



## PDS N6.30

July 2005

# **P190-6100 FAST HS CLEARCOAT**

## **PRODUCT DESCRIPTION**

**P190-6100** is a premium quality high solids acrylic urethane clearcoat developed to improve productivity in air dry and low bake environments. Fast HS Clearcoat is designed for repairs up to four panels and offers fast flash, out of dust and polish times without sacrificing appearance or durability.

- Easy Application = consistent results
- HS Clearcoat System = labor and material savings
- Fast Process = Less booth time

## ***FAST HS CLEARCOAT***

### **PRODUCTS**

***P190-6100***

***Fast HS Clearcoat***

***P210-5170***

***Hardener - Low Temperature***

***P210-5185***

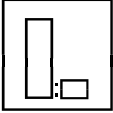



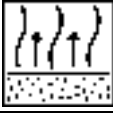

***Hardener - Mid Temperature***

***P210-5195***

***Hardener - High Temperature***

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

# PROCESS

FAST HS CLEARCOAT	
<b>MIX RATIO</b> 	<p><b>Fast HS Clearcoat</b> P190-6100                      <b>4 parts</b></p> <p><b>Hardener</b> P210-51XX                        <b>1 part</b></p>
<b>VISCOSITY &amp; POT LIFE</b> 	<p><b>Viscosity:</b> 12-14 seconds DIN 4 @ 70°F (21°C)</p> <p><b>Pot Life:</b> 1.5 to 2 hours @ 70°F (21°C)</p>
<b>SPRAY GUN &amp; AIR PRESSURE</b> 	<p><b>Siphon:</b> 1.4-1.8mm (.055" - .070") 50-55 psi at the gun.</p> <p><b>Gravity:</b> 1.3-1.6mm (.050" - .063") 50-55 psi at the gun.</p> <p><b>HLVP:</b> 0.8-1.5mm (.031" - .059") Max 10 psi cap press. 3-8 psi fluid press. (pressurised cup)</p> <p><small>(HVLV: Refer to gun manufacturer's recommendations for required inlet pressure.)</small></p>
<b>APPLICATION</b> 	<p><b>2 med. wet coats</b> (approx. 2.4-2.8 mils)</p>
<b>FLASH-OFF</b> 	<p><b>3- 5 minutes</b> between coats</p>
<b>DRYING TIME</b> 	<p><b>Air Dry</b> 1.5 to 2 hours @ 70°F (21°C)</p> <p><b>Force Dry</b> With P210-5170    10 minutes @ 120°F (49°C) Metal temperature With P210-5185/95 10 minutes @ 140°F (60°C) Metal temperature</p> <p><b>Note:</b> No flash-off is necessary before force drying</p>

# FAST HS CLEARCOAT

## WEIGHT MIX RATIOS FOR P190-6100

Fast HS Clearcoat P190-6100 @ 4:1		Mix Ratio By Weight (Cumulative Weight in Grams)			
Product	Ratio	½ Pint	1 Pint	1 Quart	2 Quart
Fast HS Clearcoat P190-6100	4	164	328	680	1362
Hardener P210-51XX	1	212	420	876	1751

**Note:** These weights will produce approximately 97.5% of the 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.

## SUBSTRATES

Fast HS Clearcoat (P190-6100) can be applied over 2K Basecoats after allowing proper dry time.

When using over plastic substrates refer to “Plastics Painting Process,” PDS N7.1.

## RECOATABILITY

Fast HS Clearcoat (P190-6100) used with Hardeners (P210-5170, P210-5185 or P210-5195) is fully recoatable after 4 to 6 hours air dry 70° F (21°C).

Fast HS Clearcoat (P190-6100) when force dried for recommended times is fully recoatable after cooling down.

# ***FAST HS 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.

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## **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 Fast HS Clearcoat (P190-6100) refer to PDS N7.3

In the event of fish-eyes, add 1-2 inner capfuls of P273-1086 (Fish-Eye Preventer) to 1 quart of Fast HS Clearcoat (P190-6100) Ready-for-Use.

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## **EQUIPMENT CLEANING**

Approved cleaning solvents

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## **2K PERFORMANCE SPECIFICATIONS**

<b>Product:</b>	P190-6100 Fast HS Clearcoat
<b>Category:</b>	Topcoat
<b>VOC As Packaged:</b>	4.77 lbs per gal/572gm/l
<b>VOC As Packaged: (Less Exempt)</b>	4.31 lbs per gal/516 gm/l
<b>VOC (RFU) @ 4:1</b>	4.35 lbs per gal/521gm/l
<b>VOC (RFU) @ 4:1 (Less Exempt)</b>	3.98 lbs per gal/ 477gm/l
<b>Weight Solids (RFU):</b>	45.05% @ 4:1
<b>Volume Solids (RFU):</b>	38.09% @ 4:1
<b>Theoretical Sq. Ft. Coverage</b>	610 sq. ft per gal. @ 1 mil RFU, 100% transfer efficiency

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