



**PDS N5.9.4C**

**December 2011**

## **P190-6800 HS EXPRESS CLEARCOAT**

### **PRODUCT DESCRIPTION**

P190-6800 HS Express Clearcoat is a high quality urethane clearcoat specifically developed for use over Aquabase<sup>®</sup> Plus and 2K<sup>®</sup> basecoats. This clearcoat, with it's no bake requirements and zero flash between coats, dramatically reduces cycle times while maintaining the quality and appearance required by high production shops.

HS Express Clearcoat is designed for use on repairs of 1- 4 panels offering extremely fast flash, polish and air dry times without sacrificing durability or appearance.

*Designed for use with*

**Aquabase**  
**PLUS**







## ***HS EXPRESS CLEARCOAT***

### **PRODUCTS**

<b><i>P190-6800</i></b>	<b><i>HS EXPRESS CLEARCOAT</i></b>
<b><i>P210-6875</i></b>	<b><i>HS HARDENER-NORMAL</i></b>
<b><i>P852-1683</i></b>	<b><i>STANDARD ACCELERATED REDUCER</i></b>
<b><i>P850-1775</i></b>	<b><i>SLOW REDUCER</i></b>

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

# PROCESS

<b>HS EXPRESS CLEARCOAT</b>									
<b>MIX RATIO</b>  	<p><b>Clearcoat</b> P190-6800 <b>4 parts</b></p> <p><b>Hardener</b> P210-6875 <b>1 part</b></p> <p><b>Thinner*</b> P852-1683 / P850-1775 / SLV898 <b>1 part</b></p> <p><small>* Thinner selection may be dependent on temperature and or size of repair. For use in extreme temperatures +95°F / +35°C, SLV898 may be used as a replacement up to one full part for P852-1683 or P850-1775 thinners. For VOC data and additional information, see OneChoice™ product bulletin OC-17. Refer to PaintManager™ for exact mix by weight volumes.</small></p>								
<b>VISCOSITY &amp; POT LIFE</b>  	<p style="text-align: center;"><b>12-14 seconds</b> DIN 4 @ 70°F* (21°C)</p> <p>Pot Life With P852-1683 : 1 - 1.5 hours @ 70°F (21°C)            Pot Life With P850-1775 / SLV898 : 2 hours @ 70°F (21°C)</p> <p style="text-align: center;"><small>Note: Pot life will be shortened with increased temperatures</small></p>								
<b>SPRAY GUN AND AIR PRESSURE</b>  	<p style="text-align: center;">1.3-1.5 Max 10 psi cap press.</p> <p style="text-align: center;">Refer to gun manufacturer's recommendations for inlet air pressure.</p>								
<b>APPLICATION</b>  	<p style="text-align: center;">Apply 2 medium wet coats</p> <p style="text-align: center;"><b>Film builds</b></p> <table style="width: 100%; border: none;"> <tr> <td style="width: 60%;">Minimum Dry</td> <td style="width: 40%;">2.0 mils</td> </tr> <tr> <td>Maximum Dry</td> <td>3.0 mils</td> </tr> <tr> <td>Recommended wet film build per coat</td> <td>2.0 - 2.5 mils</td> </tr> <tr> <td>Recommended dried film build per coat</td> <td>1.0 - 1.5 mils</td> </tr> </table>	Minimum Dry	2.0 mils	Maximum Dry	3.0 mils	Recommended wet film build per coat	2.0 - 2.5 mils	Recommended dried film build per coat	1.0 - 1.5 mils
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<b>FLASH-OFF</b>  	<p style="text-align: center;">No flash required between coats</p>								
<b>DRYING TIME</b>  	<p style="text-align: center;"><b>Air Dry @ 70°F (21°C)</b></p> <table style="width: 100%; border: none;"> <tr> <td style="width: 60%;">Dust Free</td> <td style="width: 40%;">10-15 min.</td> </tr> <tr> <td>Air Dry to Re-assemble</td> <td>1 Hour</td> </tr> <tr> <td>Polishing</td> <td>30 - 45 minutes</td> </tr> </table> <p style="text-align: center;"><b>Force Dry @ 140°F (60°C)*</b> N/A (Metal Temperature)</p> <p style="text-align: center;"><b>I-R</b> N/A</p> <p><small>*For in-Service delivery at low temperatures (below 60°F / 16°C) or inclement weather conditions, allow P190-6800 a minimum of 4 hours air dry at shop temperature (above 60°F / 16°C or above) or bake for 10 minutes @ 120°F / 49°C metal temperature and cool for one hour prior to putting into service.</small></p>	Dust Free	10-15 min.	Air Dry to Re-assemble	1 Hour	Polishing	30 - 45 minutes		
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# HS EXPRESS CLEARCOAT

## SUBSTRATES

P190-6800 HS Express Clearcoat can be applied over Aquabase Plus Waterborne and 2K<sup>®</sup> basecoats after allowing proper dry time and properly prepared and cleaned original equipment finishes and fully cured refinish paints.

## OPTIONAL ADDITIVES

### Flexible Additive

P190-6800	HS Express Clearcoat	5 Parts
P100-2021	LV Flexible Additive	1 Part

This mixture should then be activated and thinned as normal @ 4:1:1

**Note:** When used on plastic parts, P190-6800 does not require the use of P100-2021. However, for very flexible or leading edge parts such as bumper covers and fascias, the addition of P100-2021 will improve overall flexibility. For flattening recommendations, see OneChoice<sup>®</sup> bulletin OC-7

### Fisheye Eliminator

SLV73	Fisheye Eliminator	1 oz. per ready to spray quart
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## RECOATABILITY

2 - 3 hours at 70°F (21°C) air dry or after force dry for 10 minutes @ 120°F / 49°C metal temperature and cool down for one hour. P190-6800 must be sanded before recoating with primer, color or clear.

## POLISHING

30 - 45 minutes at 70°F (21°C). Polishing is not normally required. If, however, polishing is required to remove minor dirt nibs, sand with P1500 or finer and follow normal polishing procedures.

# HS EXPRESS 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, Use OneChoice® SLV840 blending solvent and apply starting from the outside of the repair moving towards the center of the repaired area to lose the clearcoat blend edge.

## EQUIPMENT CLEANING      Approved Cleaning Solvent

## PERFORMANCE SPECIFICATIONS

RTS Combinations:	P190-6800 : P210-6875 : P852-1683	P190-6800 : P210-6875 : P850-1775	(Pre mix P190-6800 : P100-2021 at 5 : 0.5 ratio) P190-6800 : P210-6875 : P852-1683	(Pre mix P190-6800 : P100-2021 at 5 : 0.5 ratio) P190-6800 : P210-6875 : P850-1775
Volume Ratio:	4 : 1 : 1	4 : 1 : 1	4 : 1 : 1 +10%	4 : 1 : 1 +10%
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating (flexed)	Clear Coating (flexed)
VOC Actual (g/L)	118	104	111	105
VOC Actual (lbs/gal)	0.99	0.87	1.00	0.88
VOC Regulatory (less water less exempt) (g/l)	249	226 - 228	244	223
VOC Regulatory (less water less exempt) (lbs/gal)	2.08	1.89 - 1.90	2.04	1.86
Density (g/L)	1093	1073 - 1119	1100	1080 - 1126
Density (lbs/gal)	9.12	8.95 - 9.34	9.18	9.01 - 9.40
Volatiles wt. %	65.2	64.6 - 66.1	64.1	63.4 - 64.9
Water wt. %	0.1	0.1	0.1	0.1
Exempt wt. %	54.4	54.9 - 56.8	53.2	53.7 - 55.6
Water vol. %	0.1	0.1	0.1	0.1
Exempt vol. %	52.9	54.4	51.6	53.0 - 53.1
Solids vol. %	33.6	33.5	34.8	34.8
Sq Ft. Coverage / U.S.gal. 1 mil. @ 100% transfer efficiency	539	538	558	558

For further information please contact:

**Nexa Autocolor-USA**  
19699 Progress Drive  
Strongsville, OH 44149

**Nexa Autocolor-Canada**  
2301 Royal Windsor Drive Unit #6  
Mississauga, Ontario L5J 1K5

