



PDS N5.10C

June 2008

P190-6730 HS PLUS CLEARCOAT

PRODUCT DESCRIPTION

2K[®] P190-6730 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 2.1/gal VOC limits for basecoat clearcoat finishes.

- Easy Application = Consistent results
- HS Plus System = Labor and material savings
- Versatility = Performance in multiple environments
- Fast Process Times = Increased through-put
- Durable, high gloss = Customer satisfaction

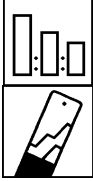



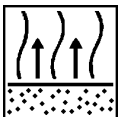

HS PLUS CLEARCOAT

PRODUCTS

| | |
|-------------------------|---|
| <i>P190-6730</i> | <i>HS PLUS CLEARCOAT</i> |
| <i>P210-6565</i> | <i>HS PLUS LOW TEMP / EXPRESS HARDENER</i> |
| <i>P210-6575</i> | <i>HS PLUS MID TEMP HARDENER</i> |
| <i>P210-6585</i> | <i>HS PLUS HIGH TEMP HARDENER</i> |
| <i>P210-6595</i> | <i>HS PLUS VERY HIGH TEMP HARDENER</i> |
| <i>P850-1775</i> | <i>HS PLUS MID-TEMP REDUCER</i> |

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

| | Standard System | Express System Medium sized repair | Express System Panel / Spot Repair Air Dry |
|---|---|--|--|
| MIX RATIO  1A | Clearcoat P190-6730 3 parts Hardener P210-6575/85/95 1 part Thinner P850-1775 10% | Clearcoat P190-6730 3 parts Hardener P210-6565/75/85 1 part Thinner P850-1775 10% | Clearcoat P190-6730 3 parts Hardener P210-6565/75 1 part Thinner P850-1775 10% |
| VISCOSITY & POT LIFE  | 15-17 seconds DIN 4 @ 70°F (21°C) Pot Life: 3-4 hrs @ 70°F (21°C) | 15-17 seconds DIN 4 @ 70°F (21°C) Pot Life: 3-4 hrs @ 70°F (21°C) | 15-17 seconds DIN 4 @ 70°F (21°C) Pot Life: 2-3 hrs @ 70°F (21°C) |
| SPRAY GUN AND AIR PRESSURE  | 1.3-1.6 (.050-.063) Max 10 psi cap press. Refer to gun manufacturer's recommendations for air pressure. | 1.3-1.6 (.050-.063) Max 10 psi cap press. Refer to gun manufacturer's recommendations for air pressure. | 1.3-1.6 (.050-.063) Max 10 psi cap press. Refer to gun manufacturer's 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°F (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°F (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°F (60°C) P210-6565 15 min. P210-6575 20 min. |

HS PLUS CLEARCOAT

Weight Activation Chart for HS Plus Clearcoat P190-6730

| Volume of RFU Paint Required | Cumulative Weight | | |
|---------------------------------|---------------------|--------------------|-------------------|
| | P190-6730 Clearcoat | P210-65XX Hardener | P850-1775 Thinner |
| ½ Pint | 205.0 | 252.0 | 275.0 |
| 1 Pint | 410.0 | 504.0 | 550.0 |
| 1 Quart | 819.0 | 1009.0 | 1100.0 |
| 2 Quart | 1638.0 | 2018.0 | 2200.0 |

Note: Volume of RFU is 97.5% of the stated volume required.

SUBSTRATES

HS Plus Clearcoat, P190-6730 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, P190-6730 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 (P190-6730) when force dried for recommended times is fully recoatable after cooling down.

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.

HS PLUS 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).

For blending of HS Plus Clearcoat (P190-6730), 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 Ready-for-Use.

EQUIPMENT CLEANING

Approved Cleaning Solvent

2K PERFORMANCE SPECIFICATIONS

| | |
|---|-----------------------------------|
| RTS Combinations: | P190-6730 : P210-65X5 : P850-1775 |
| Volume Ratio: | 3 : 1 + 10 % |
| Applicable Use Category | Clear Coating |
| VOC Actual (g/L) | 126 |
| VOC Actual (lbs/gal) | 1.05 |
| VOC Regulatory (less water less exempt) (g/L) | 244-246 |
| VOC Regulatory (less water less exempt) (lbs/gal) | 2.04-2.05 |
| Density (g/L) | 1190-1192 |
| Density (lbs/gal) | 9.93-9.95 |
| Volatiles wt. % | 65.2 |
| Water wt. % | 0.0 |
| Exempt wt. % | 54.6 |
| Water vol. % | 0.0 |
| Exempt vol. % | 48.4-48.5 |
| Solids vol. % | 36.8-36.9 |
| Sq Ft. Coverage / U.S.gal. 1 mil. @ 100% transfer efficiency | 590-592 |

For further information please contact:

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