



## PDS N5.3.1C

March 2007

### **P422 2K BASECOAT**

#### **PRODUCT DESCRIPTION**

2K<sup>®</sup> Basecoat is a high quality fast drying acrylic basecoat available in solid, metallic and pearlescent colors. 2K Basecoat offers exceptional speed, color match and hiding.

2K is suitable for spot and panel repairs, as well as complete resprays.

- Excellent Coverage = fewer coats, materials savings
- Fast Dry = reduced process time
- Easy Application = consistent results
- Exceptional Color Match = customer satisfaction

## **2K BASECOAT COLOR**

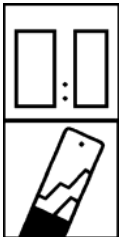



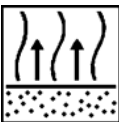

### **PRODUCTS**

<b><i>P422-XXXX</i></b>	<b><i>2K BASECOAT COLOR</i></b>
<b><i>P210-6575</i></b>	<b><i>HS PLUS MID-TEMP HARDENER</i></b>
<b><i>P850-1691</i></b>	<b><i>THINNER-VERY LOW TEMPERATURE</i></b>
<b><i>P850-1692</i></b>	<b><i>THINNER-LOW TEMPERATURE</i></b>
<b><i>P850-1693</i></b>	<b><i>THINNER-MID-TEMPERATURE</i></b>
<b><i>P850-1694</i></b>	<b><i>THINNER-HIGH TEMPERATURE</i></b>
<b><i>P850-1695</i></b>	<b><i>THINNER-VERY HIGH TEMPERATURE</i></b>
<b><i>P190-1002</i></b>	<b><i>BASECOAT BLENDER</i></b>

**THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY**

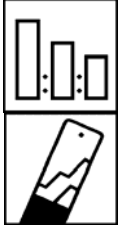



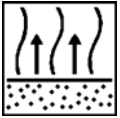

# 2K BASECOAT COLOR

## PROCESS

	STANDARD
<b>MIX RATIO</b>  <b>2A</b>	<p>P422 - Basecoat 1 part</p> <p>P850-16XX * Thinner 1 part</p> <p>* See page 7 for the requirement of basecoat reduction when using P850-1695 thinner.</p>
<b>VISCOSITY &amp; POT LIFE</b> 	<p>Thin by volume only</p> <p>Pot Life: Indefinite</p>
<b>SPRAY GUN &amp; PRESSURE</b> 	<p>0.8-1.5mm (.031"-059") Max 10 psi cap pressure</p> <p>Refer to gun manufacturer's recommendations for air pressure.</p>
<b>APPLICATION</b> 	<p>2-3 single coats to coverage</p>
<b>FLASH-OFF</b> 	<p>5-10 minutes between coats</p>
<b>DRYING</b> 	<p>Air Dry @ 70°F (21°C) before application of Clearcoat</p> <p><b>Note:</b> Allow a minimum of 20-30 minutes dry before taping.</p>

# 3-STAGE PEARL

## PROCESS

	GROUNDCOAT	PEARLCOAT
<b>MIX RATIO</b> 	P420 - Groundcoat 5 parts P210-6575 Hardener 1 part P850-16XX Thinner 2 parts	P422 - Pearlcoat 10 parts P210-6575 Hardener 1 part P850-16XX Thinner 7 parts
<b>VISCOSITY &amp; POT LIFE</b> 	<b>Viscosity:</b> 18-20 seconds DIN 4 @ 70°F (21°C)  <b>Pot Life:</b> 30-45 minutes @ 70°F (21°C)	<b>Pot Life:</b> 6-8 hours
<b>SPRAY GUN &amp; AIR PRESSURE</b> 	0.8-1.5MM (.031" - .059") Max. 10 psi cap pressure  Refer to gun manufacturer's recommendations for air pressure.	
<b>APPLICATION</b> 	2-3 single coats to coverage	
<b>FLASH-OFF</b> 	5-10 minutes between coats  10-15 minutes between groundcoat and pearlcoat	
<b>DRY TIMES</b> 	Air Dry @ 70°F (21°C) 15 minutes before application of clearcoat  <b>Note:</b> Allow a minimum of 20-30 minutes dry before taping.	

# 2K BASECOAT COLOR

## SUBSTRATES

**2K Basecoat Color** may be applied over properly prepared finishes in good condition, HS Plus Wet-On-Wet Sealers (P565-3111/3115) or HS Plus Primer/Surfacer (P565-5201/5205) after sanding with P600 Wet or P400 Dry by machine.

**2K Groundcoat Color** may be applied over properly prepared existing finishes in good condition, Chromate Free Etch or 1K Etch, or HS Plus Primer/Surfacer after sanding with P400 Wet or P320 Dry by machine.

**2K Pearlcoat Color** can be applied over 2K Groundcoat after appropriate dry times.

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## 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 clearcoating.

2K Groundcoat that has dried 8 hours or longer should be lightly scuffed prior to applying Pearlcoat.

If 2K Basecoat or Pearlcoat has been sanded, reapply color before clearcoating.

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## EQUIPMENT CLEANING

Approved Cleaning Solvent

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## PROCESS NOTES

### CHOICE OF THINNER

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

For optimum application, 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 in 2K Basecoat, allow Basecoat to dry, fully remove fish-eyes by lightly sanding with P1000, and re-apply 2K Basecoat. Do not use fish-eye eliminator in 2K Basecoat, Pearlcoat or Groundcoat Color.

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

# 2K BASECOAT COLOR

## PROCESS NOTES

For improved stone chip resistance on high impact areas, 2K Basecoat (P422) can be activated with HS Plus Hardener (P210-6575) in the following ratio:

2K Basecoat Color P422-XXXX	10 parts
HS Plus Hardener, P210-6575	1 part

This mixture should then be mixed at a 1:1 ratio with P850-16XX\* thinners.

## P190-1002 Basecoat Blender

P190-1002 may be used as a Uniform Finish Blender and a blending aid. The chart below show the mix ratio for all uses of Basecoat Blender.

### Uniform Finish Blender



1) P190-1002 may be used as a uniform finish blender on blend and repair panels to aid in the application and appearance of high metallic or pearls colors. Apply a single light coat to the repair and blend panel, Allow 5-10 minute flash time before applying 2K Basecoat color.

### Basecoat Blender

2) Under certain conditions, P190-1002 mixed at 1:1 ratio with P850-16XX thinner may be added to ready to spray 2K Basecoat high metallic and pearl basecoat colors at 10% (10:1) to improve application and metallic control.

### Checking a Blend

3) P190-1002 may be used for verifying the appearance of the blend edge of 2K Basecoat prior to clearcoating. Apply a single medium coat to the blend edge to verify the appearance. If it is not acceptable, allow a 5 minute flash and apply additional basecoat to improve the appearance, re-check, allow to flash and then apply clearcoat.

P190-1002 Basecoat Blender	
<b>Mix Ratio</b> 1:1 	P190-1002 1 part  P850-16XX 1 part
<b>Pot Life</b> 	Indefinite

# 2K BASECOAT COLOR

## 2K PERFORMANCE SPECIFICATIONS

**Product: P420**

**Category: Topcoat (Components of bc/cc system or 3/4 stage)**

P420 Package VOC Actual	2.87-3.70 lbs/gal	344-444 g/L
P420 Package VOC Regulatory (Less Water Less Exempts)	3.35-3.70 lbs/gal	401-444 g/L
P420 @ 5:1:2 RTS VOC Regulatory (Less Water Less Exempts)	4.33-5.82 lbs/gal	519-697 g/L

**Product: P422**

**Category: Topcoat (Components of bc/cc system or 3/4 stage)**

P422 Package VOC Actual	2.97-5.93 lbs/gal	356-711 g/L
P422 Package VOC Regulatory (Less Water Less Exempts)	3.41-5.93 lbs/gal	409-711 g/L
P422 @ 1:1* RTS VOC Regulatory (Less Water Less Exempts)	5.34-6.40 lbs/gal	640-767 g/L
P422 @ 10:1:11 RTS VOC Regulatory (Less Water Less Exempts)	4.31-6.31 lbs/gal	517-756 g/L
P422 @ 10:1:7 RTS VOC Regulatory (Less Water Less Exempts)	4.91-6.17 lbs/gal	588-739 g/L

\* When using P850-1695 thinner, all P422 basecoat color formulas with a packaged VOC of 5.86 lb/gal or more must only be reduced to a maximum of 85% (1 :0.85) to stay within the bc/cc VOC requirements.

**Product: P190-1002**

**Category: Specialty**

VOC (RFU) @ 1:1 (Less Water Less Exempts)	5.95 lbs /gal / 714 g/L Max.
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For further information please contact:

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