

Product Data Sheet

January 2020

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY

J1930

HS Clearcoat P190-6870	
Product	Description
P190-6870	2K HS Clearcoat
P210-8632/-8633/-8634	2K HS Hardeners
P850-1491/1492/1493/1494 P852-1661	2K Thinners High Temperature Thinner

Product Description

HS Clearcoat P190-6870 is a new acrylic 2 component clearcoat optimised for use over NEXA AUTOCOLOR® 2K & AQUABASE® Plus basecoats. Suitable for all types of repair, this new Clearcoat was developed to improve the application experience giving an easy to apply conventional 2 coat process or a 1 visit application mode.

P190-6870 gives a faster 15min drying time at 60°C or a 30min low energy option at 40°C
P190-6870 is hard from bake, yet easy to polish if needed and gives great final appearance.

Substrates / Preparation

HS Clearcoat P190-6870 should be applied on top of clean and dust-free basecoat.
The use of a tack rag is recommended just prior to clearcoat application.

HARDENER AND THINNER SELECTION

Temperature	Hardener	Thinner
Up to 20°C	P210-8632	P850-1491/1492
20-30°C	P210-8633	P850-1492/1493
Above 30°C	P210-8634	P852-1661* See Notes below

Note: The choice of hardener/thinner should be made according to application temperature, air movement and size of job.

When using IR drying equipment - thinner P852-1661 must be used.

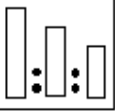




At temperatures above 30°C

- Over Aquabase Plus basecoat, thinner P852-1661 must be used.



- Over 2K basecoat either thinner P850-1494 or P852-1661 can be used.

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PROCESS			
	Mix by Volume Clearcoat P190-6870 2 parts Hardener P210-8632/33/34 1 part Thinner P850-1491/1492/93/94 0,5 part OR P852-1661 High Temperature Thinner		
Target Volume of RFU Paint required (Litres)	Weight Clearcoat P190-6870	Weight Hardener P210-863x	Weight Thinner P850-149x/P852-1661
0.10 L	57.0	85.3	98.2
0.20 L	114.1	170.6	196.3
0.50L	285.1	426.6	490.9
0.75 L	427.7	639.9	736.3
1.0 L	570.3	853.1	981.7
1.5L	855.4	1279.7	1472.6
2.0 L	1140.6	1706.3	1963.4
	14-16 secs DIN4 at 20°C		
	Pot-Life at 20°C: 2 hours		
	Gravity spraygun recommended. Set air-pressure in line with spraygun manufactures recommendations.		
	Fluid tip : Gravity Gun 1.2-1.3 mm		
	1. Apply 2 single coats to give 50-60 microns dry film thickness (2 mins flash-off between coats)		
OR			

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	2. Apply 1 light coat followed by a full coat to give 50 microns dry film thickness. No flash off is required between coats			
	Bake at a metal temperature of: 40°C (Low Energy) 60°C	P210-8632 30 mins 15 mins	P210-8633 30 mins 15 mins	P210-8634 30 mins 20 mins
	Always allow repairs to cool down fully before any sanding, polishing or rectification works			
	Air-dry (20°C) : Polishable	4 hours.	4 hours	4 hours
	Infra-red drying - Shortwave Approximately 5 mins full power (depending on colour and equipment)			
	Note: When IR Drying – Thinner P852-1661 should be used.	Infra-red drying Approximately 10 mins full power (depending on colour and equipment)		

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General Process Notes

CLEARCOAT BLENDING PROCEDURE

It is recommended to use P850-1622 Spot Blender Aerosol or P273-1106 Spot Blender

Refer to Nexa Autocolor datasheet M1200 for successful repair.

1. Key the surrounding area with a wet 1000 grade Trizact™ pad on a DA sander (3mm orbit). If clearcoat is to be faded out (up a pillar) this area should be finished with a wet Trizact™ 3000 pad.
2. Prepare less accessible areas using P562-106 Water-borne Flattening Paste with an abrasive Scotchbrite™ Ultrafine (Grey) or Extra Fine (Copper) pad.
3. Thoroughly clean and tack the area to be refinished, ready for painting.
4. Apply P190-6870 HS Clearcoat according to the information above.
5. After normal application, the gun is arced away from the panel in the blend area leaving a fine, dry overspray edge.
6. Apply the Spot Blender Aerosol (or the Spot Blender through a spraygun) to the clearcoat edge, in light coats to melt the overspray edge. DO NOT apply heavy coats.
7. Allow the paint film to thoroughly cure following the drying recommendations.
8. Lightly polish the blend area with polishing compound (SPP1001), taking care not to polish through the blend. Finish with a finishing polish.

HS Clearcoat P190-6870**J1930****PROCESS NOTES**

- After use, clean all equipment thoroughly with cleaning solvent or thinner.
- Maintain RFU temperature above a minimum of 15°C, and ideally over 18°C. This includes paint, hardeners and thinners.

HEALTH AND SAFETY

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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