



## TECHNICAL DATASHEET

### PERFORMANCE PLUS 4:1

**ART. NO:** #190.115 (1G)

PERFORMANCE PLUS 4:1 is a premium polyurethane clear coat designed for overall car refinishing as well as multi-panel purposes and single panel applications. It has excellent gloss retention, leveling and cure properties and can be air dried or force dried. The simple 4:1 mix ratio makes this clear easy to use and it can be applied directly on all water and solvent based base coats.

#### FEATURES

- ✓ Easy to use
- ✓ Excellent leveling
- ✓ Superb blending
- ✓ Excellent gloss retention
- ✓ Can be applied to flexible parts
- ✓ Guaranteed performance

#### COMPATIBLE SURFACES

- ✓ Water & Solvent base coats
- ✓ Activated polyurethane enamel (must be cured at least 8 hours)
- ✓ Activated acrylic urethane enamel (must be cured at least 8 hours)
- ✓ OEM clear coats (must be sanded with P800)

#### CONDITIONS OF USE AND CONFORMITY

The before mentioned technical data and information, especially the recommendations for applying and using our products, are based on our current knowledge and experience when applied under normal conditions. In practice, the materials, surfaces or site conditions are so different that no warranty regarding the working results or liability, arising out of any relationship, can be inferred neither from this information nor from a verbal consultation, except we are charged with intent or gross negligence. In this case the user is obliged to prove that he has informed us about all points required for a proper and promising judgement in writing, in time and completely. Patent rights of any third party are to be observed. Furthermore, our general sales and delivery Terms and Conditions and the latest Technical Data Sheet, which should be demanded, apply.

#### HEALTH & SAFETY

See Safety Data Sheet and labels for additional safety information and handling instructions. Directions for handling and waste disposal are in our Material Safety Data Sheet and the specifications of the Employers Liability Insurance Association for the chemical industry.

Product (Part A) VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
	g/L	LBS/GAL
Actual VOC	613.14	5.12
Regulatory VOC (less water & exempt solvents)	613.14	5.12
Density	970	8.10
	WEIGHT %	VOLUME %
Total Solid Content	37%	38%
Total Volatile Content	63%	62%
Water	0%	0%
Exempt Compound Content	0%	0%

Hardener (Part B) VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
	g/L	LBS/GAL
Actual VOC	617.51	5.15
Regulatory VOC (less water & exempt solvents)	617.51	5.15
Density	990	8.26
	WEIGHT %	VOLUME %
Total Solid Content	38%	38%
Total Volatile Content	62%	62%
Water	0%	0%
Exempt Compound Content	0%	0%

RTS VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
Coating Category	Clear Coating	
Mixing Ratio	4:1	
	g/L	LBS/GAL
Actual VOC	614.01	5.12
Regulatory VOC (less water & exempt solvents)	614.01	5.12
Density	974.00	8.13
	WEIGHT %	VOLUME %
Total Solid Content	37.2%	38.0%
Total Volatile Content	62.8%	62.0%
Water	0%	0%
Exempt Compound Content	0%	0%

#### PRODUCT DATA

**Dry Film Thickness / coat (DFT):** 0.8

**Coverage:** 513 Sq. Ft. / gal @ 1 mil\*

**Shelf Life:** 24 months

**Package:** 1 Gallon

**Number per case:** 4

Safety Data Sheet (SDS) is available on our website

## TECHNICAL DATASHEET



### HANDLING

#### MIXING

Make sure product is at room temperature 72°F (22.2°C) before mixing

**4 Parts Clear Coat:** #190.115 (1G)

**1 Part Activator:** #191.230.S (1QT) - Slow  
#191.230.M (1QT) - Medium  
#191.230.F (1QT) - Fast



#### POT LIFE

3 hours @ 70°F (20°C)



#### GUN SETUP

Conventional Gravity: 1.2mm - 1.3mm 40 - 45 psi @ gun

Siphon: 1.2mm - 1.3mm 40 - 45 psi @ gun

HVLP gravity: 1.2mm - 1.3mm 8 - 10 psi @ gun

Mini-Jet Gravity Fed: 1.0mm - 1.3mm 8 - 10 psi @ gun

Fluid Adjustment for 1.2 mm nozzle: turn out 3 full turns

Fluid Adjustment for 1.3 mm nozzle: turn out 2 ½ turns

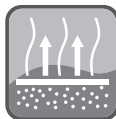


#### APPLICATION

1. Apply base coat color as per recommended procedures
2. Apply 2 full wet coats with 10 - 15 minutes flash time in between coats

#### BLENDING

1. Apply first coat of clear coat
2. Extend second coat of clear past first coat
3. After the final coat of clear melt in the edge by applying a blending solvent



#### FLASH TIME

**Between coats:** 10 - 15 minutes

**Before force dry:** 15 minutes



#### DRY TIMES

**Dust Free:** 15 - 20 minutes depending on temperature and activator selection

**Force Dry:** 25 - 35 minutes @ 140°F (60°C)

**Air Dry:** 1h 30 min - 4h @ 70° F depending on temperature and activator selection

**Time to decal:** 48 hours

**Time to deliver:** 8 - 10 hours air dry or 1 hour after cool down when forced dry



#### SANDING & BUFFING

**Optimum Times:** **Force Dry:** 45 min after cool down

**Air Dry:** 8 - 14 hours



#### Sanding:

Use 1500 grit or finer wet sandpaper or use a foam interface pad with P1500 grit or finer DA paper.

#### Polishing:

Using polishing foam pad apply a ribbon of material to work a 2-3 foot square area. Maintain buffer speed at 1500-2200 rpm. Keep buffer moving at all times overlapping approximately 50% each pass. Wipe off excess compound with clean soft cloth. Hand buff with clean soft cloth as a finishing touch.