



**AUTOCOLOR**

**PDS N5.9.4**  
**January 2011**

## ***P910-5510*** ***Waterborne Clearcoat***

### **PRODUCT DESCRIPTION**

P910-5510 Acrylic Urethane Waterborne Clearcoat is based on the latest waterborne technology which has been optimized for use over Aquabase® Plus Waterborne basecoat. It delivers a full waterborne basecoat / clearcoat alternative for collision centers that wish to be on the cutting edge of the latest refinish technology as well as minimizing their VOC emissions. The simple application produces a high quality appearance from the gun with easy polishing.

*Designed for use with*

***Aquabase***  
**PLUS**

**RM5510**

## ***WATERBORNE CLEARCOAT***

### **PRODUCTS**

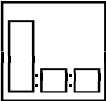
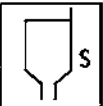


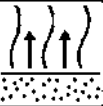

***P910-5510            WATERBORNE CLEARCOAT***

***P210-8860            WATERBORNE HARDENER***

***P980-5000            WATERBORNE THINNER***

**THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY**

# PROCESS

<p><b>MIX RATIO</b></p> 	<p><b>Clearcoat</b> P910-5510                      <b>5 parts</b></p> <p><b>Hardener</b> P210-8860                      <b>2 parts</b></p> <p><b>Reducer</b> P980-5000                      <b>2 parts</b></p> <p><i><b>Stir well Before Thinning</b></i></p>
<p><b>VISCOSITY &amp; POT LIFE</b></p> 	<p><b>20-21 seconds</b> DIN 4 @ 70°F (21 °C) Note: Initial viscosity after mixing may be higher but this will not effect application.</p> <p><b>Pot Life: 2 hours @ 70°F (21 °C)</b> Note: Pot life will be shortened with increased temperatures</p>
<p><b>SPRAY GUN AND AIR PRESSURE</b></p> 	<p>1.1 - 1.3 Fluid tip Max 10 psi cap press.</p> <p>For best overall results, refer to gun manufacturer's recommendations for optimum inlet air pressure. When using a disposable spray gun cup, a vented cup system is preferred.</p>
<p><b>APPLICATION</b></p> 	<p>Apply 1 even light coat followed by 1 full coat with 1 minute flash between coats to give 2-2.5 mils of dry film build. The first coat should be applied to all repair panels before the second coat is applied. Avoid heavy wet coats trying to achieve a full flow out of the spray gun. The clearcoat will flow during the flash off and when baking. The use of air assisted drying air to speed up flash time is not recommended as this may cause dieback or solvent pop.</p>
<p><b>FLASH-OFF</b></p> 	<p>Allow to flash until the clearcoat becomes completely transparent with no milky appearance before baking.</p>
<p><b>DRYING TIME</b></p> 	<p>Force Dry @ 140°F (60 °C) Metal temperature 40 minutes</p>

# WATERBORNE CLEARCOAT

## Weight Activation Chart for P910-5510 Waterborne Clearcoat

Final Ready for Use Volume	Cumulative Weight in Grams 5:2:2		
	P910-5510 Clear	P210-8860 Hardener	P980-5000 Thinner
1/4 Pint / 4 oz.	68.1	95.9	122.1
1/2 Pint / 8 oz.	136.2	191.7	244.0
3/4 Pint / 12 oz.	204.4	287.7	366.2
1 Pint / 16 oz.	272.5	383.5	488.1
1.5 Pint / 20 oz.	408.7	575.2	732.1
1.75 Pints / 28 oz.	476.8	671.1	854.2
1 Quart / 32 oz.	544.9	766.9	976.1
1.5 Quart / 40 oz.	817.4	1150.4	1464.2
2 Quart / 64 oz.	1089.8	1533.8	1952.2

### SUBSTRATES

P910-5510 Waterborne Clearcoat can be applied over Aquabase Plus Waterborne Basecoat after allowing for proper dry time.

### PLASTICS APPLICATION

When used on plastic parts, P910-5510 does not require the use of a flexible additive.

### RECOATABILITY

After force dry and cool down, P910-5510 must be sanded before recoating with primer, color or clear.

### POLISHING

After bake @140°F (60°C) metal temperature and cool down. Polishing is not normally required. If, however, polishing is required to remove minor dirt nibs, start with P1200 followed by P1500 and then P3000 to be sure all P1500 grit scratches are completely removed before polishing. Using low speed, follow normal polishing procedures. Polishing will be easiest between six hours or over night after baking.

# WATERBORNE CLEARCOAT

## PROCESS NOTES

For optimum performance, paint systems should not be applied cold. For best results, allow adequate time for paint to reach 70°F (21 °C).

### Fading Out

After spot repairing with Aquabase Plus Waterborne Basecoat, P910-5510 Waterborne Clearcoat must be applied to full panels only. There is not a blending recommendation for P910-5510 clearcoat.

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## EQUIPMENT CLEANING

P980-8212 Aquabase Plus Waterborne Gun Wash

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## PERFORMANCE SPECIFICATIONS

RTS Combinations:	P910-5510 : P210-8860 : P980-5000
Volume Ratio:	5 : 2 : 2
Applicable Use Category	Clear Coating
VOC Actual (g/L)	126
VOC Actual (lbs/gal)	1.06
VOC Regulatory (less water less exempt) (g/l)	250
VOC Regulatory (less water less exempt) (lbs/gal)	2.09
Density (g/L)	1033
Density (lbs/gal)	8.62
Volatiles wt. %	60.2
Water wt. %	48.0
Exempt wt. %	0.0
Water vol. %	49.6
Exempt vol. %	0.0
Solids vol. %	36.3
Sq Ft. Coverage / U.S.gal. 1 mil. @ 100% transfer efficiency	582

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