

Product Data Sheet

May 2012

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

J4510

2K Clearcoat P190-559	
<i>Product</i>	<i>Description</i>
P190-559	2K Clearcoat
P210-760/-770/-794	2K Hardeners
P210-790	2K Express Hardener
P850-1490/1491/1492/1493/1494/1495	2K Thinners
P850-1401	Fade Out Thinner
P850-1621	Aerosol Fade-out Thinner
P275-220	2K Rapid Dry Catalyst

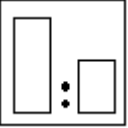



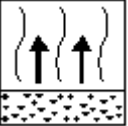
Product Description

P190-559 is a high quality normal solids 2-pack Clearcoat, designed to give an outstanding base and clear finish with **Nexa Autocolor** 2K or Belco Basecoats. The product is an easy 2-3-coat application giving an excellent smooth, glossy and hard 2K finish. P190-559 is designed to be used with standard 2K Hardeners, P210-760,-770 or -794. In combination with P210-790 Express hardener, rapid air-drying or reduced bake times can be achieved, enabling repair times to be reduced for high throughput.

Substrates and Preparation

P190-559 should only be applied over: -

- P422-line 2K basecoat
- P032-/P033-line Belco basecoat
- Prepared existing paintwork in sound condition. Existing paintwork should be first abraded (e.g. with Scotchbrite™ Ultrafine Grey and/or P562-106) and cleaned using P850-14 or P850-1402 prior to application of P190-559.

PROCESS		
Usage	Standard Air-Dry/Low Bake Process 2 COAT SYSTEM	Standard Air-Dry / Low Bake Process 3 COAT SYSTEM
Hardeners	P210-760/-770/-790/-794	P210-760/-770/-790/-794
	P190-559 2 parts P210-7* 1 part	P190-559 2 parts P210-7* 1 part P850-149* 5 - 10% * Use appropriate thinner for temperature and size of job.
	15-16 secs DIN4 at 20°C (18-20 secs BSB4) Pot-Life at 20°C: 4-8 hours	13-14 secs DIN4 at 20°C (15-17 secs BSB4) Pot-Life at 20°C: 4-8 hours
	Fluid Tip: Gravity Fed: 1.3-1.6 mm Suction Fed: 1.4-1.8 mm Pressure: 3.0-3.3 bar (45-50 psi)	Fluid Tip: Gravity Fed: 1.3-1.6 mm Suction Fed: 1.4-1.8 mm Pressure: 3.0-3.3 bar (45-50 psi)
	2 full single coats	1 half coat + 2 full single coats
	5-10 mins between coats No flash off required before baking	5-10 mins between coats No flash off required before baking

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PROCESS (Continued)



P210-770/-794 Bake at a metal temperature of:

70°C 20 mins
60°C 30 mins
50°C 60 mins

P210-790 Bake at a metal temperature of:

60°C 10 mins
50°C 20 mins
Into Service: When cool

Air Dry (20°C)

Dust Free 10 - 15 mins
Handleable 6 hours = -760/-770/-794
2 hours = -790
Into Service 16 hours = -760/-770/-794
4 hours = -790

P210-770/-794 Bake at a metal temperature of:

70°C 20 mins
60°C 30 mins
50°C 60 mins

P210-790 Bake at a metal temperature of:

60°C 10 mins
50°C 20 mins
Into Service: When cool

Air Dry (20°C)

Dust Free 10 - 15 mins
Handleable 6 hours = -760/-770/-794
2 hours = -790
Into Service 16 hours = -760/-770/-794
4 hours = -790

GENERAL PROCESS NOTES

FADE-OUT PROCESS

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. Any dry spray may be dissolved by applying P850-1401.

Please refer to Fade-out process TDS for full basecoat/clearcoat details.

Alternatively, use P850-1621 Aerosol Fade-out Thinner. See TDS M1000V for process to achieve a successful repair.

TINTING

Certain basecoat colours require the use of a tinted clearcoat to achieve a colourmatch, as specified on the microfiche. Where this is required, P190-559 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 TDS for details of how to achieve a colourmatch 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.

P210-760 is recommended for air-dry work and also suitable for a low-bake process under cooler conditions (e.g. up to 25°C).

P210-770 is recommended for low-bake work, across a temperature range of 20-30°C.

P210-794 is recommended for optimum application for all job types under conditions of high temperature (30°C or above).

Note - At temperatures of 35°C, 5% of P850-1495 2K thinner may be added. When adding thinner, care should be taken to ensure a minimum film thickness of 50 microns is achieved.

P210-790- provides the quickest way to process small repairs (air-dry or 10 minutes bake at 60°C metal temperature) and is also ideal for use in cold conditions (i.e. below 20°C).

CHOICE OF THINNER

When using P210-790 the choice of thinner should be made according to application temperature, air movement and size of job.

Thinner	Temperature
P850-1490	Below 15°C
P850-1491	15 - 25°C
P850-1492	20 - 30°C
P850-1493	25 - 35°C
P850-1494	30 - 40°C
P850-1495	Over 40°C

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

For further information please contact:

Customer Service Sales Group
PPG Industries (UK) Ltd
Needham Road
Stowmarket
Suffolk IP14 2AD
Tel: 01449 771771
Fax: 01449 773472

Product Data Sheet

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