

Product Data Sheet

May 2012

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

J0320

2K MS Clearcoat P190-596

<i>Product</i>	<i>Description</i>
P190-596	2K MS Clearcoat
P210-796/-798	2K MS Hardeners
P210-832	2K MS Express Hardener
P210-790	2K Express Hardener
P850-1401	Fade Out Thinner
P850-1621	Aerosol Fade-out Thinner
P275-220	2K Rapid Dry Catalyst

Product Description

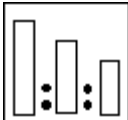




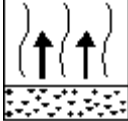

P190-596 is a versatile high quality MS 2-Pack acrylic clearcoat which can be used over all **Nexa Autocolor** 2K basecoats. It offers a hard and durable finish and is suitable for all types of repair. It can be used in conjunction with the standard MS hardener range to give superb gloss and appearance with good build. When used with Express hardeners, P210-832 and P210-790, a combination of rapid drying and high performance can be achieved which enables repair process times to be significantly reduced.

Substrates/Preparation

P190-596 should only be applied over :-

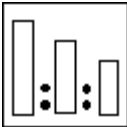




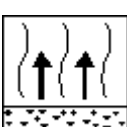


- P422-line 2K basecoat
- P965-line Aquabase™ waterborne basecoat
- P989-line Aquabase Plus waterborne basecoat
- P032-/P033-line Belco basecoat
- Prepared existing paintwork in sound condition. Existing paintwork should first be abraded (e.g. with Scotchbrite™ Ultrafine Grey and/or P562-106) and cleaned with a suitable pre-cleaner prior to application of P190-596.

Standard Process (All Repairs)

<p>HARDENERS</p>	<p>P210-796/-798</p>	
	<p>P190-596 3 parts P210-796/-798 1 part</p>	
	<p>16-17 secs DIN4 at 20°C (20-22 secs BSB4)</p> <p>Pot-Life at 20°C: 4 hours</p>	
	<p>Fluid Tip : Gravity Fed : 1.3-1.6 mm Suction Fed : 1.4-1.8 mm</p> <p>Pressure : 3.0-3.3 bar (45-50 psi)</p>	
	<p>Fluid Tip : Gravity fed : 1.3-1.6 mm Suction fed : 1.5-1.8 mm</p> <p>Pressure : 10 psi max (air cap)</p>	
	<p>2 full single coats</p>	
	<p>5-10 mins between coats</p> <p>No flash off required before baking</p>	
	<p>Bake at a metal temperature of : 70°C 20 mins 60°C 30 mins 50°C 60 mins Into Service : When cool</p> <p>Air Dry at 20°C : Dust Free 15 mins Handleable 6 hours Into Service 16 hours</p>	

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Express Process

HARDENERS	P210-832 (Medium sized repair)	P210-790 (Panel/spot repair)
	P190-596 3 parts P210-832 1 part	P190-596 2 parts P210-790 1 part
	16-17 secs DIN4 at 20°C (20-22 secs BSB4) Pot-Life at 20°C: 2 hours	15-16 secs DIN4 at 20°C (18-20 secs BSB4) Pot-Life at 20°C: 2 hour
	Fluid Tip : Gravity Fed : 1.3-1.6 mm Suction Fed : 1.5-1.8 mm Pressure : 3.0-3.3 bar (45-50 psi)	Fluid Tip : Gravity Fed : 1.3-1.6 mm Suction Fed : 1.5-1.8 mm Pressure : 3.0-3.3 bar (45-50 psi)
	Fluid Tip : Gravity fed : 1.3-1.6 mm Suction fed : 1.5-1.8 mm Pressure : 10 psi max (air cap)	Fluid Tip : Gravity fed : 1.3-1.6 mm Suction fed : 1.5-1.8 mm Pressure : 10 psi max (air cap)
	2 full single coats	2 full single coats
	5-10 mins between coats No flash off required before baking	5-10 mins between coats No flash off required before baking
	2 Full single coats	2 Full single coats
	Bake at a metal temperature of : 60°C 20 mins 50°C 40 mins Into Service : When cool Air Dry at 20°C : Dust Free 10 - 15 mins Handleable 4 hours Into Service 12 hours	Bake at a metal temperature of : 60°C 10 mins 50°C 20 mins Into Service : When cool Air-dry at 20°C : Dust Free 10 mins Handleable 2 hours Into Service 4 hours

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General Process Notes

FADE-OUT PROCESS

Apply clearcoat to the whole panel or up to a breakline. If "fading-out" the clearcoat make sure to (a) cover the basecoat edge and (b) only fade into the prepared surface. Any dry spray may be dissolved by applying P850-1401. Please refer to Fade-out process TDS for full basecoat/clearcoat details. Alternatively use P850-1621 Aerosol Fade-out process. See TDS M1000V.

TINTING

Certain basecoat colours require the use of a tinted clearcoat to achieve a colour match, as specified on the microfiche. Where this is required, P190-596 may be used as a tinted clearcoat by the addition of up to 20% of a limited range of 2K tinters, in accordance with the microfiche formulation. Please refer to 2K Tinted clearcoat process TDS for details of how to achieve a colour match where a tinted clearcoat is required. When using a tinted clearcoat finish, a final coat of untinted clearcoat is recommended for maximum durability and protection of colour.

CHOICE OF HARDENER

Nexa Autocolor offers a range of hardeners to suit the speed and quality requirements needed for every type and size of repair, under all conditions.

- P210-790 provides the quickest way to process small repairs (10 minutes bake at 60°C metal temperature) and is ideal for use in cold conditions (i.e. below 20°C)
- P210-832 combines accelerated drying (20 minutes bake at 60°C metal temperature), with a top quality finish on medium size repairs. This hardener is ideal for use up to 25°C.
- P210-796 is suitable for larger areas (e.g. complete respray) at temperatures up to 25°C.
- P210-798 should be used in place of P210-796 when the temperature lies between 25 and 30°C.

USE OF P275-220

To increase the through hardening rate of P275-220 Rapid dry catalyst may be added at a level of 10 mls to 0.5 litres of activated paint. Pot-life will reduce to 2-3 hours.

Note : P275-220 should not be used in combination with P210-790 or P210-832, and should not be used under conditions of high temperature (i.e. above 30°C) and high humidity.

General Process Notes

RECOATABILITY

1. When using P210-796, -798, or -832, P190-596 is fully recoatable after the "into-service" times.
2. The very fast curing of P210-790 results in a different behaviour from standard 2K systems. When recoating is required, this is best done within one hour after bake. If recoat is required after this period, the repair should first either be given a further 10 minute bake or be left to air-dry for 5 hours (at 20°C).

RECTIFICATION AND POLISHING

Polishing is not normally required as P190-596 has a full gloss finish. If dirt is a problem, denib with P1200 or finer, then polish by hand or machine using a quality polish such as SPP Polishing System (refer to SPP TDS). Polishing of 2K is easiest between 1 and 24 hours after "into service" drying times.

PAINTING PLASTICS

Use the standard **Nexa Autocolor** Plastics Painting System (refer to TDS).

OTHER POINTS TO NOTE

1. For optimum application, ensure both spraybooth air temperature and paint temperature are above 20°C. Best results will be obtained by allowing adequate time for the paint to reach spraybooth temperature before use.
2. When using 2-pack products it is essential to clean the gun thoroughly immediately after use.

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

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