

PDS N5.9.3

February 2019

Designed for use with



AQUABASE PLUS[®] P190-6690 High Solids Clearcoat

PRODUCT DESCRIPTION

AQUABASE[®] Plus P190-6690 HS Clearcoat is a 2-pack high solids acrylic urethane clearcoat which provides a fast and easy to apply super high gloss, durable clearcoat finish designed specifically for use over *Aquabase Plus Waterborne Basecoat*.

P190-6690 offers multiple process options from single / multiple panel repair to overall or complete applications with force cure options from 25 to 40 minutes.

P190-6690 can be used in two modes, "ONE-VISIT™" 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	
P190-6690	High Solids (HS) Clearcoat
P210-872/-875/-877	Hardeners
P850-1692/-1693/-1694/-1695	Reducer
P273-1086	Fish-Eye Preventer

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

High Solids Clearcoat

PROCESS

MIX RATIO	Standard & High Temperature	Fast & Low Temperature
	P190-6690 Clearcoat 3 parts	P190-6690 Clearcoat 3 parts
	P210-875/-877 Hardener 1 part	P210-872 Hardener 1 part
	P850-169x Thinner 1 part*	P850-169x Reducer 1 part*
POTLIFE 	Sprayable Pot Life: 2 - 2.5 hours at 70°F (21°C)* Viscosity: 18 - 20 seconds DIN #4 at 70°F (21°C)	Sprayable Pot Life: 1 hour at 70°F (21°C)* Viscosity: 18 - 20 seconds DIN #4 at 70°F (21°C)
	*Pot life will be shortened with increased temperatures	
SPRAYGUN & AIR PRESSURE 	Fluid Tip: 1.2 - 1.4 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 	One Visit: Apply 1 light to medium flowing coat is immediately followed by a second medium coat to give 2 mils dry film thickness. Or Standard 2-Coat: Apply 2 single medium wet coats allowing flash time between each coat, to provide for 2 to 2.5 mils dry film thickness.	
FLASH TIME 	One Visit: On a single vertical panel, like a fender, allows 1 minute of flash time between the 1st and 2nd coats. For 2 or more panels, no flash time between coats is required. Or Standard 2-Coat: Allow 5 - 7 minutes between coats depending on your spray booth conditions and/or hardener or thinner combination.	
DRY TIMES 	Air Dry at 70° (21°C) <u>With P210-875</u> Dust Free: 40-50 minutes Handle: 4 hours Polishing: 16 hours <u>With P210-877</u> Dust Free: 60 minutes Handle: 6 hours Polishing: 24 hours Force Dry at 140°F (60°C) Metal Temperature With P210-875 35 minutes With P210-877 40 minutes I-R Full Power: 8-15 minutes	Air Dry at 70° (21°C) <u>With P210-872</u> Dust Free: 20-30 minutes Handle: 4 hours Polishing: 12-16 hours Force Dry at 140°F (60°C) Metal Temperature 25 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

P190-6690 High Solids 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
P210-877	HS Plus Hardener - High Temperature
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).

For blending P190-6690 refer to PDS N7.3C.

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: P190-6690 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

Weight Activation Chart for P190-6690 High Solids Clearcoat

Final Ready for Use Volume	Cumulative Weight in Grams		
	P190-6990 HS Clearcoat	P210-87x Hardener	P850-169x Thinner
½ Pint / 8 oz.	146.0	200.0	224.0
1 Pint / 16 oz.	293.0	399.0	448.0
1 Quart / 32 oz.	585.0	798.0	897.0
1.5 Quart / 48 oz.	880.0	1200.0	1348.0
2 Quart / 64 oz.	1170.0	1597.0	1973.0

*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.

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GENERAL PROCESS NOTES

RECOATABILITY

P190-6690 HS 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, P190-6690 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

RTS Combinations	Standard P190-6690 : P210-87X : P850-169x	Flexible (Premix P190-6690 : P100-2021 at 5:1) P190-6690 : P210- 87X : P850-169x
Volume Ratio	3 : 1 : 1	3 : 1 : 1
Applicable Use Category	Clear Coating	Clear Coating (Flexible)
VOC Actual (g/L)	479	452
VOC Actual (lbs/Gal)	4.00	3.77
VOC Regulatory (g/L) (less water, less exempts)	484	475
VOC Regulatory (lbs/Gal) (less water, less exempts)	4.04	3.96
Density (g/L)	970	995
Density (lbs/Gal)	8.09	8.3
Volatiles wt. %	50.3	53.6
Water wt. %	0.0	0.0
Exempt wt. %	0.9	9.4
Water vol. %	0.0	0.0
Exempt vol. %	1.1	7.3
Solids vol. %	42.6	43.3
Solids wt. %	49.7	46.4
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	683	695

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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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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