

Product Data Sheet

April 2007

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

10400

2K P422 - Basecoat System

<i>Product</i>	<i>Description</i>
P422-	2K Basecoat Colours
P420-/P425-/P426-/P429-/P433- P434-/P440-	2K Mixing Basics
P417-/P419	Readymix basecoats
P192-475	Solid colour basecoat converter
P192-5600	Basecoat flip controller
P192-528	High aluminium flip controller
P850-1490/-1491/-1492/ -1493/-1495	2K Thinners
P273-1051	Basecoat fade-out additive

Product Description

The **Nexa Autocolor** 2K mixing scheme has the capability to provide a full range of single-stage and basecoat finishes from a single set of mixing basics. P422-line is an acrylic basecoat colour system, which used in combination with recommended **Nexa Autocolor** 2-pack clearcoats offers a hard and durable finish with superb gloss and coverage suitable for all types of repair work.

Innovating Repair Solutions

Substrates and Preparation

P422-line should only be applied over:-

- **Nexa Autocolor** 2-pack primer/undercoat, hand flatted with P800 or finer grade wet or dry paper, or machine sanded with P360 grade or finer, prior to topcoat application.
- **Nexa Autocolor** 2-pack Wet-on-wet primer.
- Prepared existing paintwork in sound condition. Existing paintwork should first be abraded (e.g. with Scotchbrite™ Ultrafine Grey and/or P562-100) and cleaned with a suitable pre-cleaner prior to application of P422-line colours.

NOTE : On new panels coated in works primer/electrocoat it is recommended that a **Nexa Autocolor** 2-pack primer is applied.

GENERAL PROCESS NOTES

SPECTRAL GREYS

All colours will benefit from the use of one of the 7 Spectral Greys (SG01-SG07). Use of the specified Spectral Grey will ensure that the minimum volume of basecoat colour is used and that the basecoat process time is optimised. The recommendation for which Spectral Grey to use can be found on our colour communication systems (microfiche and electronic balances). Where there is no Spectral Grey specified then SG05 should always be selected.

COLOUR IDENTIFICATION AND CHECKING

As with all refinish paint systems, a colour check should be carried out before painting. Ensure mix is thoroughly stirred before carrying out colour check. This is particularly important with 3-Stage Pearlescent finishes, because their transparent nature means that a fade-out process is difficult.

2K COLOUR MIXING

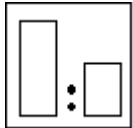



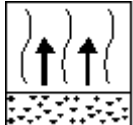

P422-line 2K metallic, pearlescent & special effect colours are mixed from P420-, P425-, P426-, P429, P433, P434 and P440-line mixing basics with P192-5600 and P192-528 Flip controllers using the weight-mix recipes provided. P422-line 2K solid colour basecoats are mixed from P420-, P425- and P429-line mixing basics with P192-475 SCB converter.

P422 colour mixes must be stirred immediately after mixing to ensure consistent colour and application properties.

In order to ensure colour accuracy, it is essential that new cans of 2K mixing basics are thoroughly hand-stirred when opened, followed by 10 minutes stirring on a mixing machine. Thereafter, mixing basics should be machine stirred twice a day for a minimum of 10 minutes each time.

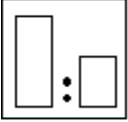




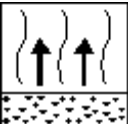

NB: P433 and P440 line mixing basics do not require regular stirring – just shake and pour.

2K BASECOAT PROCESS

	<p>Metallic, 2-stage Pearlescent & Special Effect Basecoats. P422-XXXXB/P417/P419</p>	<p>Solid Colour Basecoats. P422-XXXXB</p>
	<p>P422-P850-149x 1 part 1 part</p>	<p>P422-P850-149x 1 part 1 part</p>
	<p>Sprayed at low viscosity. Thin by volume only</p>	<p>Sprayed at low viscosity. Thin by volume only.</p>
	<p>Fluid tip: Gravity fed / Suction fed: 1.3-1.6 mm Pressure : Refer to gun manufacturer's instructions</p>	<p>Fluid tip: Gravity fed / Suction fed: 1.3-1.6 mm Pressure : Refer to gun manufacturer's instructions</p>
	<p>Apply single coats to cover (normally 2) followed immediately by a light coat applied into the wet film for even metallic appearance.</p>	<p>Apply single coats to cover (normally 2)</p>
	<p>Approx. 3-5 mins between coats.</p>	<p>Approx. 3-5 mins between coats.</p>
	<p>10-20 mins until uniformly dry, before clearcoating. 30 mins before masking</p>	<p>10-20 mins until uniformly dry, before clearcoating 30 mins before masking</p>
<p>CLEARCOAT</p>	<p>Use any recommended Nexa Autocolor 2K Clearcoat. (See Clearcoat TDS for suitability) It is not recommended to apply 1-Pack Clearcoat over 2K Basecoat.</p>	

2K BASECOAT PROCESS

2K - 3-STAGE PEARL PROCESS

	P422-XXXXG 2K Groundcoat	P422-XXXXB 2K Pearlcoat/Special Effect Colour
	P422- P850-149x 1 part 1 part	P422- P850-149x 1 part 1 part
	Sprayed at low viscosity Thin by volume only.	Sprayed at low viscosity Thin by volume only.
	Fluid tip: Gravity fed / Suction fed: 1.3-1.6 mm Pressure : 2.7-3.0 bar (40-45 psi)	Fluid tip: Gravity fed / Suction fed: 1.3-1.6 mm Pressure : 2.7-3.0 bar (40-45 psi)
	Fluid tip: Gravity fed / Suction fed: 1.3-1.6 mm Pressure : Refer to gun manufacturer's instructions	Fluid tip: Gravity fed / Suction fed: 1.3-1.6 mm Pressure : Refer to gun manufacturer's instructions
	Apply single coats to cover (normally 2)	Apply single coats based on colour check panel. This product is not designed to give opacity.
	3-5 mins between coats	3-5 mins between coats.
	10-20 mins before applying 2K Pearlcoat	10-20 mins until uniformly dry, before clearcoating
CLEARCOAT	Use any recommended Nexa Autocolor 2K Clearcoat. (See Clearcoat TDS for suitability) It is not recommended to apply 1-Pack Clearcoat over 2K Basecoat.	

Product Data Sheet

Innovating Repair Solutions

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY.

GENERAL PROCESS NOTES

FADE-OUT PROCESS

P422- line colours, with the exception of 3-stage pearlescent basecoat colours, may be easily faded-out using P273-1051 or P850-1401. Please refer to fade-out process PDS for details.

The transparent nature of 3-stage pearlescent colours means that a fade-out process is more difficult to achieve. Refer to fade-out process PDS for details. Alternatively, the fade-out process may be avoided, either by a complete panel repair or by using break lines to reduce the size of the area to be painted.

CHOICE OF THINNER

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

P850-1490	<15°C
P850-1491	15-25°C
P850-1492	20-30°C
P850-1493	25-35°C
P850-1494	30-40°C
P850-1495	>40°C

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

RECTIFICATION

The fast drying of 2K Basecoat makes rectification very easy. For 2-stage metallic, pearlescent, special effect and solid colour basecoats, simply wet flat when fully dry with P1200 paper or Scotchbrite™ Ultrafine, then re-apply basecoat. If fade-out is required refer to Fade-out PDS. For 3-stage pearl colours re-application of both groundcoat and pearlcoat is recommended.

PAINTING PLASTICS

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

OTHER POINTS TO NOTE

- For optimum application, ensure both ambient temperature and paint temperature are above 20°C. Best results will be obtained by allowing adequate time for the paint to reach spraybooth temperature before use. It is recommended that 2K mixing basics are stored in the temperature range of 15-30°C.
- For some specified warranty repair systems and for vehicles likely to require an exceptionally high level of film performance, P422- line basecoats may be activated and thinned as follows:

8 parts	P422 mix
1 part	P210-796, P210-798, P210-832, P210-8430, P210-844 or P210-842
9 parts	P850-149x

P210-790 should not be used to activate P422- line basecoats

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: http://www.ppg.com/Autocolor_MSDS

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

Nexa Autocolor, **ZK**, Aquabase, Aquadry, Belco and Ecofast are trademarks of PPG Industries.
Copyright © 2007 PPG Industries, all rights reserved.
Copyright in the above product numbers that are original is asserted by PPG Industries.

Scotchbrite is a trademark of 3M UK Plc.

Innovating Repair Solutions