



**PDS N5.10C**

June 2008

## **P190-6730 HS PLUS CLEARCOAT**

### **PRODUCT DESCRIPTION**

2K<sup>®</sup> 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

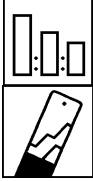



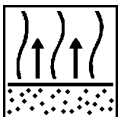

## ***HS PLUS CLEARCOAT***

### **PRODUCTS**

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

**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
<b>MIX RATIO</b>  <b>1A</b>	<b>Clearcoat</b> P190-6730 <b>3 parts</b>  <b>Hardener</b> P210-6575/85/95 <b>1 part</b>  <b>Thinner</b> P850-1775 <b>10%</b>	<b>Clearcoat</b> P190-6730 <b>3 parts</b>  <b>Hardener</b> P210-6565/75/85 <b>1 part</b>  <b>Thinner</b> P850-1775 <b>10%</b>	<b>Clearcoat</b> P190-6730 <b>3 parts</b>  <b>Hardener</b> P210-6565/75 <b>1 part</b>  <b>Thinner</b> P850-1775 <b>10%</b>
<b>VISCOSITY &amp; POT LIFE</b> 	<b>15-17 seconds</b> DIN 4 @ 70°F (21°C)  <b>Pot Life:</b> 3-4 hrs @ 70°F (21°C)	<b>15-17 seconds</b> DIN 4 @ 70°F (21°C)  <b>Pot Life:</b> 3-4 hrs @ 70°F (21°C)	<b>15-17 seconds</b> DIN 4 @ 70°F (21°C)  <b>Pot Life:</b> 2-3 hrs @ 70°F (21°C)
<b>SPRAY GUN AND AIR PRESSURE</b> 	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.
<b>APPLICATION</b> 	<b>2 single coats</b> (approx. 2.0-2.5 mils)	<b>2 single coats</b> (approx. 2.0-2.5 mils)	<b>2 single coats</b> (approx. 2.0-2.5 mils)
<b>FLASH-OFF</b> 	<b>5-10 minutes</b> between coats.  <b>Note:</b> No flash-off is necessary before force drying.	<b>5-10 minutes</b> between coats  <b>Note:</b> No flash-off is necessary before force drying.	<b>5-10 minutes</b> between coats  <b>Note:</b> No flash-off is necessary before force drying.
<b>DRYING TIME</b> 	<b>Air Dry @ 70°F (21°C)</b> Dust Free    20-30 min. Handle        4-6 hrs. Polishing     16 hrs.  <b>Force Dry @ 140°F (60°C)</b> P210-6575/85    30 min. P210-6595        40 min.	<b>Air Dry @ 70°F (21°C)</b> Dust Free    15-25 min. Handle        3-5 hrs. Polishing     12-16 hrs.  <b>Force Dry @ 140°F (60°C)</b> P210-6565        20 min. P210-6575/85    30 min.	<b>Air Dry @ 70°F (21°C)</b> Dust Free    10-20 min. Handle        2-4 hrs. Polishing     6-8 hrs.  <b>Force Dry @ 140°F (60°C)</b> 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

<b>RTS Combinations:</b>	P190-6730 : P210-65X5 : P850-1775
<b>Volume Ratio:</b>	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:

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

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