

# Product Data Sheet

March 2015



INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY

## J2572V

### 2K HS Plus Express Clearcoat P190-6659 (using P210-8815 HS+ Hardener)

<i>Product</i>	<i>Description</i>
P190-6659	2K HS Plus Express Clearcoat
P210-8815	2K HS Plus Hardener
P850-1692/1693/1694	2K Low VOC Thinner
P852-1689	2K HS Plus Express Thinner

#### Product Description

P190-6659 is a high solids, 2K HS Plus Express Clearcoat for application over single or multistage waterborne basecoats.

P190-6659 has been designed for use in two modes, standard "one visit" application, where 1 light/medium flowing coat is followed by a full coat with no flash-off between coats, or a 2 coat application

#### Substrates/Preparation

P190-6659 should be applied over: -

- P989-line AQUABASE<sup>®</sup> PLUS basecoat
- Prepared existing paintwork in sound condition. Existing paintwork should first be abraded (E.g. with **Scotchbrite**<sup>™</sup> Ultrafine Grey with P562-106) and cleaned with Nexa Aquabase<sup>®</sup> Plus Precleaner P980-8252, prior to application of P190-6659



## General Process Notes

### RATIOS FOR TEXTURE OPTIONS

The addition of P565-7210/7220 can be used to give a textured finish.

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

#### Weight Mix Guide

Substrate	Appearance	P190-6659	P565-7210	P565-7220	HS Plus Hardener	Thinner 16**
Rigid	Gloss	642g	-	-	872g	979g
	Fine Textured	287g	641g	-	745g	946g
	Coarse Textured	392g	-	708g	850g	960g

**Note: The use of these plastic additives will significantly reduce the scratch resistant properties of this clearcoat.**

### FADE-OUT PROCESS

P190-6659 HS Plus Express 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.

### 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, it is particularly important to ensure the basecoat is thoroughly dry before applying the clearcoat.

### RECOATABILITY

P190-6659 is fully recoatable after the "into-service" times.

### RECTIFICATION AND POLISHING

Polishing is not normally required as P190-6659 has a gloss finish. However, if dirt is a problem, denib with **3M Trizact™**, 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 P190-6659 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

### CHOICE OF THINNER

The choice of thinner should be made according to application temperature, air movement and size of job. The recommendations below are for guidance only :-

**Thinner:**

P850-1692 Fast / P852-1689 Express  
P850-1693 Medium  
P850-1694 Slow

**Ideal temperature range:**

up to 25°C  
20-30°C  
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.

### 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

Target Volume of RFU Paint required (Litres)	Weight P190-6659	Weight P210-8815	Weight P850-1692/93/94 or P852-1689
0.10 L	64 g	87 g	98 g
0.25 L	161 g	218 g	245 g
0.33 L	212g	288 g	323 g
0.60 L	385g	523 g	588 g
0.75 L	482 g	654 g	735 g
1.0 L	642 g	872 g	979 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.

**NOTE:**

Combinations of this product with P100-2020, P565-7210 or P565-7220 will produce a paint film with special properties as defined by the EU Directive code.

**In these specific combinations:** 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.

**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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