

# Product Data Sheet

July 2012

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY



## J2970V

### HS Plus Clearcoat P190-7020

<i>Product</i>	<i>Description</i>
P190-7020	HS Plus Clearcoat
P210-8815	HS Plus Hardener
P850-1692/1693/1694/1695	2K Low VOC Thinners
P852-1689	2K HS Plus Express Thinner

#### Product Description

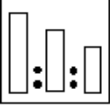








P190-7020 is an acrylic 2 component clearcoat optimized for use over AQUABASE® and AQUABASE® Plus basecoats.

#### Substrates / Preparation

P190-7020 should be applied only over: -

- P965 **Aquabase** basecoats
- 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 P190-7020

### Application Process

	Standard / High Temperature Application System	Express System
	P190-7020                      3 parts P210-8815                      1 part P850-16** series thinners    0.6 parts	P190-7020                      3 parts P210-8815                      1 part P852-1689 Express Thinner   0.6 parts
	18-20 secs. DIN4 at 20°C	
	Pot life at 20°C: 75 minutes	40 minutes
	It is recommended that the clearcoat is activated and thinned just prior to application.	
 	<b>Fluid Tip</b> Gravity Fed : 1.2-1.3 mm Inlet Pressure : Refer to spraygun manufacturers instructions, normally 2 bar/30 psi (inlet)	
	<b>Express Single Visit Process</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.	
	0 - 5 minutes flash-off required before baking, depending on oven type	
	Bake at a metal temperature of :  <u>210-8815/P850-16**</u>  60°C : 25 minutes  Into service : When cool	Bake at a metal temperature of :  <u>P210-8815/P852-1689</u>  60°C : 15 minutes  Into service : When cool
	 Short-wave : 8-15 mins full power (depending on colour and equipment). Metal temperature between 90°C and 100°C	

Product Data Sheet



## General Process Notes

### FADE-OUT PROCESS

Use **Aerosol Fade Out Thinner P850-1621** or **Express Blender P273-1105**.  
Refer to Fade-out / Blending Processes Technical Data Sheet M1000V for details.

### CHOICE OF HARDENER AND THINNER

Choose according to application temperature, air movement and size of job.  
For guidance only :-

**P210-8815** For applications in all temperature conditions

Thinner :	Ideal temperature range :
P850-1692	Up to 25°C
P850-1693	20°C - 30°C
P850-1694	25°C - 35°C
P850-1695	above 30°C
P852-1689 Express Thinner	18 - 22°C for small jobs

Use slower thinners in faster air movement booths, large jobs and high temperatures.  
Use faster thinner in slower air movement booths, small jobs and cooler temperatures.

### PAINT TEMPERATURE

Allow all components to reach room temperature (20 - 25°C) before use. 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 Plus basecoat, ensure the basecoat is thoroughly dry before applying the clearcoat.  
Use P210-8815 hardener and P850-1694 or P850 -1695 combination.

Setting for metal temperature from 90°C to 100°C.

### RECOATABILITY

P190-7020, in both standard and express modes, is fully recoatable after the "into-service" times.

### RECTIFICATION AND POLISHING

Polishing is not normally required as P190-7020 has a gloss finish. However, if dirt is a problem, denib with P1200 followed by P1500 and finished with Trizact P3000 or similar, then polish by machine using a quality polish such as SPP Polishing System (refer to SPP PDS) combined with a suitable polishing pad at minimum speed to avoid surface becoming too hot. If heating occurs allow it to cool down before continuing the polishing process.

Polishing of P190-7020 is easiest between 1 and 24 hours after "into service" drying times.



## General Process Notes

### RATIOS FOR TEXTURE AND FLEXIBLE OPTIONS

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. HS+ 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	P190-7020	P565-7210	P565-7220	P100-2020	HS Hardener	Thinner 1692/3/4/5
<b>Rigid</b>	Gloss	652g				883g	990g
	Fine Textured	267g	590g	-	-	732g	950g
	Coarse Textured	375g	-	672g	-	871g	973g
<b>Flexible</b>	Gloss	577g	-	-	663g	899g	1008g
	Fine Textured	207g	508g	-	604g	824g	965g
	Coarse Textured	300g	-	538g	677g	890g	972g

### 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.

### 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 scale between additions.

#### WEIGHT MIX GUIDE WITH P850-1692/3/4/5 and P852-1689

Volume of RFU Paint(Litres)	Weight P190-7020	Weight P210-8815	Weight P850-1692/1693/1694/1695 or P852-1689
0.10 L	65	88	98
0.25 L	161	219	246
0.33 L	213	289	325
0.60 L	390	528	588
0.75 L	484	657	738
1.00 L	646	877	983



**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 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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