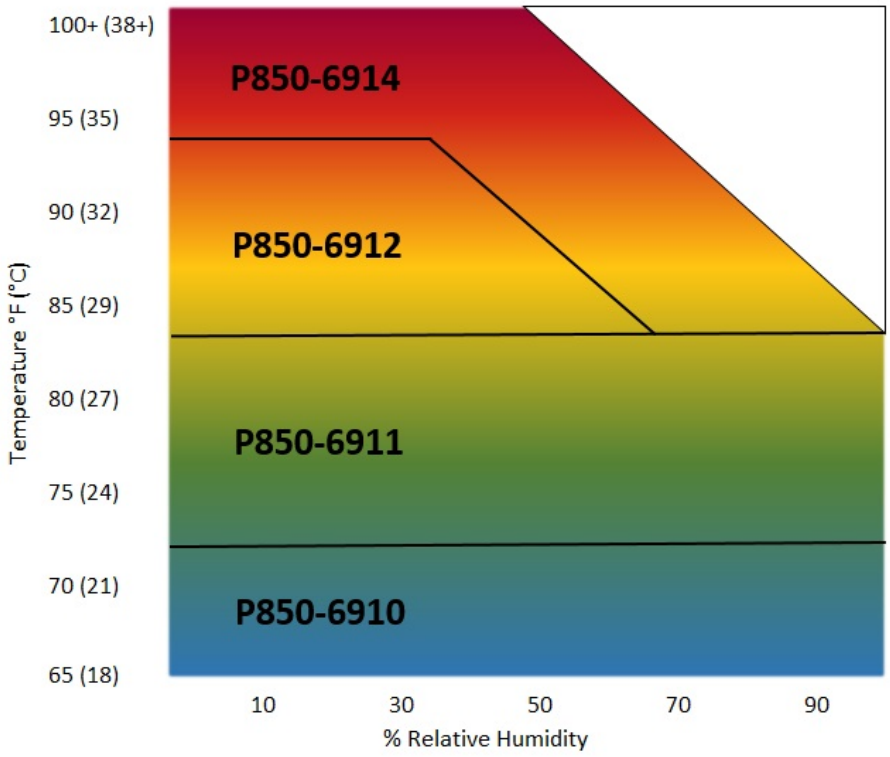
Higher Air Movement
Temperature and Humidity
(Larger)

Average Air Flow & Humidity
12,000-24,000 CFM—30%-90% RH

Lower Air Movement
Temperature and Humidity
(Smaller)

P190-6930 Thinner Selection Guide



For repairs greater than 3 panels consider using the next higher temperature thinner. Temperature, Air Flow, Humidity and Size of Repair will affect thinner selection.

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.

EMERGENTY 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 descried are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only an dare not to be construed as representations or warrantied 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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