

PDS N5.11C

May 2005

A technician wearing a white protective suit and a respirator mask is using a spray gun to apply a clear coat to the front of a car. The car's headlight and wheel are visible in the background.

**P190-6530
HS PLUS CLEARCOAT**

PRODUCT DESCRIPTION

P190-6530 HS Plus Clearcoat is a 2-pack high performance low VOC acrylic urethane clear, which provides a fast, easy to apply, high gloss and very durable finish.

VOC COMPLIANCE

When used according to the recommendations set out in this datasheet, these products will comply with 3.5/gal VOC limits for base clear finishes.

- Easy application = consistent results
- HS Plus system = labor and material savings
- Versatility = Performance in multiple environments

HS PLUS CLEARCOAT

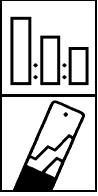



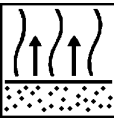

PRODUCTS

P190-6530	HS PLUS CLEARCOAT
P210-6565	HS Plus Low Temp / Express Hardener
P210-6575	HS Plus Mid Temp Hardener
P210-6585	HS Plus High Temp Hardener
P210-6595	HS Plus Very High Temp Hardener
P850-1691	Thinner - Very Low Temperature
P850-1692	Thinner - Low Temperature
P850-1693	Thinner - Mid-Temperature
P850-1694	Thinner - High Temperature
P850-1695	Thinner - Very High Temperature

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

HS PLUS CLEARCOAT

PROCESS

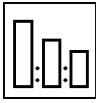
	Standard System	Express System Medium sized repair	Express System Panel / Spot repair Air Dry
MIX RATIO  1A	Clearcoat P190-6530 3 parts Hardener P210-6575,85, 95 1 part Thinner P850-1693,94,95 10%	Clearcoat P190-6530 3 parts Hardener P210-6565,75, 85 1 part Thinner P850-1692,93,94 10%	Clearcoat P190-6530 3 parts Hardener P210-6565,75, 1 part Thinner P850-1691,92,93 10%
Viscosity & Pot Life 	15-17 secs DIN 4 @ 70° F (21° C) 3-4 hrs Pot Life @ 70° F (21° C)	15-17 secs DIN 4 @ 70° F (21° C) 3-4 hrs Pot Life @ 70° F (21° C)	15-17 secs DIN 4 @ 70° F (21° C) 2-3 hrs Pot Life @ 70° F (21° C)
Spray Gun and Air Pressure 	1.3-1.6 (.050-.063) Max 10 psi cap press. Refer to gun manufacturers recommendations for air pressure.	1.3-1.6 (.050-.063) Max 10 psi cap press. Refer to gun manufacturers recommendations for air pressure.	1.3-1.6 (.050-.063) Max 10 psi cap press. Refer to gun manufacturers recommendations for air pressure.
Application 	2 single coats (approx. 2.0-2.5 mils)	2 single coats (approx. 2.0-2.5 mils)	2 single coats (approx. 2.0-2.5 mils)
Flash-off 	5-10 minutes between coats Note: No flash-off is necessary before force drying	5-10 minutes between coats Note: No flash-off is necessary before force drying	5-10 minutes between coats Note: No flash-off is necessary before force drying
Drying Time 	Air Dry @ 70°F (21°C) Dust Free 20 -30 min. Handle 4 - 6 hrs. Polishing 16 hrs Force Dry @ 140° (60°C) P210-6575/85 30 min. P210-6595 40 min.	Air Dry @ 70°F (21°C) Dust Free 15- 25 min. Handle 3- 5 hrs Polishing 12-16 hrs Force Dry @ 140° (60°C) P210-6565 20 min. P210-6575/85 30 min.	Air Dry @ 70°F (21°C) Dust Free 10-20 min. Handle 2- 4 hrs Polishing 6-8 hrs Force Dry @ 140° (60°C) P210-6565 15 min. P210-6575 20 min.

HS PLUS CLEARCOAT

Clearcoating 3-Stage Basecoat



1A



When painting a 3-stage or 4-stage color, P190-6530 must be mixed in the following ratio's to be V.O.C. compliant:

Standard System	Express System Medium sized repair	Express System Panel / Spot repair Air Dry
Clearcoat P190-6530 3 parts	Clearcoat P190-6530 3 parts	Clearcoat P190-6530 3 parts
Hardener P210-6575,85, 95 1 part	Hardener P210-6565,75, 85 1 part	Hardener P210-6565,75, 1 part
Thinner P850-1693,94,95 5%	Thinner P850-1692,93,94 5%	Thinner P850-1691,92,93 5%

Weight Activation Chart for HS Plus Clearcoat P190-6530

Volume of RFU Paint Required	Cumulative Weight		
	Clearcoat	Hardener	Thinner
½ pint	180.0	241.0	259.0
1 pint	360.0	482.0	518.0
1 quart	720.0	964.0	1036.0
2 quart	1440.0	1928.0	2072.0

NOTE: Volume of RFU is 97.5% of the stated volume required

SUBSTRATES

HS Plus Clearcoat, P190-6530 can be applied over 2K Basecoats after Allowing proper dry time.

When using over plastic substrates refer to Plastic Application Process PDS N7.1C.

RECOATABILITY

HS PLUS SYSTEM

HS Plus Clearcoat, P190-6530 used with HS Plus Hardeners, P210-6565, P210-6575, P210-6585 or P210-6595 is fully recoatable after 16 hours air dry 70° F (21°C).

HS Plus Clearcoat, P190-6530 when force dried for recommended times is fully recoatable after cooling down.

HS PLUS CLEARCOAT

POLISHING

Polishing is not normally required. If however polishing is required to remove minor dirt nibs, wet sand with P1500 wet and follow normal polishing procedures.

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).

For blending of HS Plus Clearcoat P190-6530 refer to PDS N7.3C

In the event of fish-eyes, add 1-2 inner capfuls of P273-1086, Fish-Eye Preventer to 1 quart of HS Plus Clearcoat, P190-6530 ready for use.

EQUIPMENT CLEANING

Approved cleaning solvents

2K Performance Specifications

Product:	P190-6530 HS Plus Clearcoat
Category:	Topcoat
VOC As Packaged:	3.38 lbs per gal./406 gm/l
VOC (RTU):	3.50 lbs per gal./420 gm/l
Product:	P273-1086
Category:	Specialty
VOC As Packaged:	7.2 lbs per gal./862 gm/l
Clearcoat Data:	
Weight Solids (RTU):	39.3%
Volume Solids (RTU):	38.0%
Pencil Hardness:	2H
Chemical Resistance:	Excellent

For further information please contact:

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