

Product Data Sheet

April 2016



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

J1835V

2K Matt Textured Clearcoat System

<i>Product</i>	<i>Description</i>
P190-1063	Clearcoat – Semi Gloss
P190-6659	HS Plus Express Clearcoat
P565-7210	Fine Texturing Base
P210-8815	2K HS Hardener
P850-1693/1694	2K Low VOC Thinner

Product Description

The clearcoat P190-1063 – Semi Gloss with fine texture base P565-7210 has been combined to reproduce the textured low gloss finishes found on Peugeot vehicles. It is for use over AQUABASE® PLUS.

To allow for the normal variations - due to colour, texturer model, position of repair on vehicle etc., the actual mix of the Clearcoat and Texture base can be varied to match the vehicle to be repaired.

The P190-1063 / P565-7210 mixes may be used over rigid plastics without the need for special additives.

The P190-1063 / P565-7210 Clearcoat mix can be used with HS hardener P210-8815.

Substrates/Preparation

When masking a repair, care should be taken to minimise direct contact of masking tape onto the original Matt finish. Where it is necessary to use masking tape directly on the original finish, the tape must be removed before baking to avoid marking of the original which may not recover.

The P190-6659 must be applied on top of a clean and dust-free basecoat. The light use of a tack cloth is recommended after the basecoat has flashed off.

Then the Matt - Textured blend should be applied after the P190-6659 has been dried as described below.

Care should be taken to avoid dirt inclusion at all stages. Rectification of dirt inclusion in a low Gloss textured finish is not possible after the final coat of clearcoat.

PROCESS

P190-1063/P565-7210 MIX RATIOS

The mix is activated and thinned as below.

Note: Test panels MUST be produced using the intended hardener/thinner/ratio/spraygun combination to check for colour and gloss level against the vehicle to be repaired. P850-1492 / P850-1693 Thinners are recommended to only be used on small areas or components (Mirror covers etc.)

CHOICE OF THINNER

Smaller areas / Verticals / Higher Gloss
Below 25°C
Smaller Spraygun tip size



Faster Thinner

Larger Areas / Horizontals / Lower Gloss
Above 25°C
Larger Spraygun tip size

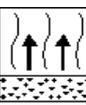


Slower Thinner



PROCESS

Standard Systems

	<p>By Volume</p> <table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th style="text-align: center;">More texture less Gloss</th> <th style="text-align: center;">Less texture more gloss</th> </tr> </thead> <tbody> <tr> <td>P190-1063</td> <td style="text-align: center;">3</td> <td style="text-align: center;">5</td> </tr> <tr> <td>P565-7210</td> <td style="text-align: center;">3</td> <td style="text-align: center;">1</td> </tr> <tr> <td>P210-8815</td> <td style="text-align: center;">1</td> <td style="text-align: center;">1</td> </tr> <tr> <td>P850-1693</td> <td style="text-align: center;">4</td> <td style="text-align: center;">4</td> </tr> </tbody> </table> <p>If Coarser texture is required it is possible to blend with P565-7220 If lower gloss is required it is possible to blend P190-1062 with P190-1063 Always do spray out cards to test the match to a vehicle</p>			More texture less Gloss	Less texture more gloss	P190-1063	3	5	P565-7210	3	1	P210-8815	1	1	P850-1693	4	4
	More texture less Gloss	Less texture more gloss															
P190-1063	3	5															
P565-7210	3	1															
P210-8815	1	1															
P850-1693	4	4															
	<p>15-16 secs. DIN4 at 20°C</p> <p>Pot life at 20°C: 1 - 2 hours depending on hardener/thinner</p>																
	<p>Fluid Tip Gravity Fed: 1.4 mm</p> <p>Inlet Pressure: Refer to spraygun manufacturers instructions (normally 2 bar/30 psi inlet)</p>																
	<p>Application Process 1: Apply 1 full coat of P190-6659 activated with P210-8815 and thinned with P850-1693 to the whole panel. This should be baked for 15 mins @ 60C and allowed to cool before application of the Matt / Textured coating. Please refer to the P210-6659 TDS for activation and application information. (This process is needed to achieve the correct robustness of the matt clearcoat layers)</p> <p>Process 2: 1 Full single coat, Flash off until evenly Matt all over + 1 Full single coat followed immediately by lighter (½ coat) cross coat. Flash off until evenly Matt all over before baking.</p>																
	<p>15 - 30 minutes, or until fully and evenly matt over the whole repair area*, flash-off is required between coats.</p> <p>15 - 30 minutes, or until fully and evenly matt over the whole repair area*, flash-off is required before baking.</p> <p>*Note: Allowing the Clearcoat to flash off fully between coats and before bake is important to achieve an even appearance and gloss level over the whole area. The actual flash off times will depend on the hardener/thinner combination required to achieve the correct gloss effect and could vary between 15 – 45 minutes.</p>																
	<p>With P210-8815 Hardener</p> <p>Bake at metal temp. of 60°C : 35 minutes Into service : When cool</p>																

General Process Notes

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.

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

RECOATABILITY

The P190-1063 / P565-7210 blend is fully recoatable after the "into-service" times.

RECTIFICATION

To remove minor dirt inclusions in the final finish, the repair should be fully dried, de-nibbed after cooling and **one** further coat of the Clearcoat Mix applied. Care should be taken to avoid too high clearcoat film thicknesses because the final colour could be affected. In this situation, the repair will require sanding and recoating with Basecoat and Clearcoat.

Dirt removal from the final Matt Textured Finish is not possible.

OTHER POINTS TO NOTE

The Gloss and texture levels achieved with this mix will vary depending upon film thickness and application. Low film thickness and dry application will give a Lower Gloss. High film thickness and wet application will give a higher gloss level.

It is recommended that this mixture be used for complete panel repair only.

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

Target Volume of RFU Paint required (Litres) @ 3 / 3 / 1 / 4	Weight P190-1063	Weight P565-7210	Weight P210-8815	Weight P850-1694
0.10 L	29 g	57 g	67g	95 g
0.25 L	74 g	143 g	168g	238 g
0.33 L	97 g	189 g	222 g	314 g
0.50 L	147 g	286 g	336 g	476 g
0.75 L	221 g	429 g	504 g	714 g
1.0 L	294 g	571 g	672 g	952 g
Target Volume of RFU Paint required (Litres) @ 3.5 / 2.5 / 1 / 4	Weight P190-1063	Weight P565-7210	Weight P210-8815	Weight P850-1694
0.10 L	33 g	55 g	64 g	95g
0.25 L	82 g	137 g	161 g	238 g
0.33 L	108 g	181 g	213 g	314 g
0.50 L	164 g	274 g	322 g	475 g
0.75 L	246 g	411g	483 g	713 g
1.0 L	328 g	548g	645 g	950 g
Target Volume of RFU Paint required (Litres) @ 4 / 2 / 1 / 4	Weight P190-1063	Weight P565-7210	Weight P210-8815	Weight P850-1694
0.10 L	37	55	65	95
0.25 L	94	138	162	238
0.33 L	124	182	214	314
0.50 L	187	275	324	476
0.75 L	281	413	485	715
1.0 L	375	551	647	953



General Process Notes

WEIGHT MIX GUIDE

Target Volume of RFU Paint required (Litres)@ 4.5 / 1.5 / 1 / 4	Weight P190-1063	Weight P565-7210	Weight P210-8815	Weight P850-1694
0.10 L	42	55	65	96
0.25 L	105	138	163	239
0.33 L	139	183	215	315
0.50 L	211	277	325	478
0.75 L	316	415	488	717
1.0 L	421	554	650	955
Target Volume of RFU Paint required (Litres)@ 5 / 1 / 1 / 4	Weight P190-1063	Weight P565-7210	Weight P210-8815	Weight P850-1694
0.10 L	47	56	65	96
0.25 L	117	139	163	240
0.33 L	155	184	215	316
0.50 L	234	278	326	479
0.75 L	351	417	490	719
1.0 L	468	556	653	958



General Process Notes

GENERAL CARE AND MAINTENANCE OF MATT TEXTURED FINISHES

The following guidance on Care and Cleaning of matt texture finish vehicles is aimed at the car owner, and applies to both the OE and the repair finish. Particular care must be taken with Matt Texture Finishes to maintain an original even Matt effect.

Guidance for the car owner on maintaining the even matt effect over time

Matt/Textured finishes can be relatively easily marked with general handling and day to day use (door/bonnet/boot opening, shoe scuffing on entry or exit of vehicle etc.). Care should be taken with these operations because marking or changing of the Matt effect could result.

Care should be taken to avoid spillage of fuel onto the Matt/Textured finishes. Spilt fuel should be removed as soon as possible using the washing guidelines below, to avoid permanent damage or altering of the Matt Textured Low Gloss effect.

1. In order to keep the Matt Textured surface effect, the use of paint cleaner, abrasives or polishes and wax polishes **must** be avoided. The vehicle **must** not be polished.
2. Polishing will lead to a higher, uneven gloss effect.
3. Cleaning/Polishing with unsuitable materials could alter the Matt Textured effect (generally increased gloss).
4. Automated car washing machines should be avoided. The preferred car washing method is by hand with a soft sponge, neutral soap and lots of water. Too frequent car washing could over a period of time lead to increased and inconsistent gloss levels across a car panel. Washing under direct sunlight should be avoided.
5. Insects and bird residues should be removed immediately. The residues should be soaked in water to soften and/or removed carefully with a high pressure cleaning equipment. In the case of strongly adhered residues, a spray on insect remover should be used prior to washing.
6. Whenever using any type of cleaning fluids with soft sponges or cloths, it is essential not to apply pressure or rub the Matt textured finish. A gentle wipe/spray on, wipe off technique should be used. Applying pressure will alter the effect and result in an uneven appearance.



VOC INFORMATION

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. 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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