Product Data Sheet

April 2010

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

J2270V

2K SR Ceramic Clearcoat
P190-6512

Product	*Description*
P190-6512	2K SR Ceramic Clearcoat
P210-8625	2K Hardener for SR Clearcoat
P850-1490/1491/1492/1493/1494/1495	2K Thinner
P850-1692/1693/1694	2K Low VOC Thinner

Product Description

P190-6512 is a high solids, Scratch Resistant 2K Clearcoat for the repair of original CeramiClear or Scratch Resistant Clearcoats. It has been designed for use over a single or multistage waterborne basecoat systems. This clearcoat is based on the CeramiClear technology that gives excellent scratch resistance. It offers a hard and durable finish with superb gloss and is suitable for all types of repair.

P190-6512 has been designed for application with Compliant spray guns. It can be used in two modes, standard 2-coat application and "one visit" application, where 1 light/medium flowing coat is followed by a full coat with no flash-off between coats (depending on the size of the repair, see application details).

Substrates/Preparation

P190-6512 should be applied only over: -

- P989-line **Aquabase Plus** basecoat
- P965-line **Aquabase™** basecoat
- Prepared existing paintwork in sound condition. Existing paintwork should first be abraded (E.g. with **Scotch-Brite™** Ultrafine Grey with P562-100 or P562-106) and cleaned with P980-251, P980-9010 or P980-8252 prior to application of P190-6512.

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Standard System

	P190-6512 2 parts P210-8625 1 part P850-1490/1/2/3/4/5 or P850-1692/3/4 Thinners 0.1 parts
	19-21 secs. DIN4 at 20°C Pot life : 1 hour at 20°C
COMPLIANT	**Fluid Tip :** Gravity Fed : 1.2 -1.4 mm **Inlet Pressure :** Refer to spraygun manufacturers instructions normally 2 bar/30 psi
	Conventional 2 coat Process Apply 2 single coats to give 50-75 microns (2-3 thou) dry film thickness Allow 5 -7 mins flash-off between coats. **Express Single Visit Process** Apply 1 light/medium coat followed by a full coat to give 50 microns (2 thou) dry film thickness. 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.
	0 - 5 minutes flash-off required before baking, depending on oven type
	Bake at metal temp. of 60°C : 30 - 40 minutes Into service : When cool
IR	Short-wave : 8-15 minutes, full power Medium-wave : 15 minutes, full power (depending on colour and equipment)

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General Process Notes

FADE-OUT PROCESS

Apply clearcoat to the whole panel or up to a break line. If "fading-out" the clearcoat make sure to cover the basecoat edge and only fade into the prepared surface.
P190-6512 2K SR Ceramic Clearcoat may be faded-out using the **Aerosol Fade Out Thinner P850-1621 or Express Blender P273-1105**. Please refer to the Fade-out / Blending Processes Technical Data Sheet M1000V for details of the technique to achieve a successful repair.

CHOICE OF THINNER

The choice of thinner will be either the 14xx series or the 16xx series thinners, and should be made according to application temperature, air movement and size of job. The recommendations below are for guidance only :-

Thinner: 14xx 2K Thinner	Ideal temperature range:
P850-1490 Extra Fast	10-20°C
P850-1491 Fast	15-25°C
P850-1492 Medium	20-30°C
P850-1493 Slow	25-35°C
P850-1494 Extra Slow	30-40°C
P850-1495 High Temperature	35-45°C

Thinner: 16xx 2K Low VOC Thinner	Ideal temperature range:
P850-1692 Low VOC Thinner Fast	up to 22°C
P850-1693 Low VOC Thinner Medium	20-32°C
P850-1694 Low VOC Thinner Slow	above 30°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

INFRA-RED DRYING

Drying times are dependent upon colour and equipment. Refer to manufacturer's instructions for set-up details.
When using Aquabase or Aquabase Plus basecoat, it is particularly important to ensure the basecoat is thoroughly dry before applying the clearcoat.

RECOATABILITY

P190-6512 is fully recoatable after the "into-service" times.

RECTIFICATION AND POLISHING

Polishing is not normally required as P190-6512 has a gloss finish. However, if dirt is a problem, denib with the **3M Trizact™** system, finishing with P3000(wet), 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 P190-6512 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.

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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 WITH P850-16XX LOW VOC THINNERS		
Volume of RFU Paint required (Litres)	**Weight P190-6512**	**Weight P210-8625**	**Weight P850-1692/1693/1694**
0.10 L	64 g	97 g	100 g
0.20 L	128 g	195 g	200 g
0.25 L	161 g	245 g	255 g
0.33 L	214 g	325 g	334 g
0.50 L	321 g	488 g	501 g
0.75 L	482 g	733 g	753 g
1.0 L	642 g	976 g	1002 g
1.5 L	964 g	1466 g	1506 g
2.0 L	1285 g	1954 g	2007 g
2.5 L	1606 g	2442 g	2508 g
	WEIGHT MIX GUIDE WITH P850-14XX 2K THINNERS		
Volume of RFU Paint required (Litres)	**Weight P190-6512**	**Weight P210-8625**	**Weight P850-1490/1/2/3/4/5**
0.10 L	64 g	97 g	100g
0.20 L	128 g	195 g	201 g
0.25 L	161 g	245 g	252 g
0.33 L	214 g	325 g	335 g
0.50 L	321 g	488 g	502 g
0.75 L	482 g	733 g	755 g
1.0 L	642 g	976 g	1005 g
1.5 L	964 g	1466 g	1509 g
2.0 L	1285 g	1954 g	2012 g
2.5 L	1606 g	2442 g	2515 g

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General Process Notes
Best Practices with UHS Products

Paint storage conditions

Keep ready for use paint in good conditions to ensure correct viscosity.

RFU temperature above a minimum of 15˚C, and ideally over 18˚C.
This includes paint, hardeners and thinners.

Mixing and making ready for use

Activate accurately, and by weight where ever possible.

Where mixing must be by volume, only use a round and parallel sided mixing container together with the correct mixing stick. If using a measuring container marked in percentages, you must be sure that the percentages give the correct quantities.

Make sure that Hardeners and Thinners are mixed in well. High solids or high viscosity products can take a little longer to mix in, so a good practice is to stir Hardener in first, then add thinner before stirring again.

Use mixed product as quickly as possible.

Choose the correct Hardener for the required bake cycle.

Keep to the recommended levels of additives.
Do not exceed the recommended level of additives such as Flexibilisers.

Application technique, process and equipment choices

Use correct spraygun set ups, and set up the spraygun correctly.

Use a “Single Visit” application wherever possible, following the advice given in the application section.

Check that the spraybooth is operating effectively. If necessary make an oven check to be sure that metal temperature is reached, especially on low down repair areas.

Nexa Autocolor recommendations are based on time at metal temperature, so this should be allowed for in the bake cycle that is set for the job.

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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 Heath and Safety information please refer to the material Safety Data Sheet, also available at:
www.nexaautocolor.com

For further information please contact:

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