

Product Data Sheet

July 2014

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

J1920

2K HS Clearcoat P190-6850

<i>Product</i>	<i>Description</i>
P190-6850	2K HS Clearcoat
P210-842	2K HS Hardener Fast
P210-8430	2K HS Hardener Medium Fast
P210-8480	2K Hardener for P190-6850
P210-844	2K HS Hardener Medium
P210-845	2K HS Hardener Slow
P850-1490/1491/1492/ 1493/1494/1495	2K Thinners
P850-1401	Fade Out Thinner
P850-1622	Spot Blender Aerosol

Product Description

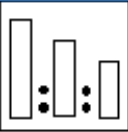





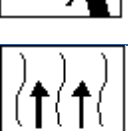

P190-6850 is a high quality HS 2-Pack acrylic clearcoat, which can be used over NEXA AUTOCOLOR® 2K, AQUABASE® & AQUABASE® PLUS basecoats. Suitable for all types of repair, it offers a hard and durable finish enabling early handling of the repair after drying. P190-6850 is used with HS hardeners to give optimum final appearance.

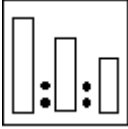





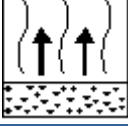

Substrates and Preparation

P190-6850 should only be applied over: -

- P422-line 2K basecoat
- P965 line *Aquabase* basecoat
- P989-line *Aquabase Plus* basecoat
- Prepared existing paintwork in sound condition. Existing paintwork should first be abraded (e.g. with Scotchbrite™ Ultrafine Grey and P562-106) and cleaned with a suitable pre-cleaner prior to application of P190-6850.

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PROCESS		
	FAST PROCESS	STANDARD PROCESS
HARDENERS	P210-842 Small - Medium Size Repairs	P210-8430/844/8480 All Size Repairs
	P190-6850 2 parts P210-842 1 part P850 - 2K Thinner 0 - 0.15 part* *Choose thinner appropriate to job	P190-6850 2 parts P210-8430/844/84 1 part P850 - 2K Thinner 0 - 0.15 part* *Choose thinner appropriate to job
	17-18 secs DIN4 at 20°C (21-24 secs BSB4) Pot-Life at 20°C: 1.5 hours	17-18 secs DIN4 at 20°C (21-24 secs BSB4) Pot-Life at 20°C: 2 hours
	Fluid Tip: Gravity Fed: 1.3-1.5 mm Suction Fed: 1.4-1.6 mm Pressure: 3.0-3.7 bar (50-55 psi)	Fluid Tip: Gravity Fed: 1.3-1.5 mm Suction Fed: 1.4-1.6 mm Pressure: 3.3-3.7 bar (50-55 psi)
	Fluid Tip: Gravity fed: 1.2-1.4 mm Suction fed: 1.4-1.6 mm Pressure: 10 psi max (air cap)	Fluid Tip: Gravity fed: 1.2-1.4mm Suction fed: 1.4-1.6 mm Pressure: 10 psi max (air cap)
	Fluid Tip: Gravity Fed: 1.2-1.4 mm Suction Fed: 1.4-1.6 mm Inlet Pressure: Refer to spraygun manufacturers instructions, normally 2 bar/30 psi (inlet)	Fluid Tip: Gravity Fed: 1.2-1.4 mm Suction Fed: 1.4-1.6 mm Inlet Pressure: Refer to spraygun manufacturers instructions, normally 2 bar/30 psi (inlet)
	2 Single Coats	2 Single Coats
	5-10 mins between coats No flash off required before baking	5-10 mins between coats No flash off required before baking
	Bake at a metal temperature of: 60°C 20 mins Into Service: When fully cool	Bake at a metal temperature of: 60°C 30 mins Into Service: When fully cool

PROCESS	
	HIGH TEMPERATURE PROCESS
HARDENER	P210-845 High Temperature Hardener
	P190-6850 2 parts P210-845 1 part P850-2KThinner 0 - 0.15 part* *Choose thinner appropriate to job
	18-20 secs DIN4 at 20°C (23-26 secs BSB4) Pot-Life at 20°C: 2 hours
	Fluid Tip: Gravity Fed: 1.3-1.6 mm Suction Fed: 1.4-1.8 mm Pressure: 3.0-3.7 bar (45-55 psi)
	Fluid Tip: Gravity fed: 1.2-1.4 mm Suction fed: 1.4-1.6 mm Pressure: 10 psi max (air cap)
	Fluid Tip: Gravity Fed: 1.2-1.4 mm Suction Fed: 1.4-1.6 mm Inlet Pressure: Refer to spraygun manufacturers instructions, normally 2 bar/30 psi (inlet)
	2 Single coats.
	5-10 mins between coats No flash off required before baking
	Bake at a metal temperature of: 60°C 40 mins Into Service: When fully cool

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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 PDS for full basecoat/clearcoat details.

Alternatively clearcoat may be faded-out using the Spot Blender Aerosol P850-1622 or Spot Blender P273-1106. Please refer to the Fade-out / Blending Processes Technical Data Sheet M1200V for details of the technique to achieve a successful repair.

CHOICE OF THINNER

The choice of thinner should be made according to application temperature, hardener choice, air movement and size of job. The recommendations below are for guidance only: -

Thinner	Ideal temperature range:
P850-1490	Below 20°C
P850-1491	15-25°C
P850-1492	20-30°C
P850-1493	25-35°C
P850-1494	30-40°C
P850-1495	Above 35°C

RECOATABILITY

P190-6850 is fully recoatable after the "into-service" times.

GENERAL PROCESS NOTES

RECTIFICATION AND POLISHING

Polishing is not normally required as P190-6850 has a gloss finish. However, if dirt is a problem, denib with P1500 or finer, then polish by machine using a quality polish such as SPP Polishing System (refer to SPP PDS). Polishing of P190-6850 is easiest between 1 and 24 hours after "into service" drying times.

PAINTING PLASTICS

Use the standard *Nexa Autocolor* Plastics Painting System (refer to PDS).

OTHER POINTS TO NOTE

1. For optimum application, ensure both spray booth air temperature and paint temperature is above 20°C.
Best results will be obtained by allowing adequate time for the paint to reach spray booth temperature before use.
2. When using 2-pack products it is essential to clean the gun thoroughly immediately after use.

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:

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