



HS Clearcoat P390-4000

Description P390-4000 is a modern, high solids urethane clearcoat for auto refinsh. It is specifically designed for use over Value-PRO™ Basecoat Colors (VB), and may also be used over Value-PRO VU.

Products	Clearcoat:	P390-4000	
	Hardener for Clearcoats:	P315-3511	
	Thinner:	P830-2065	Fast
		P830-2075	Medium
		P830-2085	Slow
		P830-2095	Extra Slow
P830-2097		Super Slow	

Suitable for use over:

Value-PRO VB/VBP Basecoat Colors. Allow at least 20 minutes flash time before clearcoat.

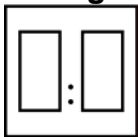
Value-PRO VU 2 Pack Urethane Colors. Allow 30 minutes to 1 hour air dry and no more than 5 days before clearcoat.

May also be incorporated into the final coat of VU color for improved gloss and durability. Add up to 25% by volume of **ACTIVATED** P390-4000 clearcoat to the final coat of **ACTIVATED** Value-PRO VU color.

Surface Preparation:

Refer to the data sheet for Value-PRO VB / VBP (RM 2610) or VU (RM 2609).

Mixing



Clearcoat: P390-4000
Hardener: P315-3511
Thinner: P830-20XX

By

volume:

4 Parts
1 Part
1 Parts

Additives - see datasheet RM 2620

- P300-9002 Accelerator
- P300-9003 Potlife Extender
- P300-9004 Fisheye Preventer
- P300-9005 Flexible Additive
- P300-3199 Matting Agent

Pot Life:

3 hours


Matting Agent P350-3199:


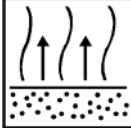
If a low gloss finish is required, add Matting Agent to the clearcoat prior to activating and thinning.


Semi-gloss: Add 50% P350-3199 = 1 part Matting Agent to 2 parts Clearcoat.

Matt: Add 60% P350-3199 = 3 parts Matting Agent to 5 parts Clearcoat.

Activate and thin the above mixtures as normal 4:1:1

Application 	Conventional gun:	Tip size 1.3 – 1.6 mm Air pressure 50-60 psi at the gun
	HVLP gun:	Tip size 1.2 – 1.5 mm Air pressure 10 psi max at the tip HVLP: Refer to manufacturer's inlet pressure requirements

Coats 	2 coats	Flash Time 
	(2.0-2.5 mils dry film)	

Drying 	Air Dry (@ 70°F/21°C):	Dust Free: 60-80 minutes
		Tack Free: 2½-3½ hours
		Tape Free: 12 hours
		Polish / Into Service: 16 hours (overnight)
	Force Dry:	30 minutes @ 140°F/60°C Polish / Into Service: after 2 hours
	Infra Red (medium wave)	12-15 minutes
	Rectification or Recoat	After "into service" times / air dry After 2 hours cool down / force dry

Process Notes

For Value-PRO VB / VBP basecoat, the maximum time to clearcoat is 24 hours. If left longer, scuff thoroughly and apply additional basecoat before applying clearcoat.

For Value-PRO VU 2 Pack Urethane, the maximum time to clearcoat is 5 days. If left longer, scuff thoroughly before applying clearcoat

Clean up equipment immediately after use, using thinner Value-PRO or another suitable solvent. Dispose of waste in accordance with applicable regulations

VOC	Package = 4.2 lb/gal, Applied (4:1:1) = 4.3 lb/gal
Coverage	626 sq. ft. / gal, at 1 mil dry film.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION:

USA (412) 434-4515; CANADA (514) 645-1320; MEXICO 91-800-00-214