

# Product Data Sheet

July 2016

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY



## J3070V

### HS Plus Clearcoat P190-8000

<i>Product</i>	<i>Description</i>
P190-8000	HS Plus Clearcoat
P210-8817	HS Plus Hardener
P852-1660	Express Thinner
P852-1661	Express Thinner High Temperature

#### Product Description

P190-8000 is an acrylic 2 component clearcoat optimized for use over AQUABASE® and AQUABASE® Plus basecoats. This new Clearcoat has been developed to reinforce NEXA AUTOCOLOR® brand's position as a market leader of quality products. Express Plus Clearcoat provides market leading speed without any compromise on appearance, application or size of repair. In order to achieve the optimum performance, this water white clearcoat uses a dedicated hardener (P210-8817) and two thinners depending on the application temperature. The Express Plus Clearcoat is the fastest clearcoat available in the Market; requiring only 5 minutes at 60°C or 20 minutes at 40°C, resulting in significant time and energy savings.

#### Substrates / Preparation

P190-8000 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 P190-8000

**HS Plus Clearcoat P190-8000**
**J2970V**
**Application Process**

	Standard Application System (Below 26°C)	High Temperature Application System (Over 26°C)																																												
	P190-8000                      2 parts P210-8817                      2 part P850-1660                      0.5 parts	P190-8000                      2 parts P210-8817                      2 part P852-1661                      0.5 parts																																												
	<p><b>MIXING BY WEIGHT:</b>                      The weights are cumulative - please do <b>NOT</b> tare the balance between additions.</p> <table border="1"> <thead> <tr> <th>Volume of RFU paint required (Litres)</th> <th>P190-8000</th> <th>P210-8817</th> <th>P852-1660/61</th> </tr> </thead> <tbody> <tr><td>0,1 L</td><td>45,7 g</td><td>91,2 g</td><td>101,4 g</td></tr> <tr><td>0,20 L</td><td>91,4 g</td><td>182,5 g</td><td>202,9 g</td></tr> <tr><td>0,25 L</td><td>114,2 g</td><td>228,1 g</td><td>253,6 g</td></tr> <tr><td>0,33 L</td><td>150,8 g</td><td>301,1 g</td><td>334,7 g</td></tr> <tr><td>0,50 L</td><td>228,4 g</td><td>456,2 g</td><td>507,2 g</td></tr> <tr><td>0,75 L</td><td>342,7 g</td><td>684,3 g</td><td>760,8 g</td></tr> <tr><td>1,00 L</td><td>456,9 g</td><td>912,4 g</td><td>1014,3 g</td></tr> <tr><td>1,50 L</td><td>685,3 g</td><td>1368,7 g</td><td>1521,5 g</td></tr> <tr><td>2,00 L</td><td>913,8 g</td><td>1824,9 g</td><td>2028,7 g</td></tr> <tr><td>2,50 L</td><td>1142,2 g</td><td>2281,1 g</td><td>2535,8 g</td></tr> </tbody> </table>		Volume of RFU paint required (Litres)	P190-8000	P210-8817	P852-1660/61	0,1 L	45,7 g	91,2 g	101,4 g	0,20 L	91,4 g	182,5 g	202,9 g	0,25 L	114,2 g	228,1 g	253,6 g	0,33 L	150,8 g	301,1 g	334,7 g	0,50 L	228,4 g	456,2 g	507,2 g	0,75 L	342,7 g	684,3 g	760,8 g	1,00 L	456,9 g	912,4 g	1014,3 g	1,50 L	685,3 g	1368,7 g	1521,5 g	2,00 L	913,8 g	1824,9 g	2028,7 g	2,50 L	1142,2 g	2281,1 g	2535,8 g
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	17-19 secs. DIN4 at 20°C																																													
	Pot life at 20°C:	P852-1660      60 minutes P852-1661      120 minutes																																												
It is recommended that the clearcoat is activated and thinned just prior to application.																																														

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	<p><b>Fluid Tip</b></p> <p>Gravity Fed : 1.2 mm                  Inlet Pressure : Refer to spraygun manufacturers instructions, normally 2-2.2 bar/30 psi (inlet)</p>	
	<p><b>Two Coat application Process</b></p> <p>Apply 1 light/medium &amp; 1 full coat.  <i>The first coat should be applied as a light <u>closed</u> coat.                  Second coat is applied as a full coat.</i></p> <p><b>Flash-off between coats: 5 mins</b>  <b>Flash-off before bake or IR: 5 mins</b></p>	
	<p><b><u>Bake at a panel temperature of :</u></b></p> <p><b><u>210-8817/P852-1660</u></b></p> <p>60°C: 5 minutes                  40°C: 20 minutes                  20°C: 90 minutes</p> <p>Into service : When cool</p>	<p><b><u>Bake at a panel temperature of :</u></b></p> <p><b><u>P210-8817/P852-1661</u></b></p> <p>60°C: 10 minutes                  40°C: 30 minutes                  20°C: 120 minutes</p> <p>Into service : When cool</p>
	<p><b>IR force drying with HT thinner:</b> 6 mins full power (depending on colour and equipment).                  Allow 5 min flash off before full power.                  Metal temperature max. 100°C</p>	

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## General Process Notes

### FADE - OUT REPAIR PROCESS

- Prepare the fade out area with a 3000 grade soft pad on a DA sander.
- Apply P190-8000 according to the information above.
- Take care to minimise the clearcoat edge in the fade-out area.
- Apply the following blend to the clearcoat edge to melt the edge

Target volume of RFU paint required	P190-8000	P210-8817	P852-1660/61	P273-1106
0.1L	45.7g	91.2g	101.4g	106g

- This is the maximum amount of spot blender allowed by VOC legislation
- Immediately melt overspray edge using Spot Blender Aerosol P850-1622 or Spot Blender P273-1106.
- It is not recommended to fade out on ½ panels such as doors. It is more efficient to Clearcoat the whole panel.
- After a thorough bake or if necessary application of an IR lamp for 5 mins, sand the edge briefly with 3000 grade soft pad on a DA sander.
- This step is not essential but makes the polishing much easier.
- Polish with normal process system.

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## 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	P190-8000	P565-7210	P565-7220	P100-2020	P210-8817	P852-1660/61
<b>Rigid</b>	Gloss	456,9g				912g	1013,3g
	Matt Textured	243,8g	531,3g	-	-	814,7g	987,7g
	Leather Grain	314,7g	-	557,0g	-	870,5g	991,5g
<b>Flexible</b>	Gloss	354,5g	-	-	473,8g	885,7g	1011,5g
	Matt Textured	188g	455g	-	551g	800g	985g
	Leather Grain	214g	-	380g	489g	772g	984g

### 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 P190-8000****J2970V****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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