

Product Data Sheet

April 2010

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

J1540

Product Data Sheet

Clearcoat Supreme P190-625

<i>Product</i>	<i>Description</i>
P190-625	Clearcoat Supreme
P210-922	2K MS Hardener Extra Fast
P210-925	2K MS Hardener Normal
P210-926	2K MS Hardener Slow
P850-1491/-1492/-1493/-1494	2K Thinners
P273-1101	Anti-Crater Additive
P565-554	2K Matting Agent

Product Description






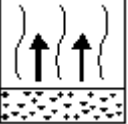
Nexa Autocolor, Clearcoat Supreme 625, is a higher solids 2K Clearcoat giving a "super wet-look" appearance. The product is extremely versatile producing the "OE Peel" pattern of many original finishes when mixed with 5-10% thinner with two coat application and a smoother finish when thinned 15-20% with 3 coat application. The product is highly durable and will retain its high gloss finish for many years when used as part of a recommended Nexa Autocolor 'system'.

Substrates/Preparation

P190-625 can be applied over:-





- P422-line 2K basecoat
- Prepared existing paintwork in sound condition. Existing paintwork should first be abraded (e.g. with **Scotchbrite™** Ultrafine Grey and/or P562-106) and cleaned with a suitable pre-cleaner prior to the application of P190-625.

Clearcoat Supreme 625 Process

	2 coats	3 coats
	P190-625 2 parts P210-922/-925/-926 1 part P 850-1491/-1492/ -1493/-1494 5 -10%	P190-625 2 parts P210-922/-925/-926 1 part P 850-1491/-1492/ -1493/-1494 15 - 20%
	17 -19 secs DIN4 at 20°C (20-22 secs .BSB4) Pot life at 20°C : 4 hours (925/926) 2 hours (922)	14-16 secs DIN4 at 20°C (16-18 secs BSB4) Pot life at 20°C : 4 hours (925/926) 2 hours (922)
 	Fluid Tip : Gravity Fed : 1.3-1.5 mm (0.051 -0.059 in) Suction Fed : 1.4-1.8 mm (0.055 – 0.070 in) Pressure : 3.0 - 3.7 bar (45-55 psi) at gun	Fluid Tip : Gravity Fed : 1.3-1.5 mm (0.051 -0.059 in) Suction Fed : 1.4-1.8 mm (0.055 – 0.070 in) Pressure : 3.0 - 3.7 bar (45-55 psi) at gun
	2 full wet single coats	3 wet single coats
	Approx 5 mins between coats No Flash off required before bake	Approx 5 mins between coats No Flash off required before bake

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Clearcoat Supreme 625 Process

	2 coats	3 coats
Baking 	Using -925/-926 -922 50°C 60 mins 40 mins 60°C 30 mins 15 mins 70°C 20 mins Into Service when cool	Using -925/-926 -922 50°C 60 mins 40 mins 60°C 30 mins 15 mins 70°C 20 mins Into Service when cool
Air Dry at 25°C 	Using -925/-926 -922 Dust free 10-15 mins 10 mins Handleable 6 hours 3 hours Into Service 16 hours 8 hours	Using -925/-926 -922 Dust free 10-15 mins 10 mins Handleable 6 hours 3 hours Into Service 16 hours 8 hours
Dirt Removal 	Denib P1500 or finer using soap and water	Denib P1500 or finer using soap and water
Gloss Restoration 	By Hand or machine (Lambswool Pad) Burnishing Cream 993-35124 By Machine (Foam Pad) Cutting Cream 993-42947 By Hand or Machine Finishing Glaze 994-42960	By Hand or machine (Lambswool Pad) Burnishing Cream 993-35124 By Machine (Foam Pad) Cutting Cream 993-42947 By Hand or Machine Finishing Glaze 994-42960

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General Process Notes

FADE-OUT PROCESS

1. Flash-off basecoat for 10-20 minutes before applying Clearcoat.
2. Apply clearcoat to the whole panel or up to a breakline. If "fading out" the clearcoat, make sure to (a) cover the Basecoat edge and (b) only fade into the prepared surface. See 2K Fade-Out Process PDS M0300.

TINTING

Certain basecoat colours require the use of a tinted clearcoat to achieve a colour match, as specified on the microfiche. Where this is required, P190-625 may be used as a tinted clearcoat by the addition of up to 20% of a limited range of 2K tinters, in accordance with the microfiche formulation.

Please refer to 2K Tinted clearcoat process PDS J1000 for details of how to achieve a colour match where a tinted clearcoat is required. When using a tinted clearcoat finish, a final coat of untinted clearcoat is recommended for maximum durability and protection of colour.

CHOICE OF HARDENER

Nexa Autocolor offers a range of hardeners to suit the speed and quality requirements needed for every type and size of repair, under all conditions.

Temperature(°C)	15	20	25	30	35	40	
Hardener	P210- 922		P210-925			P210-926	
Thinner	P850-1491		P850-1492		P850-1493		P850-1494

When spraying large jobs or in fast air movement booths and at higher temperatures, use slower hardeners and thinners. When spraying smaller jobs or in slower air movement booths, and at cooler temperatures, use faster hardeners and thinners.

When air drying at cool or normal temperatures or when undertaking panel/small area repairs in low bake conditions (up to 30°C) use P210-922 Extra Fast Hardener for reduced drying times.

General Process Notes

CRATER PREVENTION, USE OF P273-1101

In the event of fisheyes or craters in the first coat of application add 1% i.e. 10g P273-1101 to 1 litre of ready to spray Clearcoat Supreme (P190-625). Continue application as normal. Do not exceed 3% level or add to 2K basecoats or 2K Undercoats. Eliminate cause of contamination (e.g. dirt, wax, silicone) and/or switch to faster paint system.

RECOATABILITY

P190-625 is fully recoatable after the "into service" times.

REDUCTION OF GLOSS LEVELS

The gloss level of P190-625 may be reduced by the addition of P565-554 2K Matting Agent according to the colour formulation provided on the microfiche. Alternatively, use the following guidelines :-

Gloss Level :	P190-625	:	P565-554
Semi-gloss	2 parts (67%)	:	1 part (33%)
Eggshell	3 parts (60%)	:	2 parts (40%)
Matt	1 part (50%)	:	1 part (50%)

This mix should then be activated and thinned as standard P190-625. Where a matt finish is required in the repair of a plastic part, refer to the **Nexa Autocolor** Plastics Painting System PDS.

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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