



2.1 VOC High Gloss Clearcoat P390-4005

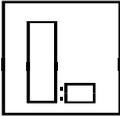
Description P390-4005 is a fast drying, 2.1 VOC high gloss two component polyurethane clearcoat for production shops. It is specifically designed for use over Value-PRO™ VBX Basecoat Colors.

Products	Clearcoat:	P390-4005	2.1 VOC High Gloss Urethane Clear
	Hardeners:	P315-4500	2.1 Clear Hardener - Fast
		P315-4501	2.1 Clear Hardener - Medium
		P315-4502	2.1 Clear Hardener - Slow

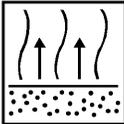
Suitable for use over:
Value-PRO VBX Basecoat

Allow 30 minutes flash time before clearcoating.
VBX Basecoat must be clear coated within 24 hours.

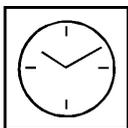
Surface Preparation:
Refer to the data sheet for Value-PRO VBX,

	Mixing	Clearcoat P390-4005 Hardener P315-450X	By Volume: 4 Parts 1 Part	Additives SLV73 Fisheye Preventer 1.2 oz per RTS quart SLV814 Flexible Additive, see page 2 SLV4985 Matting Agent, see page 2
	Pot Life:	1.5 – 2 hours @ 70° F/21°C		

	Application	Conventional gun:	Tip size 1.3 – 1.5 mm Air pressure 50-60 psi at the gun
	HVLP gun:	Tip size 1.3 – 1.5 mm Air pressure 10 psi max at the tip Refer to manufactures inlet pressure requirements	

	Coats	2-3 coats (2.4 - 3.5 mils dry film)	Flash Time 	5-10 minutes between coats @ 70°F/21°C
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Drying



Air Dry @ 70°F/21°C:
With P315-4500 Hardener

Dust Free: 15 - 20 minutes
Tape / Polish: 6 - 8 hours
Into Service: 8 hours or overnight

Air Dry @ 70°F/21°C:
With P315-4501/4502 Hardener

Dust Free: 20 - 30 minutes
Tape / Polish: 6 - 8 hours
Into Service: 8 hours or overnight

Force Dry: 30 minutes @ 140°F/60°C

IR (Infrared): 12-15 minutes

Rectification or Recoat: After "into service" time, 8 hours air dry, overnight, small defects may be sanded out and clearcoat re-applied @ 70°F/21°C or after force dry with a 90 minute cool down.

Process Notes

For Value-PRO VBX Basecoat, the maximum time to clearcoat is 24 hours. If left longer, scuff thoroughly and apply additional basecoat before applying clearcoat.

Clean up equipment immediately after use, using Value-PRO General Purpose Solvent or another suitable solvent. Dispose of waste in accordance with applicable regulations.

Properties

RTS Combinations:	P390-4005 : MH450X	P390-4005 : P315-450X : SLV814	P390-4005 : SLV4985 : P315-450X	P390-4005 : SLV4985 : P315-450X	P390-4005 : SLV4985 : P315-450X
Volume Ratio:	4 : 1	4 : 1 : 1/2	4 : 9 : 1	4 : 5 : 1	4 : 3 : 1
Applicable Use Category	Clear Coating	Clear Coating (Flexible)	Clear Coating (Flat)	Clear Coating (Eggshell)	Clear Coating (Semi-gloss)
VOC Actual (g/L)	100	95	92	103	113
VOC Actual (lbs/gal)	0.84	0.79	0.77	0.87	0.95
VOC Regulatory (less water less exempt) (g/L)	248	237	246	247	248
VOC Regulatory (less water less exempt) (lbs/gal)	2.07	1.98	2.05	2.06	2.07
Density (g/L)	1112	1123	1171	1149	1129
Density (lbs/gal)	9.28	9.37	9.77	9.59	9.42
Volatiles wt. %	70.4	70.7	72.9	69.8	67.0
Water wt. %	0.0	0.0	0.0	0.0	0.0
Exempt wt. %	61.4	62.3	64.9	60.8	57.0
Water vol. %	0.0	0.0	0.0	0.0	0.0
Exempt vol. %	59.7	60.1	62.2	57.9	54.1
Solids vol. %	28.7	29	26.9	29.9	32.6
Sq Ft. Coverage / U.S.gal. 1 mil. @ 100% transfer efficiency	460	465	431	480	523

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

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION:

USA (412) 434-4515; CANADA (514) 645-1320; MEXICO 91-800-00-214