

Product Data Sheet

October 2010

INTERNATIONAL MASTER
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J1890V

2K Low Gloss Clearcoat P190-1061/P190-6512 Mix (Approx. 20 -30% Gloss @ 60°)

<i>Product</i>	<i>Description</i>
P190-1061	2K Matt Clearcoat
P190-6512	2K SR Ceramic Clearcoat
P210-8430/844	2K HS Hardener
P850-1492/1493/1494/1495	2K Thinners
P850-1693/1694	2K Low VOC Thinner

Product Description

The mix of P190-1061 and P190-6512 Clearcoats is designed for use over Aquabase, Aquabase Plus or 2K basecoats. 2K basecoat must only be used for repair work not controlled by EU Directive 2004/42.

2K Low Gloss Clearcoat Mix is a versatile 2K acrylic urethane clearcoat designed for the specialised repairs of vehicles or areas of vehicles originally finished with low gloss clearcoat over a single or multistage colour basecoat system (e.g. Mercedes full body Matt Finish). To allow for the normal gloss variations - due to colour, model, position of repair on vehicle etc., the actual mix of the two Clearcoats can be varied to match the vehicle to be repaired.

The P190-1061/P190-6512 Mix may be used over rigid plastics without the need for special additives.

The P190-1061/P190-6512 Mix Clearcoat can be used with HS hardeners P210-8430/P210-844.

Substrates/Preparation

P190-1061 / P190-6512 Mix should be applied only over: -

- P989-line **Aquabase Plus** basecoat
 - P965-line **Aquabase™** basecoat
- or
- P422-line **2K™** basecoat in areas not controlled by EU Directive 2004/42.

The P190-1061/P190-6512 Mix Clearcoat 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.

Care should be taken to avoid dirt inclusion at all stages. Rectification of dirt inclusion in Matt or Low Gloss finishes is not possible after the final coat of clearcoat.

PROCESS

P190-1061/P190-6512 MIX RATIOS

To allow for normal variations in the gloss level, depending on colour, model, position of repair on vehicle, it is possible to mix the P190-1061 and P190-6512 as follows to match the required gloss for a particular repair.

	<u>Lower Gloss Option By Weight</u>	<u>Higher Gloss Option By Weight</u>
P190-1061	85	80
P190-6512	15	20

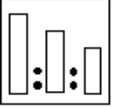



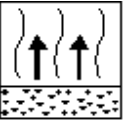


The resulting mix is then activated and thinned as below.

Note: It is strongly recommended that test panels are produced to check for colour and gloss level against the vehicle to be repaired.



PROCESS

Standard Systems

	<p>By Volume</p> <p>P190-1061/P190-6512 Mix 3 parts P210-8430/-844 1 part P850-1693/4 or 1 part P850-1492/3/4/5</p>	<p>By Weight</p> <p>See table, Page 5</p>
	<p>16 -19 secs. DIN4 at 20°C</p> <p>Pot life at 20°C: 2 hours</p>	
	<p>Fluid Tip</p> <p>Gravity Fed: 1.2-1.4 mm Suction Fed: 1.4-1.6 mm InletPressure: Refer to spraygun manufacturers instructions (normally 2 bar/30 psi inlet)</p>	
	<p>Conventional 2 - 3 coat Process</p> <p>Apply 2 - 3 single coats to give 50-60 microns dry film thickness</p>	
	<p>Minimum 15 minutes, or until fully and evenly matt over the whole repair area*, flash-off is required between coats.</p> <p>Minimum 15 minutes, or until fully and evenly matt over the whole repair area*, flash-off is required before baking.</p> <p>*Note: Allowing the Clearcoat Mix to flash off fully between coats and before bake is important to achieve an even appearance and gloss level over the whole area.</p>	
	<p>With P210-8430 Hardener</p> <p>Bake at metal temp. of 60°C : 30 minutes</p> <p>Into service : When cool</p>	<p>With P210-844 Hardener</p> <p>Bake at metal temp. of 60°C : 40 minutes</p> <p>Into service : When cool</p>
	<p>Short-wave : 8-15 minutes, full power Medium-wave : 15 minutes, full power (depending on colour and equipment)</p>	

General Process Notes

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:
P850-1492 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:
P850-1693 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

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 Finish is not possible.

OTHER POINTS TO NOTE

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

It is recommended that this clear 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 using 16xx thinners

Target Volume of RFU Paint required (Litres)	Weight P190-1061 / P190-6512 Mix	Weight P210-8430 / 844	Weight P850-1693 / 1694
0.10 L	62 g	82 g	99 g
0.20 L	124 g	164 g	197 g
0.25 L	155 g	205 g	246 g
0.33 L	207 g	273 g	328 g
0.50 L	311 g	410 g	492 g
0.75 L	466 g	615 g	738 g
1.0 L	622 g	820 g	984 g
1.5 L	932 g	1230 g	1476 g
2.0 L	1244 g	1640 g	1969 g
2.5 L	1555 g	2050 g	2461 g

WEIGHT MIX GUIDE using 14xx thinners

Target Volume of RFU Paint required (Litres)	Weight P190-1061 / P190-6512 Mix	Weight P210-8430 / 844	Weight P850-1492/3/4/5
0.10 L	62 g	82 g	100g
0.20 L	124 g	164 g	199 g
0.25 L	155 g	205 g	249 g
0.33 L	207 g	273 g	332 g
0.50 L	311 g	410 g	498 g
0.75 L	466 g	615 g	747 g
1.0 L	622 g	820 g	996 g
1.5 L	932 g	1230 g	1493 g
2.0 L	1244 g	1640 g	1992 g
2.5 L	1555 g	2050 g	2461 g

General Process Notes

GENERAL CARE AND MAINTENANCE OF MATT FINISHES

The following guidance on Care and Cleaning of matt 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 Finishes to maintain an original even Matt effect.

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

1. In order to keep the Matt 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 lead to 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.

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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