



**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

RM-3001CAN

## ***2K MS Clearcoat***

### **PRODUCTS**

***P190-596                      2K™ MS Clearcoat***

***P210-790                      Express Hardener***

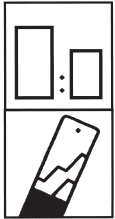
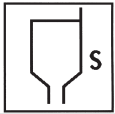


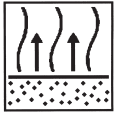

***P210-832                      MS Hardener – Express***

***P210-796                      MS Hardener – Normal***

***P210-798                      MS Hardener – Slow***

**THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY**

# PROCESS

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

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## **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.

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## **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.

# 2K MS CLEARCOAT

## EQUIPMENT CLEANING

Approved Cleaning Solvent

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## 2K PERFORMANCE SPECIFICATIONS

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