

HS Plus Clearcoat P190-6515

J2294V

# Product Data Sheet

January 2017

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY



## J2294V

### SR Plus Clearcoat P190-6515

Product	Description
P190-6515	SR Plus Clearcoat
P210-8605	Hardener

#### Product Description

SR Plus Clearcoat provides the ultimate protection for any repair and will be the clearcoat used for all VW warranty work. P190-6515 is developed to surpass the requirements for the toughest of OEM tests on film performance.

In order to achieve the optimum performance, this clearcoat uses a dedicated hardener (P210-8605), but does not require any thinners. **P190-6515 can be used in either a standard 2 coat application or a quicker 'one-visit' application if preferred.**

#### Substrates / Preparation

**P190-6515 should be applied only over: -**

- P989 *Aquabase* Plus basecoats
- Prepared existing paintwork in sound condition. Existing paintwork should first be abraded (E.g. with **Scotch-Brite™** Ultrafine Grey with P562-106) and cleaned with P980-251, P980-9010 or P980-8252 prior to application of P190-6515



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J2294V

## Application Process



	<b>Standard Application System</b>
	P190-6515                      2 parts P210-8605                      1 part
	16-17 secs. DIN4 at 20°C
	Pot life at 20°C: 60 minutes / 1 hour
	It is recommended that the clearcoat is activated just prior to application.
 	<p><b>Fluid Tip</b>            Gravity Fed : 1.2-1.3 mm            Inlet Pressure : Refer to spraygun manufacturers instructions,            normally 2 bar/30 psi (inlet)</p>
	<p><b>Express Single Visit Process</b></p> <p>Apply 1 light/medium closed coat followed by a full coat to give 50-60 microns dry film thickness. The first coat should be applied to all repair panels before the second coat is applied.            For 1 panel application, allow 1-3 minutes flash between spray coats.            For more than 3 panels, no flash off is required.            Flash off before bake or IR dry: 3 minutes</p> <p><b>Conventional Two Coat Process</b></p> <p>Apply 2 single coats to give ~60 microns dry film build.            Flash off between spray coats: 3 minutes            Flash off before bake or IR dry: 3 minutes</p>
	3 minutes flash-off required before baking, depending on oven type

Product Data Sheet



**HS Plus Clearcoat P190-6515**

**J2294V**

	<p>Bake at a metal temperature of :</p> <p>60°C : 40 minutes</p> <p>Into service : When cool</p>
	<p>Short-wave : 8 -15 mins full power (depending on colour and equipment). Metal temperature between 90°C and 100°C</p>

Product Data Sheet



## General Process Notes

### FADE OUT PROCESS

Use Spot Blender Aerosol P850-1622 or Spot Blender P273-1106.  
Refer to Fade-out / Blending Processes Technical Data Sheet M1200V for details.

Application Temperature: Up to 30°C

### PAINT TEMPERATURE

Allow all components to reach room temperature (20°C) before use. It is strongly recommended that cold paint is warmed to a minimum of 15°C before application. Below this temperature paint application performance may be adversely affected.

### INFRA-RED DRYING

Drying times are dependent upon colour and equipment. Refer to manufacturer's instructions for set-up details. When using Aquabase Plus basecoat, ensure the basecoat is thoroughly dry before applying the clearcoat.

Setting for metal temperature from 90°C to 100°C.

### RECOATABILITY

P190-6515, is fully recoatable after the "into-service" times.

### RECTIFICATION AND POLISHING

Polishing is not normally required as P190-6515 has a gloss finish. However, if dirt is a problem, denib with P1200 followed by P1500 and finished with Trizact P3000 or similar, then polish by machine using a quality polish such as SPP Polishing System (refer to SPP PDS) combined with a suitable polishing pad at minimum speed to avoid surface becoming too hot. If heating occurs allow it to cool down before continuing the polishing process.

Polishing of P190-6515 is easiest between 1 and 24 hours after "into service" drying times.



## General Process Notes

### RATIOS FOR TEXTURE AND FLEXIBLE OPTIONS

P565-7210/7220 can be used to give a textured finish. For use over flexible substrates, P100-2020 should also be used.

**Note:** The majority of plastics used on cars are considered **Rigid**. These plastics may have some flexibility when painted off the car, but are rigid once mounted. HS+ Clearcoats only require the addition of the Flexible Additive (See **Flexible** chart below) when painting very flexible plastics, mostly found on older vehicles, e.g. foam type.

The following tables, gives a **1L WEIGHT MIX** for various topcoat appearances, ready to spray. The weights in grams are cumulative. **DO NOT TARE** the scale between additions.

Substrate	Appearance	P190-6515	P565-7210	P565-7220	P100-2020	P210-8605	P850-1691x Thinners
RIGID	Gloss	658,0g				1004,3g	
	Matt Textured	291,7g	650,1g			803,6g	957,1g
	Leather Grain	394,8g		711,5g		919,3g	973,9g
FLEXIBLE	Gloss	510,5g			689,5g	958,2g	1000,6g
	Matt Textured	217,7g	538,7g		653,2g	806,7g	963,5g
	Leather Grain	282,0g		508,2g	656,5g	854,4g	971,5g

### PAINTING PLASTICS

Use the standard NEXA AUTOCOLOR® plastics painting system (refer to PDS).

### OTHER POINTS TO NOTE

When using 2-pack products it is highly recommended to clean the gun thoroughly immediately after use.



**HS Plus Clearcoat P190-6515**
**J2294V**
**GUIDELINES FOR WEIGHT MIXING**

Where a specific volume of clearcoat mix is required, this may be best achieved by weight mixing, using the guidelines below.

The weights are cumulative - please do **NOT** tare the scale between additions.

Volume of RFU Paint(Litres)	Weight P190-6515	Weight P210-8605
0,1L	65,8g	100,4g
0,25L	164,5g	251,1g
0,33L	217,1g	331,4g
0,4L	263,2g	401,7g
0,5L	329,0g	502,2g
0,66L	434,3g	662,9g
0,7L	460,6g	703,0g
0,75L	493,5g	753,3g
0,9L	592,2g	903,9g
1L	658,0g	1004,3g

Product Data Sheet



**HS Plus Clearcoat P190-6515****J2294V****VOC INFORMATION**

The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC.  
The VOC content of this product in ready to use form is max. 840g/litre.  
Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

**These products are for professional use only**, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information please refer to the material Safety Data Sheet, also available at: [www.nexaautocolor.com](http://www.nexaautocolor.com)

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