

Process Data Sheet

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INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

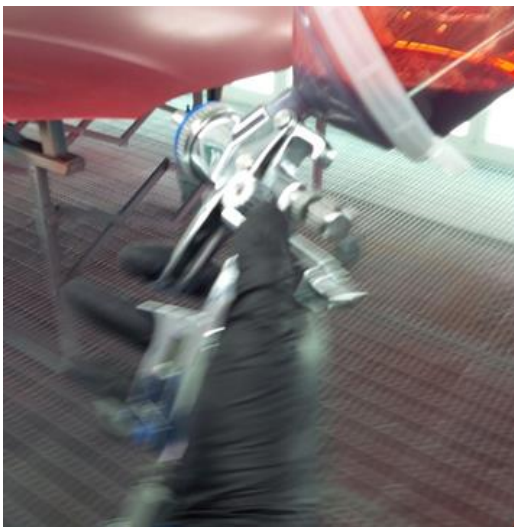


J1006V

TCB100 - Aquabase Plus Clean Vivid Ruby Special Concentrate P190-1005 (P210-8815) EMEA

<i>Product</i>	<i>Description</i>
P190-1005	Clean Vivid Ruby - Special Concentrate
<i>Process also requires</i>	
P190-6659	2K HS Plus Express Clearcoat
P210-8815	2K HS Plus Hardener
P850-1692/1693/-1694/-1695	2K Low VOC Thinners
P852-1689	2K HS Plus Express Thinner

Process Description



Clean Vivid Ruby is a tinted clear layer using specialised pigment dispersion technology to give the enhanced depth and clarity required in the latest OEM Candy Apple type colours.
e.g. Ford Ruby Red.

PROCESS

1. REPAIR AND PREPARATION OF SUBSTRATE

- 1.1 The damaged body work of the vehicle should be repaired using a NEXA AUTOCOLOR® repair and undercoating system for the substrate of the body panels being repaired (Aluminium, Steel, Plastic etc.)
- 1.2 Finish the repair with the recommended SG Spectral Grey Primer shade for the specific colour to be applied.
- 1.3 When preparing the substrate suitable colour panels should be prepared alongside for use when checking the colour/effect of the full Clean Vivid Ruby Colour Process

2. CLEAN VIVID RUBY COLOURS – CHECKING COLOUR MATCH

Colours containing the P190-1005, Clean Vivid Ruby Concentrate will be listed in Colour IT (PAINTMANAGER®), showing the blend of P190-1005 to P190-6659 required for a particular OEM colour.

When using the Clean Vivid Ruby type colours and process it is important to create colour panels to ensure the correct blend of P190-1005 with P190-6659 is used to achieve the required colour depth and effect of the vehicle being repaired.

Due to the UHS nature of the tinted Midcoat layer, varying the number of coats, to achieve the correct depth of red, is not possible and only the recommended number of coats of this layer must be applied.

To increase or decrease the depth of this layer the ratio of P190-1005 to P190-6659 should be altered depending on the direction required from the starting ratio e.g. 50/50 P190-1005/P190-6659, remembering that the recommended number of coats and film thickness must be remain fixed.

Clear	Percentage (%) Weight Mix				
P190-1005	25	35	50	65	75
P190-6659	75	65	50	35	25
	<<< Lighter (less Red)		Starting Point	Darker (more Red) >>>	

To produce the colour panels, use the full panel application process described below.

A full panel, “edge to edge” colour match is possible but is more difficult to achieve and could require more time spent on the colour checking process, therefore it is highly recommended to follow the Fade Out process as the preferred option.

CLEAN VIVID RUBY LAYER ACTIVATION

	By Volume
P190-1005/P190-6659 Mix	3 Parts
P210-8815 2K HS Plus Hardener	1 Part
P850-1692/1693/1694/1695 or P852-1689 Thinner	0.6 Part

Weight activations for the pre-mixed tinted layer can be found in the Colour RFU section of *PaintManager*

PROCESS

3. CLEAN VIVID RUBY COLOURS: FADE-OUT

Fade-out Option 1:

- Finish the repair with the recommended SG Spectral Grey Primer shade for the specific colour to be applied.
- Prepare panel as recommended for a blending process.
- Apply AQUABASE[®] or *Aquabase Plus Basecoat* (Main Layer from Colour IT).
- Application 3 coats + 1 light coat of *Aquabase or Aquabase Plus basecoat* to reach opacity/eveness.
- Flash off between coats as recommended.
- Use recommended fadeout process for *Aquabase or Aquabase Plus basecoat*.
- Mix the tinted midcoat layer (blend of P190-1005 + P190-6659 as confirmed from colour sprayout panels). Then activate @ 3: 1:0.6 ratio with P210-8815 hardener + thinner.
- Apply 1 visit coat of tinted midcoat layer over the basecoat, applying 1 light/medium coat followed by a full coat. Allow 1 - 2 minutes flash between spray coats.
- Melt the edge of tinted midcoat layer with Aerosol Spot Blender – P850-1622.
- Flash off 30 min @ 20°C then apply P190-6659 for final gloss as best choice, but any NEXA AUTOCOLOR[®] HS+ clear could be used, to the whole panel.



PROCESS

3. CLEAN VIVID RUBY COLOURS: FADE-OUT

Fade-out: Option 2:

- Finish the repair with the recommended SG Spectral Grey Primer shade for the specific colour to be applied.
- Prepare panel as recommended for a blending process.
- Apply *Aquabase* or *Aquabase Plus* Basecoat (Main Layer from Colour IT).
- Application 3 coats + 1 light coat of *Aquabase* or *Aquabase Plus* basecoat to reach opacity/evenness.
- Flash off between coats as recommended.
- Use recommended fadeout process for *Aquabase* or *Aquabase Plus* basecoat.
- Mix the tinted midcoat layer (blend of P190-1005 + P190-6659 as confirmed from colour sprayout panels). Then activate @ 3: 1:0.6 ratio with P210-8815 hardener + thinner
- Apply 1 visit coat of tinted midcoat layer over the basecoat, applying 1 light/medium coat followed by a full coat. Allow 1 - 2 minutes flash between spray coats.
- Bake the spot of blended tinted mid layer binder
 - If using P850-16XX Low VOC thinners, bake 30min @ 60°C
 - If using P852-1689 Express thinner, bake 15min @ 60°C
- Allow to dry & cool fully
- Wet machine sand the edge with a suitable blend/finishing disc, taking care to remove any over spray to the entire panel.
- Apply any *Nexa Autocolor* clearcoat to the whole panel to achieve the final gloss.



PROCESS

4. CLEAN VIVID RUBY COLOURS – FULL PANELS

Option 1:

- Apply *Aquabase* or *Aquabase Plus* Basecoat (Main Layer from Colour IT) over the correct grey primer shade . This is important to achieve the final color.
- Apply *Aquabase* or *Aquabase Plus* as recommended, two to three coats to achieve full opacity plus one final control coat.
- Leave *Aquabase* or *Aquabase Plus* to flash off for 30' at 20 - 23°C.
- Mix the tinted midcoat layer (blend of P190-1005 + P190-6659 as confirmed from colour sprayout panels). Then activate @ 3: 1:0.6 ratio with P210-8815 hardener + thinner.
- Apply 1 visit coat of tinted midcoat layer over the basecoat, applying 1 light/medium coat followed by a full coat. 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.
- Avoid any heavy application to reduce risk of fat edges/ framing.
- Bake according to the schedules below
 - If using P850-16XX Low VOC thinners, bake 30min @ 60°C
 - If using P852-1689 Express thinner, bake 15min @ 60°C
- Leave to cool down and wet sand with DA P1500.
- Clean and apply any *Nexa Autocolor* clearcoat desired for final gloss.

NOTE: Use this process for best appearance.



PROCESS

4. CLEAN VIVID RUBY COLOURS – FULL PANELS

Option 2:

- Apply *Aquabase or Aquabase Plus* Basecoat (Main Layer from Colour IT) over the correct grey primer shade. This is important to achieve the correct final color.
- Apply *Aquabase or Aquabase Plus* as recommended, Two to three coats to achieve full opacity plus one final control coat
- Leave *Aquabase or Aquabase Plus* to flash off for 30' at 20-23°C.
- Mix the tinted midcoat layer (blend of P190-1005 + P190-6659 as confirmed from colour sprayout panels). Then activate @ 3: 1:0.6 ratio with P210-8815 hardener + thinner.
- Apply 1 visit coat of tinted midcoat layer over the basecoat, applying 1 light/medium coat followed by a full coat. 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.
- Avoid any heavy application to reduce risk of fat edges/framing
- Flash off 30' @ 20°C
- Apply P190-6659 for final gloss as best choice but any *Nexa Autocolor* HS+ clear could be used.

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

For further information please contact:

Customer Service Sales Group
PPG Industries (UK) Ltd
Needham Road
Stowmarket
Suffolk. IP14 2AD
Tel: **01449 771771**
Fax: **01449 773472**

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