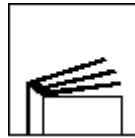


FOR PROFESSIONAL USE ONLY



# I0110

Date of Issue: July 2002

## 2K P420 - Single Layer Solid Colour System Normal Solids

Products	
P420-	2K Single-layer Solid Colour mixes and 2K Readymix
P420-/P425-/P429-	2K Mixing basics
P190-376	2K Adjuster
P210-760/-770	2K Hardeners
P210-790	Express Hardener
P850-1692/-1693/-1694	2K Low VOC Thinners
P850-1401	Fade-out Thinner
P851-727	Retarder
P275-220	2K Rapid Dry Catalyst
P017-773	2K Air dry lacquer converter
P565-554	2K Matting Agent

### 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.

P420-line is a 2-pack acrylic single-layer solid colour system based on this mixing scheme which offers a hard and durable finish with superb gloss and coverage suitable for all types of repair work.

Using P420-line with 2K hardeners P210-760/-770 gives a 3-coat process, ideal for both air-dry and low bake users in all conditions. 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 bodyshop throughput.

**THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE  
VEHICLES ONLY AFTER REFERENCE TO THE MANUFACTURER'S  
MATERIAL SAFETY DATA SHEET**

## **GENERAL PROCESS INFORMATION**

### **SUBSTRATES AND PREPARATION**

P420-line should only be applied over :-

- **Nexa Autocolor** 2-pack primer/undercoat, hand flatted with P600 or finer grade wet or dry paper, or machine sanded with P320 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 P850-14 or P850-1402 prior to application of P420-line colours.

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

### **COLOUR IDENTIFICATION AND CHECKING**

As with all Refinish paint systems, a colour check should be carried out before painting the vehicle. Ensure the check mix is thoroughly stirred before carrying out colour check.

### **2K COLOUR MIXING**

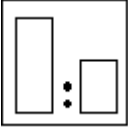



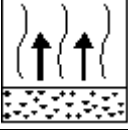

P420-line 2K colours are mixed from P420-, P425- and P429-line mixing basics and P190-376 2K Adjuster using the weight-mix recipes provided. This mix should be thoroughly stirred to achieve colour-match.

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.

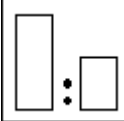



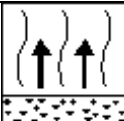

## 2K - P420 - Single Layer Solid Colour System

### Normal Solids

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STANDARD PROCESS (All Repairs)		
	Low Bake Process	Air-Dry Process
	P420- 4 parts P210-760/-770 2 parts P850-2K Thinner 1 part	P420- 4 parts P210-760/-770 2 parts P850-2K Thinner 0.5 part
	16-17 secs DIN4 at 20°C (20-22 secs BSB4)  <b>Pot-life at 20°C :</b> 6-8 hours	19-20 secs DIN4 at 20°C (24-26 secs BSB4)  <b>Pot-life at 20°C :</b> 6-8 hours
	Fluid tip : Gravity fed : 1.3-1.6 mm Suction fed : 1.4-1.8 mm Pressure : Refer to manufacturers information	Fluid tip : Gravity fed : 1.3-1.6 mm Suction fed : 1.4-1.8 mm Pressure : Refer to manufacturers information
	2 or 3 coats depending on build and appearance required.	2 or 3 coats depending on build and appearance required.
	Approx. 5 mins between coats. No flash-off is required before baking	Approx. 5 mins between coats
	<b>Bake at a metal temperature of 20°C :-</b>  70°C 20 mins 60°C 30 mins 50°C 60 mins Into Service : When cool	<b>Air-dry (20°C) :</b>  Dust free 15 mins Handleable 6 hours Into-Service 16 hours

## EXPRESS PROCESS (P210-790)

	Low Bake Process	Air-Dry Process
	P420- 4 parts P210-790 2 parts P850-2K Thinner 1 part	P420- 2 parts P210-790 1 part P850-2K Thinner 1 part
	16-17 secs DIN4 at 20°C (20-22 secs BSB4)  <b>Pot-life at 20°C :</b> 2 hours	14-15 secs DIN4 at 20°C (16-18 secs BSB4)  <b>Pot-life at 20°C :</b> 3 hours
	Fluid tip : Gravity fed : 1.3-1.6 mm Suction fed : 1.4-1.8 mm  Pressure : Refer to manufacturers information	Fluid tip : Gravity fed : 1.3-1.6 mm Suction fed : 1.4-1.8 mm  Pressure : Refer to manufacturers information
	3 single coats or 1 single and 1 double coat	3 single coats or 1 single and 1 double coat
	Approx. 5 mins between coats.  No flash-off is required before baking	Approx. 5 mins between coats
	<b>Bake at a metal temperature of 20°C :-</b>  60°C 10 mins 50°C 20 mins Into Service : When cool	<b>Air-dry (20°C) :</b>  Dust free 10 mins Handleable 2 hours Into-Service 4 hours

## 2K - P420 - Single Layer Solid Colour System Normal Solids

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### GENERAL PROCESS NOTES

#### FADE-OUT PROCESS

P420- line colours may be faded out using P850-1401. Please refer to fade-out process PDS for details.

#### 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 approx. 25°C)

P210-770 - is recommended for low-bake work, across a broad temperature range (20-30°C)

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).

#### USE OF P275-220

To increase the through hardening rate with P420- colours, P275-220 Rapid Dry Catalyst may be added at a level of 10 mls to 0.5 litres of activated and thinned paint.

**NOTE:** P275-220 should not be used in combination with P210-790 and should not be used in conditions of high temperature (i.e. above 30°C) and high humidity.

#### RECOATABILITY

P420-line colours, with all recommended hardeners, are fully recoatable after the "Into-service" times.

#### REDUCTION OF GLOSS LEVELS

The gloss level of P420-line solid colours may be reduced by addition of P565-554 2K Matting agent according to the colour formulation provided on the microfiche. Alternatively, use the following guidelines :-

Gloss Level	P 420-	P565-554
Semi-gloss	2 parts (67%)	1 part (33%)
Eggshell	3 parts (60%)	2 parts (40%)
Matt	1 part (50%)	1 part (50%)

This mix should then be activated and thinned as standard P420-line. Where a matt finish is required in the repair of a plastic part, refer to the **Nexa Autocolor** plastics painting system PDS.

## 2K - P420- Single Layer Solid Colour System Normal Solids

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### GENERAL PROCESS NOTES

#### RECTIFICATION AND POLISHING

Polishing is not normally required as P420-line solid colours have a full gloss finish. However, if dirt is a problem, denib with P1200 or finer, then polish by hand or machine using a quality polish such as P562-64. For optimum appearance follow with P971-9. Polishing of 2K is easiest between 1 and 24 hours after "into service" drying times.

#### DOOR SHUTS/INTERIORS

For the finishing of interior surfaces and door shuts use of an Express Hardener is recommended. Alternatively, 2K can be converted to give lacquer dry by adding an equal part of P017-773 Lacquer Converter to the base colour mix, using the following mixing ratios :-

Spraying:

P420-line	1 part
P017-773	1 part
P850-1401	1 part

Brushing:

P420-line	1 part
P017-773	1 part
P851-727	0.5 part

This system is recommended for interior surfaces only.

#### 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 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.
2. When using 2-pack products it is highly recommended to clean the gun thoroughly immediately after use.

**This information is given in good faith but without warranty.**

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