



PDS N5.3.1

April 2017

NEXA AUTOCOLOR® 2K® P422 - Basecoat

PRODUCT DESCRIPTION

NEXA AUTOCOLOR® 2K® Basecoat is a high quality fast drying acrylic basecoat available in solid, metallic and pearlescent colors. This product offers exceptional hiding along with excellent color match. 2K is suitable for spot and panel repairs as well as complete resprays.

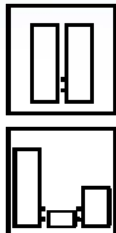





- *Great coverage = fewer coats, materials savings*
- *Fast dry = reduced process time*
- *Easy application = consistent results*
- *Excellent color match = customer satisfaction*

Products	
P422	Basecoat
P210-796/-798	2K MS Hardeners
P850-1692/-1963/-1964/-1695/-1696	2K Thinner
P273-1086	Fish-Eye Preventer

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

2K Basecoat

PROCESS

<div>MIX RATIO</div> <div></div>	<div>Standard</div> <div>P422-xxxx Basecoat 1 part P850-16xx Thinner 1 part</div> <div>Note: See section outlining requirements for using P850-1695 for standard basecoat reduction.</div>	<div>3-Stage Pearl</div> <div>P422-xxxx Basecoat 10 parts P210-796/8 Hardener 1 part P850-16xx Thinner 7 parts</div> <div>Note: Both the solid ground coat and the mid coat pearl layer must be activated and thinned as above.</div>
<div>POTLIFE</div> <div></div>	Pot Life: 6 - 8 hours at 70°F (21°C)	
<div>SPRAYGUN & AIR PRESSURE</div> <div></div>	<div>Gun Setup: 1.3 - 1.4 mm HVLP: Maximum of 10 psi cap pressure Compliant: 29 - 40 psi at the gun</div> <div>For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures</div>	
<div>APPLICATION</div> <div></div>	Apply: 2 - 3 single coats or until desired color is achieved	
<div>FLASH TIME</div> <div></div>	Between coats: 5 - 10 minutes at 70°F (21°C)	
<div>DRY TIMES</div> <div></div>	<div>Air dry:</div> <div>To clearcoat: 15 minutes at 70°F (21°C) To tape: 20 - 30 minutes at 70°F (21°C)</div>	

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GENERAL PROCESS NOTES

SUBSTRATES

2K Basecoat Color can be applied over existing finishes in good condition. Nexa Autocolor 2-pack primers after sanding with P600 wet or P400 dry by machine or wet on wet sealers.

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

RECOATABILITY

2K Basecoat should be clearcoated after recommended dry times.

NOTE: If 2K Basecoat has dried longer than 24 hours, additional 2K Basecoat should be applied before clear coating.

If 2K Basecoat has been sanded, reapply 2K Basecoat prior to clear coating.

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).

P210-796	MS Hardener - Normal
P210-798	MS Hardener - Slow
P850-1692	Thinner - Low Temperature 65 - 75°F (18 - 24°C)
P850-1693	Thinner - Mid Temperature 70 - 80°F (21 - 26°C)
P850-1694	Thinner - High Temperature 80 - 95°F (27 - 35°C)
P850-1695	Thinner - Very High Temperature 90°F (32°C) and above
P850-1696	Thinner - Ultra High Temperature 95°F (35°C) and above

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

In the event of fish-eyes in 2K Basecoat, allow basecoat to dry fully remove fish-eyes by lightly sanding with P1000 and re-apply 2K Basecoat.

For blending of 2K Basecoat Color refer to PDS N7.3 Blending Techniques.

For maximum stone chip resistance on high impact areas, Standard 2K Basecoat can be activated with P210-796/798 MS Hardener in the following ratio:

2K Basecoat Color P422-xxxx	10 parts
MS Hardener P210-796/-798	1 part
P850-16xx Thinners	11 parts

EQUIPMENT CLEANING

Approved PPG Cleaning Solvent

POLISHING

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

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2K Basecoat

	Standard	Standard w/ Hardener	3-Stage Pearl
RTS Combinations	P422- XXX : P850-169X	P422- XXX : P210-79X : P850-169X	P422- XXX : P210-79X : P850-169X
Volume Ratio	1 : 1	10 : 1 : 11	10 : 1 : 7
VOC Package g/L	513-710*	513-710	463-676**
VOC Package lbs./ US Gallon	4.28-5.93*	4.28-5.93	3.86-5.64**
Package VOC Regulatory (Less Water, Less Exempts) g/L	513-710*	513-710	463-676**
Package VOC Regulatory (Less Water, Less Exempts) lbs./ US gallon	4.28-5.93*	4.28-5.93	3.86-5.64**
RTS VOC Regulatory (Less Water, Less Exempts) g/L	666-767	668-761	606-730
RTS VOC Regulatory (Less Water, Less Exempts) lbs./ US gallon	5.56-6.40	5.57-6.38	5.06-6.09
Total Solids by Weight (RTS)	13.4-27.3	14.5-29.5	17.6-35.8
Total Solids by Volume (RTS)	9.8-22.1	10.6-21.8	13.0-26.7
Sq. Ft. Coverage / US Gallon (RTS) / 1 mil / 100% Transfer Efficiency	157-354	170-349	208-428

* P422 basecoat colors with a package VOC above 5.86 should be reduced 85% (1:0.85) if using P850-1695 or P850-1696 in order to meet ready to spray VOC maximum value listed in table. However if using P850-1692, P850-1693 or P850-1694 standard 1:1 mix to spray ratio will meet

**Average of the groundcoat and midcoat for each 3-stage color matched set of formulas will not exceed this value

VOC COMPLIANCE

To ensure accurate mixing, best performance & VOC compliance:

- Do not add extra hardener, thinner or change the recommended mixing ratio.
- Do not use hardeners or thinners that are not specific in this process summary.

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 warranted 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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