



# RIVAL™ RV500™ Polyurethane Clearcoat



## GENERAL

### DESCRIPTION

A two-component, polyurethane clearcoat for use in overall applications for the economy commercial transportation segment. This clearcoat is designed to deliver a high-performance, very durable finish in 2.1 lb./gal (250 g/l) VOC and 3.5 lb./gal (420 g/l) VOC levels.

### SUGGESTED USES

Designed for overall repairs.

### RECOMMENDED FOR USE OVER

Rival Topcoat (RV35 and RV28 qualities) as a color coat / clearcoat system.

### NOT RECOMMENDED FOR

Immersion service or over alkyd enamels or lacquer finishes.

### DRY FILM CHARACTERISTICS

Chemical Resistance	VERY GOOD
Humidity Resistance	VERY GOOD
Weatherability	EXCELLENT
Acid Resistance	VERY GOOD
Alkali Resistance	VERY GOOD
Solvent Resistance	GOOD
Abrasion Resistance	VERY GOOD
Flexibility	EXCELLENT

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



## MIXING

### MIX RATIO

Stir clearcoat thoroughly prior to activation. Combine components and mix thoroughly. Filter material prior to spray application.

### COMPONENTS

#### 3.5 VOC Mixing Ratio

	Parts by Volume
Rival RV500 Clearcoat	6
RV135™ Activator	1

#### 2.1 VOC Mixing Ratio

Rival RV500 Clearcoat	6
RV128™ Activator	1

### ADDITIVES

#### Increased cure:

##### 3.5 VOC

Add up to 2 oz. of 389S™ Accelerator per activated gallon

##### 2.1 VOC

Add up to 2 oz. of 389S Accelerator per activated gallon



**INITIAL APPLICATION VISCOSITY**

9-11 seconds with #3 Zahn Cup.

**INDUCTION TIME**

No induction time is required.

**POT LIFE - 70°F (21°C)**

3 hours as activated or with 2 oz. 389S Accelerator



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**APPLICATION**

**APPLICATION CONDITIONS**

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

**APPLICATION EQUIPMENT**

Refer to spray equipment documentation for setting recommendations.

Pressure Pot	Suction Spray
Gravity Feed	Air-Assisted Airless

**APPLICATION**

- Allow Rival single stage topcoat solid colors to flash dry for 30 minutes prior to clearcoat application.
- To avoid mottling of the metallic flake, allow Rival metallic colors to cure overnight prior to applying clearcoat. They should be lightly scuff-sanded if allowed to dry for more than 24 hours prior to application of RV500 clearcoat.
- Apply using a cross-coat technique - a wet coat using a top-to-bottom motion and a medium-wet second coat using a side-to-side motion. Flash 30 seconds to 5 minutes between coats. In general, the shorter the flash the smoother the appearance.
- For pressure pot application, fluid delivery should be set for 10-12 fluid oz/min.
- When recoating RV500 with itself, sanding is required if the clearcoat has air dried more than 24 hours or has been force dried.

**APPLICATION SOLVENTS**

No reduction necessary; product is ready-to-spray. Further reduction may result in an increased VOC.

**CLEANUP SOLVENTS**

- 130™ Acetone
- 105™ Lacquer Thinner
- 107™ Low VOC Gun Cleaner
- 108™ Low HAPS Cleaning Solvent

**ADDITIONAL COMMENTS**

Heating activated material above 110°F (43°C) will shorten pot life and cause product to gel.



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**DRY TIMES**

**AIR DRY**

77°F (25°C) & 50% RH at recommended film thickness

	As Activated	With 389S
Dry to touch	2 hours	1 hour
Tack free	2-3 hours	1-2 hours
Tape free	12-24 hours	6-10 hours
Dry to assemble	24 hours	16 hours



**FORCE DRY**

30 minutes at 130-140°F (54-60°C)

Maximum Service Temperature:

200°F (92°C) in continuous service  
300°F (148°C) in intermittent heat

Weight Per Gallon (component only)

8.96 lbs.

Weight Per Liter (component only)

1074 grams

Suggested Dry Film Thickness

1.5 – 2.0 mils

Gloss

High

Color

Clear

Flash Point (Closed Cup)

See MSDS/SDS

Shelf Life

12 months minimum

**RTS mixed 6:1 with:**

**Includes 389S**

Gallon Weight pounds per gallon

**RV135**

8.94

**RV128**

8.99

Gallon Weight grams per liter

1072

1077

VOC AP pounds per gallon

1.3

1.2

VOC AP grams per liter

161

139

VOC LE pounds per gallon

2.3

2.1

VOC LE grams per liter

279

247

Weight Solids

40.6%

41.8%

Volume Solids

38.1%

39.5%

Weight Volatiles

59.4%

58.2%

Weight Water

0.0%

0.0%

Volume Water

0.0%

0.0%

Weight Exempt Solvents

44.5%

45.3%

Volume Exempt Solvents

42.6%

43.8%

Theoretical Coverage per RTS Gallon at 1 mil DFT

611 ft<sup>2</sup> (56.8 m<sup>2</sup>)

633 ft<sup>2</sup> (58.8 m<sup>2</sup>)

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## VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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## SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Revised: November 2021

In the United States:  
**1.855.6.AXALTA**  
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In Canada:  
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**axalta.ca**

