



AUTOCOLOR

PDS N5.1.1

September 2005

P420 SOLID & P421 METALLIC *HS SINGLE LAYER COLOR*

PRODUCT DESCRIPTION

2K™ Single Layer Color is a high quality acrylic urethane finish. It is mixed with HS Hardeners to provide a high build, smooth and high gloss finish. It can also be mixed with HS Topcoat Accelerator (P275-350) to provide an exceptionally fast drying system.

• Versatility = performance in multiple environments

• Exceptional Speed = reduced process time

**AUTOCOLOR**






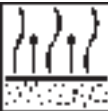

SINGLE LAYER COLOR

PRODUCTS

<i>P420 / P421</i>	<i>HS Single Layer Color</i>
<i>P210-854</i>	<i>HS Hardener – Low-Mid Temperature</i>
<i>P210-856</i>	<i>HS Hardener – Mid Temperature</i>
<i>P210-857</i>	<i>HS Hardener – High Temperature</i>
<i>P850-1692</i>	<i>Thinner – Low Temperature</i>
<i>P850-1693</i>	<i>Thinner – Mid Temperature</i>
<i>P850-1694</i>	<i>Thinner – High Temperature</i>
<i>P850-1695</i>	<i>Thinner – Very High Temperature</i>
<i>P275-350</i>	<i>HS Topcoat Accelerator</i>

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

MIX RATIO  	HS Express	HS
	Mixed Color 3 Parts P210-854 1 Part P850-16XX 1 Part P275-350 5% Note: Express process can only be mixed with P210-854 Hardener.	P420/P421 3 Parts P210-85X 1 Part P850-16XX 1 Part
VISCOSITY & POT LIFE 	Activated Viscosity: 19-22 seconds Din#4 @ 70°F (21°C) Pot Life: 2 hours @ 70°F (21°C)	Activated Viscosity: 20-23 seconds Din#4 @ 70°F (21°C) Pot Life: 3 hours @ 70°F (21°C)
SPRAY GUN & AIR PRESSURE 	Siphon: 1.4-1.8mm (.055" - .070") 45-55 psi at the gun Gravity: 1.3-1.6mm (.050" - .063") 45-55 psi at the gun HVLP: 0.8-1.5mm (.031" - .059") Max 10 psi cap pressure 3-8 psi fluid pressure (pressurized cup).	Siphon: 1.4-1.6mm (.055"- .063") 50-55 psi at the gun Gravity: 1.3-1.6mm (.050" - .063") 50-55 psi at the gun HVLP: 0.8-1.5mm (.031" - .059") Max 10 psi cap pressure 3-8 psi fluid pressure (pressurized cup).
	(HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)	
APPLICATION 	Apply 2 single coats (approx. 2.5 mils).	Apply 2 single coats (approx. 2.5 mils).
FLASH TIME 	5-10 minutes between coats. Note: No flash-off is necessary before force drying.	5-10 minutes between coats. Note: No flash-off is necessary before force drying.
DRYING TIME 	Minimum Air-dry times at 70°F (21°C) Dust Free 10 minutes Handleable 2 Hours Polishing 6 hours Force Dry (metal temperature): 10 minutes at 140°F (60°C)	Minimum Air-dry times at 70°F (21°C) Dust Free 10-15 minutes Handleable 4-6 Hours Polishing 12-16 hours Force Dry (metal temperature): P210-854: 20 minutes 140°F (60°C) P210-856: 30 minutes 140°F (60°C) P210-857: 40 minutes 140°F (60°C)

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SUBSTRATES

2K™ Single Layer can be applied over existing finishes in good condition and all Nexa Autocolor 2-pack primers after sanding with P400 wet or P320 dry by machine.

When using 2K Single Layer on plastics, refer to PDS N7.1.

RECOATABILITY

HS SYSTEM

2K™ Single Layer used with HS Hardeners (P210-854, P210-856 or P210-857) is fully recoatable after 16 hours air dry at 70°F (21°C).

2K Single Layer when force dried for recommended times is fully recoatable after cooling down.

GENERAL PROCESS NOTES

CHOICE OF HARDENER/THINNER

Hardener and Thinner selection will depend mainly on temperature, but also on air movement and size of repair. (Refer to Hardener and Thinner Selection Guide.)

For optimum application, these paint systems should not be applied cold. Best results will be obtained by allowing adequate time for paint to reach 70°F (21°C).

In the event of fish-eyes, use 1-2 inner capfuls of P273-1086 (Fish-Eye Preventer) per 1 quart of 2K Single Layer Ready-for-Use.

For blending of 2K™ Single Layer, refer to PDS N7.3, Blending Techniques.

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EQUIPMENT CLEANING

Approved Cleaning Solvent

POLISHING

Polishing is not normally required as 2K™ Single Layer has a full gloss finish. If, however, polishing is required to remove minor dirt nibs, wet sand with P1500 and follow normal polishing procedures.

2K™ PERFORMANCE SPECIFICATIONS

Product:	P420 Solid P421 Metallic	
Category:	Topcoat	
VOC As Packaged:	P420/P421 Color Max.	4.76 lbs. per gal/570 gm/l
VOC RFU:	P420/P421 Color Max.	5.0 lbs. per gal/600 gm/l
RFU Weight Solids:	P420/P421	37.1% @ 3:1:1
RFU Volume Solids:	P420/P421	32.0% @ 3:1:1

For further information please contact:

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