



PDS N7.1

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NEXA AUTOCOLOR® 2K® Plastics Painting Process

PRODUCT DESCRIPTION

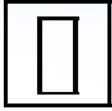




The NEXA AUTOCOLOR® 2K® Plastic Painting Process offers a complete and high quality range of products for the painting of new and repaired plastic parts. The system has been specifically designed to work with *Nexa Autocolor* undercoat and topcoat products.

Products	
P273-1333	Cleaner For Plastics
SWX350	H2O-SO-CLEAN® Waterborne Pre-Cleaner
P273-1050	Anti-Static Cleaner for Plastics
P572-2001	1K Adhesion Primer for Plastics
P100-2020	Flexible Additive for Plastics
P565-554	Matting Agent
P565-768	Coarse Texturing Base

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

Plastic Painting Process

PROCESS

MIX RATIO 	Overall P572-2001 1K Adhesion Promoter for Plastics is sold Ready for Use
SPRAYGUN & AIR PRESSURE 	Fluid Tip: 1.3 - 1.5 mm HVLP: Maximum of 10 PSI cap pressure Compliant: 29 - 40 PSI at the gun For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures.
APPLICATION 	Apply: 1 double coat or 2 single coats
FLASH TIME 	Between Coats: 2 minutes at 70°F (21°C)
DRY TIMES 	Air Dry to Topcoat: 10 minutes at 70°F (21°C)

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UN-PRIMED PLASTICS

The following procedure outlines the **preferred** method for refinishing of un-primed factory replacement plastic parts.

1. Wash part with warm soap and water and rinse.
2. Mix P273-1333 Cleaner for Plastics at a ratio of 1 : 1 with water.
3. Dampen a gray or finer scuff pad with the above cleaner mixture.
4. Using the dampened pad, clean and abrade the entire area to be painted.
5. Rinse thoroughly with clean water. Water should sheet (flat run-off) from the surface. If water beads up, repeat the process.
6. Wipe entire part with SWX350 *H₂O-So-Clean* Waterborne Pre-Cleaner to remove any cleaning residue.
7. With a lint-free cloth, wipe down the entire area to be painted with P273-1050 Anti-Static Cleaner and use another lint-free cloth to remove. Be sure that the part is completely dry prior to applying P572-2001 1K Adhesion Primer for Plastics. For best results, refinishing should be started within **1 hour** of cleaning.
8. Apply P572-2001 1K Adhesion Primer for Plastics to the entire area to be painted (see "Plastic Primer Process").
9. Apply a wet-on-wet sealer or primer-surfacer following the recommended Plastics Usage mix ratio and application process on the appropriate 2K PDS for product selected.
10. For basecoat color, the addition of flexible additive is not necessary. When applying single layer color or clearcoat, a 5 : 1* (20%) ratio with flexible additive is required.

*For very flexible plastics such as a PUR spoiler, a mix ratio of 2 : 1 with flexible additive will be required. (See "Painting of Flexible Plastics" tables for additional primers, sealers, basecoats and topcoats with their appropriate mix ratios which may also be used in the refinishing of plastics).

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PRE-PRIMED PLASTICS

The following procedure outlines the preferred method for refinishing of pre-primed factory replacement plastic parts.

1. Wash part with warm soap and water and rinse.
2. Dampen a gray or finer scuff pad with SWX350 *H₂O-So-Clean* Waterborne Pre-Cleaner.
3. Using the dampened pad, clean and abrade the entire surface to be painted being careful not to sand through the factory primer..
4. Rinse thoroughly with clean water.
5. Wipe entire part with SWX350 *H₂O-So-Clean* Waterborne Pre-Cleaner **DO NOT** use P273 -1050 Anti-Static Cleaner or P572-2001 1K Adhesion Primer on pre-primed parts. Be sure that the part is completely dry prior to applying a wet-on-wet sealer or primer-surfacer.
6. Apply a wet-on-wet sealer or primer-surfacer flexed with P100-2020 Flexible Additive at a ratio of 5 : 1* (20%) and then activate and thin this mixture as normal (For mix ratio and application process, see the appropriate 2K PDS for product selected).
7. For basecoat color, the addition of flexible additive **is not** necessary. When applying single layer color or clearcoat, a 5 : 1* (20%) ratio with flexible additive is required.

*For very flexible plastics such as a PUR spoiler, a mix ratio of 2 : 1 with flexible additive will be required. (See "Painting of Flexible Plastics" tables for additional primers, sealers, basecoat and topcoats with their appropriate mix ratios, which may also be used in the refinishing of plastics).

RECOATABILITY OF PLASTIC PRIMERS

Plastic primers or pre-primed plastics can be recoated with P420 2K Single Layer and P422 2K Basecoat.

Note: For optimum performance, apply flexed primer or sealer over *Nexa Autocolor* plastic primers or pre-primed plastic parts before application of topcoat.

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GENERAL PROCESS NOTES


PAINTING OF FLEXIBLE PLASTICS

When painting flexible plastics, P100-2020 Flexible Additive must be used in 2-pack primers, sealers, and single layer topcoat and clearcoat.

MIX RATIO 	FLEXIBLE PLASTICS PROCESS			
	PRIMERS/SEALERS		TOPCOATS	
	P565-2910 P565-2960 P565-5301 P565-5305 P565-5005	5 parts	2K Topcoats (P420/P190-xxxx)	5 parts
	P100-2020	1 part	P100-2020	1 part
	Activate and thin primers/sealers as normal		Activate and thin topcoats as normal	

PAINTING OF VERY FLEXIBLE PLASTICS

When painting very flexible plastics, such as PUR, P100-2020 Flexible Additive must be used in Nexa Autocolor primers, sealers, single layer, basecoats and clearcoats, it must be mixed as directed below.

MIX RATIO 	VERY FLEXIBLE PLASTICS (PUR) PROCESS					
	PRIMERS/SEALERS		BASECOATS		TOPCOATS	
	P565-2910 P565-2960 P565-5301 P565-5305 P565-5005	2 parts	2K Basecoat (P422)	3 parts	2K Topcoats (P420 / P190-xxxx)	2 parts
	P100-2020	1 part	P100-2020	1 part	P100-2020	1 part
	Activate and thin primers/sealers as normal.		Thin basecoats as normal.		Activate and thin topcoats as normal.	
The use of P100-2020 Flexible Additive will extend dry time.						


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GENERAL PROCESS NOTES

MATT FINISHES

In order to produce a matt finish, the use of P565-554 2K Matting Agent is required. 2K Matting Agent produces a smooth matt finish. It is designed for use in 2K HS Single Layer Color and 2K Clearcoat.

MIX RATIO 	MATTING PROCESS			
	SEMI-GLOSS	EGGSHELL	MATT	MAXIMUM
Matt Clearcoat* P190-xxxx/P420 P565-554	2 parts 1 part	3 parts 2 parts	1 part 1 part	1 part 1 part
Flexibilized Matt Clearcoat* P190-xxxx P100-2020 P565-554	2 parts 1 part 1.5 parts	2 parts 1 part 2 parts	2 parts 1 part 3 parts	2 parts 1 part 3 parts
Flexibilized Matt Single Layer* P420 P100-2020 P565-554	2 parts 1 part 1.5 parts	2 parts 1 part 2 parts	2 parts 1 part 3 parts	2 parts 1 part 3 parts

*Activate and thin mixtures as normal

DRY TIMES

Refer to PDS for P420 Single Layer and 2K Clearcoats for additional mix ratios, activation and thinner recommendations.

TEXTURED FINISHES

P565-768 Coarse Texturing Base additive is designed to reproduce the textured finishes of many OEM bumpers.

MIXING OF TEXTURED COLORS

Textured color formulations are available through the PAINTMANAGER® program software. Additional colors can be produced by mixing 2K Single Layer, Matting Agent and either of the texturing bases as follows.

Note: Texturing base should not be added to *Nexa Autocolor* Primers, 2K Basecoat or Clearcoats.

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TEXTURED FINISHES, Cont'd

MIX RATIO	TEXTURING PROCESS
	P420/P421 1 part P565-768 1 part P565-554 1 part
	Mixture should be activated and thinned as normal Note: Do not add Flexible Additive to this mixture Dry Times: Follow dry times as indicated on P420/P421 Product Data Sheets

PERFORMANCE SPECIFICATIONS

Product	Description	Intended Use	Package VOC
P273-1050	Anti-Static Cleaner for Plastics	Substrate Cleaner - Plastic	7.02 lbs./gal (842 g/L)
P273-1333	Cleaner for Plastics	Substrate Cleaner - Plastic	6.30 lbs./gal (755 g/L)
P572-2001	1K Plastics Adhesion Promoter	Specialty Ctg. - Adhesion Promoter	6.95 lbs./gal (833 g/L)
P100-2020	Flexible Additive	Specialty Ctg. - Flex Additive	3.31 lbs./gal (397 g/L)
P565-554	Matting Base	Specialty Ctg. - Flex Additive	5.66 lbs./gal (678 g/L)
P565-768	Coarse Texturing Base	Specialty Ctg. - Texture Additive	2.88 lbs./gal (345 g/L)
SWX350	H ₂ O-So-Clean Waterborne Pre-Cleaner	Substrate Cleaner	0.16 lbs./gal (20 g/L)

HEALTH AND SAFETY

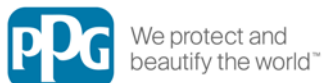
See Safety Data Sheet and Labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDSs of all the components since the mixture will have the hazards of all of its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statement listed on label. Statement and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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