

# Product Data Sheet

January 2021

INTERNATIONAL MASTER  
FOR PROFESSIONAL USE ONLY



## J2390

### HS Clearcoat P190-6865

<i>Product</i>	<i>Description</i>
P190-6865	HS Clearcoat
P210-842	HS Hardener - Fast
P210-844	HS Hardener – Medium
P210-8430	HS Hardener – Medium Fast

#### Product Description

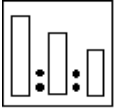






P190-6865 is a high solids 2 component acrylic clearcoat. It offers a hard, durable high gloss finish and is suitable for all types of repair.

#### Substrates/Preparation

P190-6865 should be applied over: -  
NEXA AUTOCOLOR® 2K & 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 P190-6865.

## Application Process

Application Systems	
	P190-6865                      2 parts P210-842/844/8430            1 part
	16-18 secs. DIN4 at 20°C
	Pot life at 20°C: 1 hour with P210-842/8430, 2 hours with P210-844 It is recommended that the clearcoat is activated just prior to application.
	<b>Fluid Tip</b> Gravity Fed : 1.2-1.3 mm Suction Fed : 1.4-1.6 mm Pressure : 0.7 bar/10 psi max (air cap)
	<b>Fluid Tip</b> Gravity Fed : 1.2-1.3 mm Suction Fed : 1.4-1.6 mm Inlet Pressure : Refer to spraygun manufacturers instructions, normally 2 bar/30 psi (inlet)
	<b>Conventional 2 coat Process</b> Apply 2 single coats to give 50 microns dry film thickness Allow 5 -7 mins flash-off between coats.
	0 - 5 minutes flash-off required before baking, depending on oven type

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## Application Process



Application temperature:

- P210-842      Up to 20°C
- P210-8430    20°C to 30°C
- P210-844      Above 30°C

Bake at metal temp. of :

- 30-40 minutes @ 60°C
- 8 hours Air-dry @ 20°C

Into service :      When cool



Short-wave : 15-20 mins full power (depending on colour and equipment)

## General Process Notes

### FADE-OUT PROCESS

P190-6865 HS Clearcoat may be faded-out using the **Spot Blender Aerosol P850-1622** or **Spot Blender P273-1106**. Please refer to the Fade-out / Blending Processes Technical Data Sheet M1200V for details of the technique to achieve a successful repair.

### PAINT TEMPERATURE

As with other paint systems, optimum spray application is achieved if the paint is allowed to reach room temperature (20-25°C) before use. This is particularly important for high solids systems. 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 or Aquabase Plus basecoat, it is particularly important to ensure the basecoat is thoroughly dry before applying the clearcoat.

### RECOATABILITY

P190-6865, is fully recoatable after the "into-service" times.



## Guide to Weight Mixing - 1

### RATIOS FOR TEXTURE AND FLEXIBLE OPTIONS

The addition of 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.

Flexible additive 10-30 %  
Antisilicone additive 0.5-2%  
Texture additive from 30 to 50%

### RECTIFICATION AND POLISHING

Polishing is not normally required as P190-6865 has a gloss finish. However, if dirt is a problem, denib with P1500 or finer, then polish by machine using a quality polish such as SPP Polishing System (refer to SPP PDS. Polishing of P190-6865 is easiest between 1 and 24 hours after "into service" drying times.

### PAINTING PLASTICS

Use the standard NEXA AUTOCOLOR<sup>®</sup> 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.



## Guide to Weight Mixing - 2

### 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 balance between additions.

Volume of RFU Paint (Litres)	Weight P190-6865	Weight P210-842/844/-8430
0.1 L	66.0g	98.7g
0.2 L	132.0g	197.3g
0.3 L	198.0g	296.0g
0.4 L	264.0g	394.7g
0.5 L	330.0g	493.3g
0.6 L	396.0g	592.0g
0.7 L	462.0g	690.7g
0.8 L	528.0g	789.3g
0.9 L	594.0g	888.0g
1 L	660.0g	986.7g



## General Process Notes Best Practices with UHS Products

### Paint storage conditions

Keep ready for use paint in good conditions to ensure correct viscosity.

RFU temperature above a minimum of 15°C, and ideally over 18°C.  
This includes paint, hardeners and thinners.

### Mixing and making ready for use

Activate accurately, and by weight where ever possible.

Where mixing must be by volume, only use a round and parallel sided mixing container together with the correct mixing stick. If using a measuring container marked in percentages, you must be sure that the percentages give the correct quantities.

Make sure that Hardeners and Thinners are mixed in well. High solids or high viscosity products can take a little longer to mix in, so a good practice is to stir Hardener in first, then add thinner before stirring again.

Use mixed product as quickly as possible.

Choose the correct Hardener for the required bake cycle.

Keep to the recommended levels of additives.  
Do not exceed the recommended level of additives such as Flexibilisers.

### Application technique, process and equipment choices

Use correct spraygun set ups, and set up the spraygun correctly.

Use a "Single Visit" application wherever possible, following the advice given in the application section.

Check that the spraybooth is operating effectively. If necessary make an oven check to be sure that metal temperature is reached, especially on low down repair areas.

Nexa Autocolor recommendations are based on time at metal temperature, so this should be allowed for in the bake cycle that is set for the job.



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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