



AUTOCOLOR

PDS N5.6

April 2002

P190-596

2K™ MS CLEARCOAT

PRODUCT DESCRIPTION

2K™ MS Clearcoat is a high quality, acrylic urethane Clearcoat, which when mixed with MS Hardeners delivers a smooth, glossy high build finish. It can also be mixed with Express Hardener (P210-790) to provide an exceptionally fast system.

- Easy to use
- Fast dry
- Excellent gloss and appearance
- Express system for spot and panel repairs

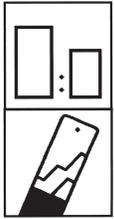
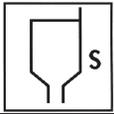
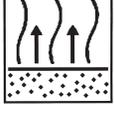
2K MS Clearcoat

PRODUCTS

<i>P190-596</i>	<i>2K™ MS Clearcoat</i>
<i>P210-790</i>	<i>Express Hardener</i>
<i>P210-832</i>	<i>MS Hardener – Express</i>
<i>P210-796</i>	<i>MS Hardener – Normal</i>
<i>P210-798</i>	<i>MS Hardener – Slow</i>

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

	EXPRESS	MS EXPRESS	MS
MIX RATIO 	P190-596 2 parts P210-790 1 part	P190-596 3 parts P210-832 1 part	P190-596 3 parts P210-796/798 1 part
VISCOSITY & POT LIFE 	Viscosity: 16-17 seconds @ 70°C (21°C) Pot Life: 2 Hours @ 70°C (21°C)	Viscosity: 17-19 seconds @ 70°C (21°C) Pot Life: 2 Hours @ 70°C (21°C)	Viscosity: 17-19 seconds @ 70°C (21°C) Pot Life: 4 Hours @ 70°C (21°C)
SPRAY GUN & AIR PRESSURE 	Siphon Feed: 1.4-1.8mm (.055" - .070) 45-55 psi at the gun Gravity Feed: 1.3-1.6mm (.051" - .063") 45-55 psi at the gun	Siphon Feed: 1.4-1.8mm (.055" - .070) 45-55 psi at the gun Gravity Feed: 1.3-1.6mm (.051" - .063") 45-55 psi at the gun	Siphon Feed: 1.4-1.8mm (.055" - .070) 45-55 psi at the gun Gravity Feed: 1.3-1.6mm (.051" - .063") 45-55 psi at the gun
(HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)			
APPLICATION 	2-3 single coats (approx. 2.0-2.5 mil)	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 10 min. Handle 2 hrs. Polishing 4 hrs Force Dry @ 140° (60°C) (metal temperature) 10 minutes	Air Dry @ 70°F (21°C) Dust Free 10 min. Handle 2 hrs. Polishing 12 hrs Force Dry @ 140° (60°C) (metal temperature) 20 min.	Air Dry @ 70°F (21°C) Dust Free 15 min. Handle 6 hrs Polishing 16 hrs Force Dry @ 140° (60°C) (metal temperature) 30 min.

2K MS CLEARCOAT

WEIGHT MIX RATIOS FOR P190-596

MS Clearcoat P190-596		Express	Mix Ratio By Weight (Cumulative Weight in Grams)			
Product	Ratio	1/2 Pint	1 Pint	1 Quart	2 Quart	
CLEARCOAT P190-596	2	147	295	590	1180	
HARDENER P210-790	1	221	442	884	1768	

MS Clearcoat P190-596		MS Express	Mix Ratio By Weight (Cumulative Weight in Grams)			
Product	Ratio	1/2 Pint	1 Pint	1 Quart	2 Quart	
CLEARCOAT P190-596	3	166	332	664	1328	
HARDENER P210-832	1	223	445	890	1780	

MS Clearcoat P190-596		MS	Mix Ratio By Weight (Cumulative Weight in Grams)			
Product	Ratio	1/2 Pint	1 Pint	1 Quart	2 Quart	
CLEARCOAT P190-596	3	166	332	664	1328	
HARDENER P210-796/798	1	223	446	892	1784	

Note: These weights will produce approximately 97.5% of the volume stated to allow for mixing in the can. If an exact quart, pint, half-pint, etc. is required, multiply all weights by 1.025. All weights have been rounded off to whole numbers.

SUBSTRATES

2K™ MS (P190-596) should only be applied over P422 Basecoat after the recommended dry times.

2K™ MS Clearcoat can also be used as part of the 2K Single Layer blending process (see PDS 7.1, Blending Techniques).

2K MS CLEARCOAT

RECOATABILITY

EXPRESS SYSTEM

The very fast curing of 2K Express Clearcoat used with P210-790 (Express Hardener) results in different behavior from 2K™ MS Clearcoat used with MS Hardeners.

2K Express Clearcoat can be recoated within 16-48 hours air dry (40°F - 70°F).

@ 40°F (4°C) finish needs to dry 48 hours before recoating.

@ 70°F (21°C) finish needs to dry 16 hours before recoating.

When force dried for 10 minutes at 140°F (60°C) metal temperature, 2K Express Clearcoat needs five additional hours to air-dry before recoating.

MS SYSTEM

2K™ MS Clearcoat used with MS Hardeners (P210-832 and P210-796) is fully recoatable after 16 hours air dry @ 70°F (21°C)

When force dried for recommended times 2K™ MS Clearcoat is fully recoatable after cooling down.

POLISHING

Polishing is not normally required as 2K™ MS Clearcoat has a full gloss finish. If, however, polishing is required to remove minor dirt nibs, wet sand with P1500 Grit and follow normal polishing procedures.

PROCESS NOTES

CHOICE OF HARDENER

1. Hardener and thinner selection will depend mainly on temperature, but also on air movement and size of repair.
2. For optimum application, these paint systems should not be applied cold. Best results will be obtained by slowing adequate time for paint to reach 70°F(21°C)
3. In the event of fish-eyes, use 1- 2 inner capfuls of P273-1086 (Fish Eye Preventer) per 1 quart of 2K™ MS Clearcoat Ready-for-Use.
4. For blending of 2K™ MS Clearcoat, refer to PDS N7.1, Blending Techniques.

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EQUIPMENT CLEANING

Approved Cleaning Solvent

2K PERFORMANCE SPECIFICATIONS

Product:	P190-596 2K™ MS Clearcoat
Category:	Topcoat
VOC As Packaged:	4.64 lbs. per gal/ 557gm/l
VOC (RFU):	4.65 lbs. per gal/ 558gm/l with P210-796/798(Maximum)
RFU Weight Solids:	42.5%
RFU Volume Solids:	36.1%
VOC (RFU):	4.66 lbs. per gal/ 559gm/l with P210-832 (Maximum)
RFU Weight Solids:	42.3%
RFU Volume Solids:	35.9%
VOC (RFU):	4.79 lbs. per gal/ 575gm/l with P210-790 (Maximum)
RFU Weight Solids:	40.4%
RFU Volume Solids:	34.2%
Product:	P273-1086 Fish-eye Eliminator
Category:	Specialty
VOC As Packaged:	7.2 lbs. per gal/862 gm/l

For further information please contact:

Nexa Autocolor-USA
801 Canterbury Road
Westlake, OH 44145

Nexa Autocolor- Canada
1330 Castlefield Avenue
Toronto, Canada M6B 4B3

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