

**HS Plus Clearcoat P190-6570**
**J2380 V**

# Product Data Sheet

October 2017

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY



## J2380V

### HS Plus Clearcoat P190-6570

<i>Product</i>	<i>Description</i>
P190-6570	HS Plus Clearcoat
P210-8645	HS Plus Hardener

#### Product Description

P190-6570 is an acrylic 2 component clearcoat Clearcoat designed as a 420g/l VOC restricted product to achieve 15 minutes @ 60°C drying time easy application and excellent final appearance result over Aquabase® Plus basecoats.

#### Substrates / Preparation

**P190-6570 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 P190-6570



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**Application Process**

	P190-6570                      2 parts P210-8645                      1 part
	16-18 secs. DIN4 at 20°C
	Pot life at 20°C: 1 hour sprayable time at 20°C DIN4cup. 1½ hour double viscosity
	<b>Fluid Tip</b> Gravity Fed : 1.2-1.3 mm Inlet Pressure : Refer to spraygun manufacturers instructions, normally 2-2.2 bar/30 psi (inlet)
	<b>Express Single Visit Process</b> Apply 1 light/medium closed coat followed by a full coat to give 50-60 microns 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 1½-2 minutes flash between spray coats. For more than 3 panels, no flash off is required.  <b>Two Coat Application Process</b> Apply 2 single coats to give 60-75 microns dry film thickness Allow 5 mins flash-off between coats.
	0 - 5 minutes flash-off required before baking, depending on oven type

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	Bake at a metal temperature:  60°C : 15 minutes  40°C : 40 minutes  20°C : 8 Hours  Into service : When cool
	Short-wave : 8 mins (depending on colour and equipment). Metal temperature between 90°C and 100°C

**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.

Volume of RFU Paint(Litres)	Weight P190-6570	Weight P210-8645
0,1 L	65,9	100,5
0,20 L	131,9	201,1
0,25 L	164,8	251,3
0,50 L	329,7	502,7
0,75 L	494,5	754,0
1,00 L	659,3	1005,3



## General Process Note

### Fade Out Process

Melt the overspray edge using Spot Blender(Can version), applied by spray-gun (Mini-jet 1,0-1,2mm)  
 Low pressure/Poor atomisation of the blender can cause small craters in the clearcoat surface.  
 Refer to Fade-out / Blending Processes Technical Data Sheet M1200V for details.

For applications in temperature conditions:

Hardener:  
 P210-8645

Ideal temperature range :  
 Up to 35°C

### PAINT TEMPERATURE

Allow all components to reach room temperature (20°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 P210-8645 hardener.

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

### RECOATABILITY

P190-6570, in both standard and express modes, is fully recoatable after the "into-service" times.

### RECTIFICATION AND POLISHING

Polishing is not normally required as P190-6570 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 P190-6570 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	P190-6570	P565-7210	P565-7220	P100-2020	HS Hardener	Thinner 1692/3/4/5
<b>Rigid</b>	Gloss	659,3	-	-	-	1005,3	-
	Fine Textured	292,3	650,7	-	-	814,3	959,7
	Coarse Textured	380,4	-	684,9	-	884,5	968,6
<b>Flexible</b>	Gloss	659,3	-	-	-	1005,3	-
	Fine Textured	292,3	650,7	-	-	814,3	959,7
	Coarse Textured	380,4	-	684,9	-	884,5	968,6

### 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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**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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