



PDS N5.9.8

June 2018

AQUABASE[®] PLUS P190-6920 Production Clearcoat - National Rule

For National Rule Markets

PRODUCT DESCRIPTION

AQUABASE[®] Plus P190-6920 Production Clearcoat is designed for use with Aquabase Plus Waterborne Basecoat. Optimized for a repair area up to 4 panels, P190-6920 Production Clearcoat meets the throughput demands of high performing shops by consistently delivering a premier finish with exceptional image retention.







P190-6920 is manufactured with a high solids resin that reduces material usage, lowers VOC emissions and is available for use in all regions of North America.

Products	
P190-6920	Production Clearcoat
P210-6975	Mid-Temperature Hardener
P850-1693/-1694/-1695 P850-6910/-6911/-6912/-6914	Thinners
P100-2020	Flexible Additive
SL814	Universal Flexibilizer
P273-1086	Fisheye Preventer
SL93LV	Accelerator

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

Production Clearcoat

PROCESS

MIX RATIO 	<div> <div>P190-6920</div> <div>P210-6975</div> <div>P850-169x</div> <div>P850-691x</div> </div> <div> <div>Clearcoat</div> <div>Hardener</div> <div>Thinner</div> </div> <div> <div>3 parts</div> <div>1 part</div> <div>1 part</div> </div> <p>P850-6914 is the required retarder for all markets Thinner selection available in the online catalog under ABPTS010NR Nexa NR Thinner Guide</p>
POTLIFE 	<div> <div>Sprayable Pot Life:</div> <div>45 minutes at 70°F (21°C)</div> </div> <div> <div>Viscosity:</div> <div>15 seconds DIN #4 at 70°F (21°C)</div> </div>
SPRAYGUN & AIR PRESSURE 	<div> <div>Fluid Tip:</div> <div>1.2 - 1.4 mm</div> </div> <div> <div>HVLP:</div> <div>10 PSI cap pressure</div> </div> <div> <div>Compliant:</div> <div>29 - 40 PSI at the gun</div> </div> <p>Note: Refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.</p>
APPLICATION 	<div> <div>Apply:</div> <div>2 medium wet coats</div> </div> <div> <div>Film Builds:</div> <div>Minimum Dry:</div> <div>Maximum Dry:</div> <div>Recommended wet film build per coat:</div> <div>Recommended dry film build per coat:</div> </div> <div> <div>2.0 mils</div> <div>3.5 mils</div> <div>2.0 - 2.5 mils</div> <div>1.0 - 1.5 mils</div> </div>
FLASH TIME 	<div> <div>Between coats:</div> <div>3 - 5 minutes</div> </div>
DRY TIMES 	<div> <div>Air Dry:</div> <div>Dust Free:</div> <div>Air Dry to Re-assemble:</div> </div> <div> <div>30 - 35 minutes at 70°F (21°C)</div> <div>1.5 - 2 hours at 70°F (21°C)</div> </div> <div> <div>Force Dry:</div> <div>Bake:</div> </div> <div> <div>20 minutes at 120°F (49°C)</div> <div>15 minutes at 140°F (60°C)</div> <div>(Metal Temperature)</div> </div> <div> <div>Tape Time:</div> <div>1.5 - 2.5 hours</div> </div> <div> <div>Infrared:</div> <div>NA</div> </div>

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

P190-6920 Production 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 on temperature, air movement and size of repair. Reducer selection guide are available online in bulletin ABPTS010NR *Nexa Autocolor* NR Thinner Guide.

P210-6975	Mid Temperature Hardener
P850-1693	Thinner Mid Temperature
P850-1694	Thinner High Temperature
P850-1695	Thinner Very High Temperature
P850-6910	Low Temperature Thinner
P850-6911	Mid Temperature Thinner
P850-6912	High Temperature Thinner
P850-6914	High Temp-Humidity Thinner

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

P100-2020	Flexible Additive	¼ up to ½ part to RTS quart
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SL814	Universal Flexibilizer	¼ up to ½ part to RTS quart
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Note: P190-6920 does not require the use of P100-2020 but it is recommended. For very flexible or leading edge parts, the addition of P100-2020 or SL814 will improve overall flexibility.

Fisheye Eliminator

P273-1086	Fisheye Preventer	1 oz. to RTS quart
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Accelerator

SL93LV	Accelerator	2% to RTS quart
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RECOATABILITY

P190-6920 Production Clearcoat is recoatable after 2 - 4 hours at 70°F (21°C) air dry or after force dry for 20 minutes at 120°F (49°C) metal temperature and cool down for one hour.

P190-6920 Production Clearcoat must be sanded before recoating with primer, sealer or clear.

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Production Clearcoat

GENERAL PROCESS NOTES

PROCESS NOTES

Fading Out:

After spot repairing, use ONECHOICE® SX840 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	P190-6920 : P210-6975 : P850-169x / P850-691x	P190-6920 : P210-6975 : P850-169x/ P850-691x + P273-1086	P190-6920 : P210-6975 : P850-691x/ P850-691x + SL93LV	P190-6930 : P210-6975 : P850-169x/ P850-691x + P100-2020/ SL814
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 Regulatory (g/L) (less water, less exempts)	243-316	272-339	243-316	265-352
VOC Regulatory (lbs./Gal) (less water, less exempts)	2.03-2.64	2.27-2.83	2.03-2.64	2.21-2.94
Solids vol. %	44.0	42.7	43.2	42.8-45.0
Solids wt. %	43.8-45.7	42.8-44.6	42.8-44.7	43.1-47.2
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	706	685	693	687-722

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.

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