

# Product Data Sheet

October 2020

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY



## J3072V

### HS Plus Clearcoat P190-8002

<i>Product</i>	<i>Description</i>
P190-8002	HS Plus Clearcoat
P210-8812	HS Plus Hardener
P210-8813	HS Fast Plus Hardener
P852-1663	Express Thinner Medium
P852-1664	Express Thinner Slow

#### Product Description

This new Clearcoat (for use over 2K® and AQUABASE® Plus basecoats) has been developed to reinforce NEXA AUTOCOLOR® brand's position as a market leader of quality products. The New Express Plus Clearcoat provides market leading speed without any compromise on appearance, application or size of repair with the advantages of easy application and air dry capability. In order to achieve the optimum performance, this water white clearcoat uses dedicated hardeners and thinners depending on the temperature for ultimate flexibility. .

#### Substrates / Preparation

P190-8002 can be used over NEXA 2K® and 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 P190-8002

**HS Plus Clearcoat P190-8002**
**J3072V**

## Application Process

	<p style="text-align: center;"><b>Hardener and Thinner selection – Recommendation</b></p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: left;">Temperature °C)</th> <th style="text-align: center;">&lt; 20 and Air-dry</th> <th style="text-align: center;">20 &lt; T &lt; 30 Air-dry and Bake</th> <th style="text-align: center;">&gt; 30 and Bake</th> </tr> </thead> <tbody> <tr> <td><b>Hardener</b></td> <td style="text-align: center;">P210-8813</td> <td style="text-align: center;">P210-8812</td> <td style="text-align: center;">P210-8812</td> </tr> <tr> <td><b>Thinner</b></td> <td style="text-align: center;">P210-1663</td> <td style="text-align: center;">P210-1663</td> <td style="text-align: center;">P210-1664</td> </tr> </tbody> </table>			Temperature °C)	< 20 and Air-dry	20 < T < 30 Air-dry and Bake	> 30 and Bake	<b>Hardener</b>	P210-8813	P210-8812	P210-8812	<b>Thinner</b>	P210-1663	P210-1663	P210-1664																																
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	<p><b>MIXING BY WEIGHT:</b> The weights are cumulative - please do <b>NOT</b> tare the balance between additions.</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: left;">Volume of RFU paint required (Litres)</th> <th style="text-align: center;">P190-8002</th> <th style="text-align: center;">P210-8812/13</th> <th style="text-align: center;">P852-1663/64</th> </tr> </thead> <tbody> <tr><td>100,0 ml</td><td style="text-align: center;">56,2g</td><td style="text-align: center;">86,6g</td><td style="text-align: center;">101,6g</td></tr> <tr><td>200,0 ml</td><td style="text-align: center;">112,4g</td><td style="text-align: center;">173,1g</td><td style="text-align: center;">203,2g</td></tr> <tr><td>300,0 ml</td><td style="text-align: center;">168,7g</td><td style="text-align: center;">259,7g</td><td style="text-align: center;">304,8g</td></tr> <tr><td>400,0 ml</td><td style="text-align: center;">224,9g</td><td style="text-align: center;">346,2g</td><td style="text-align: center;">406,4g</td></tr> <tr><td>500,0 ml</td><td style="text-align: center;">281,1g</td><td style="text-align: center;">432,8g</td><td style="text-align: center;">508,0g</td></tr> <tr><td>600,0 ml</td><td style="text-align: center;">337,3g</td><td style="text-align: center;">519,3g</td><td style="text-align: center;">609,6g</td></tr> <tr><td>700,0 ml</td><td style="text-align: center;">393,6g</td><td style="text-align: center;">605,9g</td><td style="text-align: center;">711,2g</td></tr> <tr><td>800,0 ml</td><td style="text-align: center;">449,8g</td><td style="text-align: center;">692,4g</td><td style="text-align: center;">812,8g</td></tr> <tr><td>900,0 ml</td><td style="text-align: center;">506,0g</td><td style="text-align: center;">779,0g</td><td style="text-align: center;">914,5g</td></tr> <tr><td>1000,0 ml</td><td style="text-align: center;">562,2g</td><td style="text-align: center;">865,6g</td><td style="text-align: center;">1016,1g</td></tr> </tbody> </table> <p><b>Mix Ratio by volume:</b> <b>2 :1 :0,6</b></p>			Volume of RFU paint required (Litres)	P190-8002	P210-8812/13	P852-1663/64	100,0 ml	56,2g	86,6g	101,6g	200,0 ml	112,4g	173,1g	203,2g	300,0 ml	168,7g	259,7g	304,8g	400,0 ml	224,9g	346,2g	406,4g	500,0 ml	281,1g	432,8g	508,0g	600,0 ml	337,3g	519,3g	609,6g	700,0 ml	393,6g	605,9g	711,2g	800,0 ml	449,8g	692,4g	812,8g	900,0 ml	506,0g	779,0g	914,5g	1000,0 ml	562,2g	865,6g	1016,1g
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	18-19 secs. DIN4 at 20°C																																														
	Pot life at 20°C:		45 to 60 minutes																																												
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**HS Plus Clearcoat P190-8002**
**J3072V**

	<p><b>Fluid Tip</b></p> <p>Gravity Fed : 1.2 mm                  Inlet Pressure : Refer to spraygun manufacturers instructions, normally 2-2.2 bar/30 psi (inlet)</p>																		
	<p><b>One visit application</b></p> <p>Apply 1 light/medium &amp; 1 full coat.  <i>The first coat should be applied as a light <u>closed</u> coat.                  Second coat is applied as a full coat.</i></p> <p><b>Flash-off between coats:</b>  <i>One Visit application: If 1 -2 panels; 1 minute flash off.</i></p> <p><b>Flash-off before IR: 5 mins</b></p>																		
	<table border="0"> <thead> <tr> <th></th> <th>20°C</th> <th>40°C</th> <th>60°C</th> </tr> </thead> <tbody> <tr> <td>Dust free:</td> <td>20 minutes</td> <td>-----</td> <td>-----</td> </tr> <tr> <td>Dry to handle:</td> <td>60 minutes</td> <td>20 minutes</td> <td>5 minutes</td> </tr> <tr> <td>Polishing:</td> <td>90 minutes</td> <td>after cooling</td> <td>after cooling</td> </tr> </tbody> </table> <p>IR Drying: Short wave – 2-3 min @ 50% followed by 5-6 minutes @ 100%  <b>*Note: For Ir process use only P210-8812 and P852-1664</b>                  Drying times will depend on the type of infrared lamp used.</p>				20°C	40°C	60°C	Dust free:	20 minutes	-----	-----	Dry to handle:	60 minutes	20 minutes	5 minutes	Polishing:	90 minutes	after cooling	after cooling
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## General Process Notes

### FADE - OUT REPAIR PROCESS

- Prepare the fade out area with a 3000 grade soft pad on a DA sander.
- Apply P190-8002 according to the information above.
- Take care to minimise the clearcoat edge in the fade-out area.
- Immediately melt overspray edge using Spot Blender P273-1106.
- It is not recommended to fade out on ½ panels such as doors. It is more efficient to Clearcoat the whole panel.
- After a thorough bake or if necessary application of an IR lamp for 5-6 mins, sand the edge briefly with 3000 grade soft pad on a DA sander.
- This step is not essential but makes the polishing much easier.
- Polish with normal process system.

## 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	P190-8002	P565-7210	P565-7220	P100-2020	P210-8813/12	P852-1663/64
<b>Rigid</b>	Gloss	562,2g	-	-	-	865,6g	1016,1g
	Fine Textured	279,8g	612,6g	-	-	763,6g	980,0g
	Coarse Textured	361,4g	-	647,1g	-	816,1g	988,1g
<b>Flexible</b>	Gloss	446,5g	-	-	599,1g	856,1g	1015,4g
	Fine Textured	205,1g	497,9g	-	603,1g	750,7g	982,6g
	Coarse Textured	271,1g	-	485,4g	624,4g	809,6g	995,1g

### 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.

**HS Plus Clearcoat P190-8002****J3072V****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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