

Product Data Sheet

May 2012

INTERNATIONAL MASTER
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J5510V

Waterborne Clearcoat P910-5510

<i>Product</i>	<i>Description</i>
P910-5510	Waterborne Clearcoat
P210-8861	Hardener for Waterborne Clearcoat
P980-2552	Thinner for Waterborne Clearcoat

Product Description

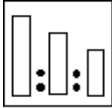





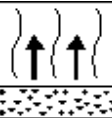

P910-5510 is a state of the art Waterborne Clearcoat designed to be used as part of a full waterborne repair system. It is especially useful for bodyshops wishing to minimise VOC usage and provides a high quality finish from the gun.

Substrates/Preparation

P910-5510 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 P910-5510.

Standard Process

Standard Application Systems	
	<p>P910-5510 2 parts P210-8861 1 parts P980-2552 1.6 – 1.8 parts</p> <p>First add hardener and stir well then add thinner and stir well again.</p> <p>Care should taken to ensure that the 3 components are thoroughly mixed and incorporated together. Use the mixing stick to ensure any thicker material is removed from the sides of the container and fully mixed in.</p> <p>After thoroughly stirring, check the mix on the mixing stick visually to ensure even incorporation of the hardener and thinner.</p>
	<p>20-21 secs. DIN4 at 20°C</p> <p>Initial viscosity can be higher but will not effect the application.</p>
	<p>Pot life at 20°C: 2 hours</p> <p>It is recommended that the clearcoat is activated and thinned just prior to application.</p>
	<p>Fluid Tip</p> <p>Gravity Fed: 1.3 mm Pressure: 0.7 bar/10 psi max (air cap)</p>
	<p>Fluid Tip</p> <p>Gravity Fed: 1.3 mm Inlet Pressure: Refer to spraygun manufacturers instructions, normally 2 bar/30 psi (inlet)</p>
	<p>Single Visit Process</p> <p>Apply 1 light even coat followed by a full coat to give 50 - 60 microns (2 – 2.4 thou) dry film thickness.</p> <p>The first coat should be applied to all repair panels before the second coat is applied.</p> <p>Allow 1 minute flash between spray coats.</p>
	<p>Flash off for 5 minutes before baking.</p>
	<p>Bake at a metal temperature of :</p> <p>60°C: 40 minutes</p> <p>Into service : When cool</p>

General Process Notes

FADE-OUT PROCESS

P910-5510 WB Clearcoat may be faded-out using the **Thinner for WB Clearcoat, P980-2552**.

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 P910-5510.

Step 1 - Apply WB Clearcoat keeping the edge of the repair smooth arcing the spraygun.

Step 2 - Use 100% clean Thinner for WB Clearcoat over the edge of the repair to melt in the overspray edge. Set spraygun needle at ½ turn out from fully closed to avoid over application of the Thinner.

Step 3 - Allow a minimum of 1 hour after baking before polishing the repair edge.

Note: The repair must be done within a well prepared area

PAINT TEMPERATURE

As with other paint systems, optimum spray application is achieved if the paint is at a minimum of 15°C (ideally 20°C) before use. This is particularly important for waterborne systems. Below this temperature paint application performance may be adversely affected.

RECOATABILITY

P910-5510 is fully recoatable after the "into-service" times.

RECTIFICATION AND POLISHING

If dirt is a problem, denib with P1200 followed by P 1500 and finished with Trizact P3000 or similar , then polish by machine using a quality polish such as SPP Polishing System (refer to SPP PDS) at minimum speed to avoid surface becoming too hot. If heating occurs allow it to cool down before continuing the polishing process.

Polishing of P910-5510 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 Waterborne Clearcoat mix is required, this may be best achieved by weight mixing, using the guidelines below.

The weights of Clearcoat and Hardener are cumulative - please do **NOT** tare the balance between additions. After Hardener addition, stir well and tare the balance, leaving the stirring stick in the container. Add the required weight of Thinner and stir the mix thoroughly. See full mixing instructions on page 2.

WEIGHT MIX GUIDE

Volume of RFU Paint(Litres) (1.8 parts vol. Thinner)	Weight P910-5510 Clearcoat	Weight P210-8861 Hardener		Weight P980-2552 Thinner	
Volume Mix =	2	1		1.6	1.8
0.10 L	41.7	62.5		33.4	37.6
0.20 L	83.4	125.0	STIR	66.7	75.1
0.25 L	104.3	156.3	WELL	83.4	93.9
0.33 L	137.7	205.7		110.1	123.8
0.50 L	208.5	312.5	THEN	166.8	187.7
0.75 L	312.8	468.8		250.2	281.5
1.00 L	417	625	TARE	334	375
1.50 L	626	938	BALANCE	500	563
2.00 L	834	1250		667	750
2.50 L	1043	1563		834	939

VOC INFORMATION

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

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