

Product Data Sheet

July 2014



INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY

J2292V

2K SR Ceramic Clearcoat P190-6512 (using P210-8815 HS+ Hardener)

<i>Product</i>	<i>Description</i>
P190-6512	2K SR Ceramic Clearcoat
P210-8815	HS Plus Hardener
P850-1692/1693/1694	2K Low VOC Thinner
P852-1689	2K HS Plus Express Thinner

Product Description

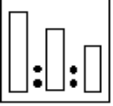






P190-6512 is a high solids, Scratch Resistant 2K Clearcoat for the repair of original CeramiClear or Scratch Resistant Clearcoats. It has been designed for use over a single or multistage waterborne basecoat systems. This clearcoat is based on the CeramiClear technology that gives excellent scratch resistance. It offers a hard and durable finish with superb gloss and is suitable for all types of repair.

Substrates/Preparation

P190-6512 should be applied only over: -

- P989-line AQUABASE® PLUSbasecoat
- P965-line AQUABASE®basecoat*
- 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 P190-6512.

PROCESS

	Standard Systems	Fast System
	P190-6512 3 parts P210-8815 1 part P850-1692/3/4 0.5 parts	P190-6512 3 parts P210-8815 1 part P852-1689 0.5 parts
	19 - 21 secs. DIN4 at 20°C Pot life at 20°C: 1 hour	19 - 21 secs. DIN4 at 20°C Pot life at 20°C: 30 minutes
	Fluid Tip Gravity Fed: 1.2-1.4 mm Suction Fed: 1.4-1.6 mm Inlet Pressure: Refer to spraygun manufacturers instructions (normally 2 bar/30 psi inlet)	
	Conventional 2 coat Process Apply 2 single coats to give 50-75 microns (2-3 thou) dry film thickness Allow 5 -7 mins flash-off between coats. Express Single Visit Process Apply 1 light/medium coat followed by a full coat to give 50 microns (2 thou) dry film thickness. The first coat should be applied to all repair panels before the second coat is applied. For less than 3 panels, allow 2-3 minutes flash between spray coats. For more than 3 panels, no flash off is required. *Application over P965-line Aquabase basecoat For optimum appearance when used over Aquabase metallic/pearl basecoats, the P190-6512 should be applied as per the Express Single Visit Process, baked as recommended, allowed to cool, sanded with either P1500 Dry or 3M Trizact™ 1000 Wet , then recoated with 1 full coat of P190-6512. Finish with a further bake as recommended.	
	5 - 10 minutes flash-off required before baking, depending on oven type	
	Bake at metal temp. of 60°C : 35 minutes Into service : When cool	Bake at metal temp. of 60°C : 20 minutes Into service : When cool
	Short-wave : 8 - 15 minutes, full power Medium-wave : 15 minutes, full power (depending on colour and equipment)	

General Process Notes

FADE-OUT PROCESS

Apply clearcoat to the whole panel or up to a break line. If "fading-out" the clearcoat make sure to cover the basecoat edge and only fade into the prepared surface. P190-6512 2K SR Ceramic 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.

CHOICE OF THINNER

The choice of thinner will be either the 14xx series or the 16xx series thinners, and should be made according to application temperature, air movement and size of job.

The recommendations below are for guidance only :-

Thinner: 16xx 2K Low VOC Thinner	Ideal temperature range:
P850-1692 Low VOC Thinner Fast	up to 25°C
P850-1693 Low VOC Thinner Medium	20-30°C
P850-1694 Low VOC Thinner Slow	25- 35°C

In general use a slower thinner in fast air movement booths, for large jobs and for high temperature application. Use a faster thinner in slow air movement booths, for small jobs and application at cooler temperatures.

PAINT TEMPERATURE

As with all paint systems, optimum spray application is achieved if the paint, hardener and thinner, are allowed to reach room temperature (20-25°C) before use. This is particularly important for high solids systems. Application performance may be adversely affected if paint is allowed to cool to 15°C or below

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

P190-6512 is fully recoatable after the "into-service" times.

RECTIFICATION AND POLISHING

Polishing is not normally required as P190-6512 has a gloss finish. However, if dirt is a problem, denib with the **3M Trizact™** system, finishing with P3000(wet), then polish by machine using a quality polish such as SPP Polishing System (refer to SPP PDS). For optimum appearance, finish with a Non Silicone Finishing Glaze. Polishing of P190-6512 is easiest between 1 and 24 hours after "into service" drying times.

OTHER POINTS TO NOTE

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



General Process Notes

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.

WEIGHT MIX GUIDE using 16xx thinners

Target Volume of RFU Paint required (Litres)	Weight P190-6512	Weight P210-8815	Weight P850-1692/93/94 or P852-1689
0.10 L	66 g	90 g	99 g
0.25 L	166 g	226 g	248 g
0.33 L	219 g	298 g	328 g
0.60 L	396 g	540 g	594 g
0.75 L	499 g	677 g	745 g
1.0 L	665 g	903 g	994 g

VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC. The VOC content of this product in ready to use form is max. 420g/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

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