

**PDS N6.3.1**

July 2004

P190-6330 HS PRODUCTION CLEARCOAT

Product Description

P190-6330 HS Production Clearcoat is a premium quality high solids acrylic urethane clearcoat specifically formulated to meet the demands of today's high production collision centers. With lower bake temperatures and shorter cycle times, HS Production Clearcoat increases throughput which also improves shop productivity while maintaining a premium quality finish.

- **Easy Application = Consistent Results**
- **HS Clearcoat = Material Savings**
- **Shorter Cycle Times = Increased productivity**

HS PRODUCTION CLEARCOAT

PRODUCTS

P190-6330

HS Production Clearcoat

P210-6370

Low Temperature Hardener

P210-6385

Mid Temperature Hardener

P210-6395

High Temperature Hardener

P850-1692

Thinner – Low Temperature

P850-1693

Thinner – Mid Temperature

P850-1694

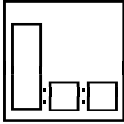
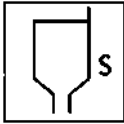


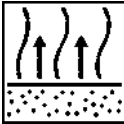
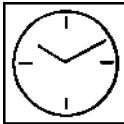
Thinner – High Temperature

P850-1695

Thinner – Very High Temperature

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

<p>MIX RATIO</p> 	<p>Clearcoat P190-6330 3 parts</p> <p>Hardener P210-63XX 1 part</p> <p>Thinner P850-169X 1 part</p>
<p>POT LIFE</p> 	<p>Pot Life: 3 to 4 hours @ 70°F (21°C)</p>
<p>SPRAY GUN & AIR PRESSURE</p> 	<p>Siphon: 1.4-1.8mm (.055" - .070") 50-55 psi at the gun.</p> <p>Gravity: 1.3-1.6mm (.050" - .063") 50-55 psi at the gun.</p> <p>HLVP: 0.8-1.5mm (.031" - .059") Max 10 psi cap press. 3-8 psi fluid press. (pressurized cup)</p> <p><small>(HLVP: Refer to gun manufacturer's recommendations for required inlet pressure.)</small></p>
<p>APPLICATION</p> 	<p>2 medium wet coats (Approximately. 2.4-2.6 mils)</p>
<p>FLASH-OFF</p> 	<p>5-10 minutes between coats</p>
<p>DRYING TIME</p> 	<p>Air Dry 4 hours @ 70°F (21°C) or overnight</p> <p>Force Dry</p> <p>With P210-6370 10 minutes @ 120°F (49°C) Metal temperature</p> <p>With P210-6385 15 minutes @ 140°F (60°C) Metal temperature</p> <p>With P210-6395 20 minutes @ 140°F (60°C) Metal temperature</p> <p>Note: No flash-off is necessary before force drying</p>

HS PRODUCTION CLEARCOAT

WEIGHT MIX RATIOS FOR P190-6330

Clearcoat P190-6330 @ 3:1:1			Mix Ratio By Weight (Cumulative Weight in Grams)			
Product	Ratio		½ Pint	1 Pint	1 Quart	2 Quart
Clearcoat P190-6330	3		136.2	272.4	544.8	1089.6
Hardener P210-63XX	1		187.2	374.5	749.0	1498.0
Thinner P850-169X	1		225.8	451.6	903.2	1806.4

SUBSTRATES

P190-6330 Clearcoat can be applied over 2K Basecoat color after allowing proper dry time.

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

RECOATABILITY

P190-6330 Clearcoat used with Hardeners P210-6370, P210-6385 and P210-6395 is fully recoatable after 4 to 6 hours air dry 70° F (21°C).

When forced dried, P190-6330 is fully recoatable after cool down.

POLISHING

If polishing is required when forced dried, P190-6330 Clearcoat may be sanded and polished after cool down. If it has been air dried, sanding and polishing may be done after 4 hours @ 70°F (21°C). Using P1500 wet or finer, both forced and air dried systems may be wet sanded followed by normal polishing procedures using either a foam or wool pad.

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 P190-6330, 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 P190-6330 Ready-for-Use.

HS PRODUCTION CLEARCOAT

EQUIPMENT CLEANING

Approved cleaning solvents

2K PERFORMANCE SPECIFICATIONS

Product:	P190-6330 HS Production Clearcoat
Category:	Topcoat
VOC As Packaged:	3.79 lbs per gal/ 455 gm/l
VOC As Packaged: (Less Exempt)	3.32 lbs per gal/ 398 gm/l
VOC (RFU) @ 3:1:1	4.18 lbs per gal/ 502 gm/l
VOC (RFU) @ 3:1:1 (Less Exempt)	3.89 lbs per gal/ 467 gm/l
Theoretical Sq. ft. Coverage	656 sq. ft per U.S. gal. @ 1 mil RFU, 100% transfer efficiency

For further information please contact:

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