

# Product Data Sheet

October 2010

INTERNATIONAL MASTER  
FOR PROFESSIONAL USE ONLY



# J2370V

## HS Clearcoat P190-6550

<i>Product</i>	<i>Description</i>
P190-6550	HS Clearcoat
P210-8632	HS Hardener - Fast
P210-8633	HS Hardener - Medium
P210-8634	HS Hardener - Slow

### Product Description

P190-6550 is a high solids 2 component acrylic clearcoat. It offers a hard, durable high gloss finish and is suitable for all types of repair.

For compliance reasons P190-6550 has been designed for application with HVLP or 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.

### Substrates/Preparation

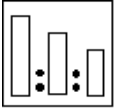





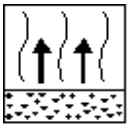
- P190-6550 should be applied only over: -
- P965-line **Aquabase™** basecoats
  - P989-line **Aquabase Plus** basecoats
  - Prepared existing paintwork in sound condition. Existing paintwork should first be abraded (E.g. with **Scotch-Brite™** Ultrafine Grey with P562-106) and cleaned with P980-251, P980-9010 or P980-8252 prior to application of P190-6550.

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## Application Process

Application Systems	
	<p>P190-6550                      2 parts                      P210-8632/8633/8634        1 part</p>
	<p>18-20 secs. DIN4 at 20°C</p>
	<p>Pot life at 20°C: 1 hour with P210-8632, 1.5 hours with P210-8633/8634                      It is recommended that the clearcoat is activated just prior to application.</p>
	<p><b>Fluid Tip</b>                      Gravity Fed : 1.2-1.4 mm                      Suction Fed : 1.4-1.6 mm                      Pressure : 0.7 bar/10 psi max (air cap)</p>
	<p><b>Fluid Tip</b>                      Gravity Fed : 1.2-1.4 mm                      Suction Fed : 1.4-1.6 mm                      Inlet Pressure : Refer to spraygun manufacturers instructions,                      normally 2 bar/30 psi (inlet)</p>
	<p><b>Fast Single Visit Process - Recommended</b>                      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.</p> <p><b>Conventional 2 coat Process</b>                      Apply 2 single coats to give 50-75 microns (2-3 thou) dry film thickness                      Allow 5 -7 mins flash-off between coats.</p>
	<p>0 - 5 minutes flash-off required before baking, depending on oven type</p>

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## Application Process



Application temperature:

<u>P210-8632</u>	Up to 18°C
<u>P210-8633</u>	18°C to 30°C
<u>P210-8634</u>	Above 30°C

Bake at metal temp. of :

<u>P210-8633</u>	30 minutes	60°C
<u>P210-8632</u>	30 minutes	60°C
<u>P210-8634</u>	35 minutes	60°C
	:	
	Into service :	When cool
<u>P210-8632</u>	Air-dry (20°C)	16 hours:



Short-wave : 8-15 mins full power (depending on colour and equipment)

## General Process Notes

### FADE-OUT PROCESS

P190-6550 HS 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 HARDENER

**P210-8633** Recommended choice for Low Bake environment and for optimum performance of P190-6550 up to 30°C application temperature.  
Gives a standard 30 minutes at 60°C metal temperature bake system suitable for all types of job.

**P210-8634** Ideal for processing large jobs at very high application temperatures (>30°C).  
Gives 35 minutes at 60°C metal temperature bake system.

**P210-8632** Can be used in Low Bake Environment but will not provide drying benefits over P210-8633.  
Ideal for applications up to 18°C . Best suited to an air dry process.

### PAINT TEMPERATURE

As with other paint systems, optimum spray application is achieved if the paint is allowed to reach room temperature (20-25°C) before use. This is particularly important for high solids systems. It is strongly recommended that cold paint is warmed to a minimum of 15°C before application. Below this temperature paint application performance may be adversely affected.

### 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

P190-6550, is fully recoatable after the "into-service" times.



## Guide to Weight Mixing - 1

### RATIOS FOR MATT, TEXTURE AND FLEXIBLE OPTIONS

Using P565-554, it is possible to reduce the gloss of P190-6550. The addition of 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. UHS 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	P190-6550	P565-554	P565-7210	P565-7220	P100-2020	HS Hardener	Thinner P850-xxxx
<b>Rigid</b>	Gloss	648g	-	-	-	-	978g	-
	Semi-gloss	486g	733g	-	-	-	980g	-
	Matt	389g	784g	-	-	-	982g	-
	Fine Textured	299g	-	673g	-	-	822g	949g
	Coarse Textured	417g	-	-	768g	-	968g	-
<b>Flexible</b>	Gloss	534g	-	-	-	645g	973g	-
	Semi-gloss	259g	500g	-	-	639g	936g	982g
	Matt	216g	582g	-	-	697g	972g	987g
	Matt Textured	208g	-	520g	-	632g	897g	970g
	Coarse Textured	271g	-	-	492g	637g	983g	-

### RECTIFICATION AND POLISHING

Polishing is not normally required as P190-6550 has a gloss finish. However, if dirt is a problem, denib with P1500 or finer, then polish by machine using a quality polish such as SPP Polishing System (refer to SPP PDS). Polishing of P190-6550 is easiest between 1 and 24 hours after "into service" drying times.

### 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.

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## Guide to Weight Mixing - 2

### 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.

Volume of RFU Paint (Litres)	Weight P190-6550	Weight P210-8632/-8633/-8634
0.10 L	65g	98g
0.20 L	130g	198g
0.25 L	163g	245g
0.33 L	215g	323g
0.50 L	324g	489g
0.75 L	488g	735g
1.0 L	648g	978g
1.5 L	972g	1467g
2.0 L	1296g	1956g
2.5 L	1620g	2445g



## 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.



**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 P565-554, 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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