Product Data Sheet

May 2012

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

J4330

2K MS Clearcoat
P190-598

Product	*Description*
P190-598	2K MS Clearcoat
P210-8430/-844/-845	2K HS Hardeners
P210-842	2K HS Express Hardener
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

Product Description

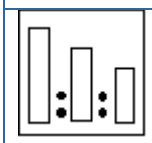
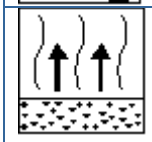
P190-598 is a versatile high quality 2-Pack acrylic clearcoat, which can be used over **Nexa Autocolor** 2K basecoats. Suitable for all types of repair, it offers a hard and durable finish enabling early handling of the repair after drying. It can be used in conjunction with the HS hardener range to give superb gloss and appearance with good build. When used with Express hardeners, P210-842 and P210-790, a combination of rapid drying and high performance can be achieved which enables repair process times to be significantly reduced.

Substrates/Preparation

P190-598 should only be applied over: -

- P422-line 2K basecoat
- P965-line Aquabase™ waterborne basecoat
- P989-line Aquabase Plus waterborne 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 P190-598.

Standard Process (All Repairs)

HARDENERS	P210-8430/-844/	P210-845 (High Temperature Process)
	P190-598 2 parts P210-8430/-844 1 part * P850 - 2K Thinner 10-15%	P190-598 2 parts P210-845 1 part * P850 - 2K Thinner 10-15%
	17-19 secs DIN4 at 20°C (22-24 secs BSB4) with 10% thinner **Pot-Life at 20°C:** 4 hours	17-19 secs DIN4 at 20°C (22-24 secs BSB4) with 10% thinner **Pot-Life at 20°C:** 4 hours
	Fluid Tip Gravity Fed : 1.3-1.6 mm Suction Fed : 1.4-1.8 mm Pressure : 3.3-3.7 bar (50-55 psi)	Fluid Tip : Gravity Fed : 1.3-1.6 mm Suction Fed : 1.4-1.8 mm Pressure : 3.3-3.7 bar (50-55 psi)
	Fluid Tip : Gravity fed : 1.3-1.6 mm Suction fed : 1.5-1.8 mm Pressure : 10 psi max (air cap)	Fluid Tip : Gravity fed : 1.3-1.6 mm Suction fed : 1.5-1.8 mm Pressure : 10 psi max (air cap)
	2 full single coats	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
	***Bake at a metal temperature of :*** 70°C 20 mins 60°C 30 mins 50°C 60 mins Into Service : When cool	***Bake at a metal temperature of :*** 70°C 30 mins 60°C 40 mins 50°C 60 mins Into Service : When cool

* **NOTE:** Use appropriate thinner for temperature and size of job.

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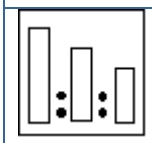
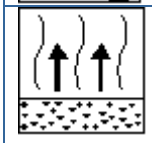
Express Process

HARDENERS	P210-842 (Medium sized repair)	P210-790 (Panel/spot repair)
	P190-598 2 parts P210-842 1 part P850-2K Thinner 10-15%*	P190-598 3 parts P210-790 2 parts P850-2K Thinner 10-15%*
	17-19 secs DIN4 at 20°C (22-24 secs BSB4) with 10% thinner **Pot-Life at 20°C:** 2 hours	17-19 secs DIN4 at 20°C (22-24 secs BSB4) with 10% thinner **Pot-Life at 20°C:** 1 hour
	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 : 1.3-1.6 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 : 1.5-1.8 mm Pressure : 10 psi max (air cap)	Fluid Tip : Gravity fed : 1.3-1.6 mm Suction fed : 1.5-1.8 mm Pressure : 10 psi max (air cap)
	2 full single coats	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
	***Bake at a metal temperature of :*** 60°C 20 mins 50°C 40 mins Into Service : When cool	***Bake at a metal temperature of :*** 60°C 10 mins 50°C 20 mins Into Service : When cool

* Use appropriate thinner for temperature and size of job.

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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, use P850-1621 Aerosol Fade-out Process. See TDS for details.

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, P190-598 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 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.

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

P210-842 combines accelerated drying (20 minutes bake at 60°C metal temperature), with a top quality finish on medium repairs. Ideal for temperatures up to 25ºC

P210-8430 is suitable for larger areas (e.g. complete repaint) at temperatures up to 25ºC.

P210-844 should be used in place of P210-8430 when the temperature lies between 25 and 30°C.

P210-845 may be used as an alternative to P210-844 when the temperature exceeds 30°C.

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 Extra Fast	10-20°C
P850-1491 Fast	15-25°C
P850-1492 Medium	20-30°C
P850-1493 Slow	25-35°C
P850-1494 Extra Slow	30-40°C
P850-1495 High Temperature	35-45°C

In general use a slower thinner in fast air movement booths, for large jobs and for HVLP application. Use a faster thinner in slow air movement booths and for small jobs.

General Process Notes

RECOATABILITY

When using P210-8430, -844, -845, or -842, P190-598 is fully recoatable after the "into-service" times. The very fast curing of P210-790 results in a different behaviour from standard 2K systems. When recoating is required, this is best done within one hour after bake. If recoat is required after this period, the repair should first either be given a further 10 minute bake or be left to air-dry for 5 hours. (at 20°C).

RECTIFICATION AND POLISHING

Polishing is not normally required as P190-598 has a full gloss finish. If dirt is a problem, denib with P1200 or finer, then polish by machine using a quality polish such as SPP Polishing System (refer to SPP PDS). Polishing of P190-598 is easiest up to 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 spraybooth air temperature and paint temperature are above 20ºC. Best results will be obtained by allowing adequate time for the paint to reach spraybooth 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**

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