

**PDS N5.1.2C**

**November 2008**

**P471**

***HS PLUS SINGLE LAYER  
SOLID COLOR SYSTEM***

**PRODUCT DESCRIPTION**

The Nexa Autocolor 2K HS Plus Single Layer Solid Color System provides all the benefits of high solids technology in delivering a hard, durable finish and high gloss. Coupled with its ease of application it is suitable for all types of repair.

By appropriate choice of hardener the 2K HS Plus Single Layer Solid Color System offers a full range of drying options depending on the size of the repair

The P471 2K HS Plus Single Layer Solid Color System complies with the V.O.C. limit of 3.5 lbs/gal for Single Stage Topcoats.

- **Versatility = Performance in multiple environments**
- **Meets VOC regulations**
- **Exceptional speed = reduced process time**

## ***HS PLUS SINGLE LAYER COLOR***

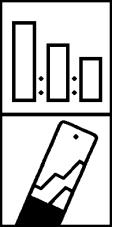
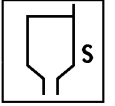


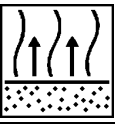
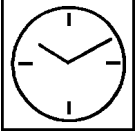
### **PRODUCTS**

<b>P471-XXXX</b>	<b>HS PLUS SINGLE LAYER COLOR</b>
<b>P210-6565</b>	<b>HS PLUS LOW-TEMP. / EXPRESS HARDENER</b>
<b>P210-6575</b>	<b>HS PLUS MID-TEMP. HARDENER</b>
<b>P210-6585</b>	<b>HS PLUS HIGH-TEMP. HARDENER</b>
<b>P210-6595</b>	<b>HS PLUS VERY -HIGH TEMP. HARDENER</b>
<b>P852-1893</b>	<b>HS PLUS REACTIVE REDUCER MID -TEMP</b>
<b>P852-1894</b>	<b>HS PLUS REACTIVE REDUCER HIGH-TEMP</b>

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

# HS PLUS SINGLE LAYER COLOR

## PROCESS

	Standard System	Express System Med. Size Repair	Express System Panel / Spot Repair Air Dry
<b>MIX RATIO</b> 	P471-XXXX      3 parts P210-6585/-95    2 parts P852-1893/-94    15%	P471-XXXX      3 parts P210-6575/85    2 parts P852-1893/-94    15%	P471-XXXX      3 parts P210-6565/75    2 parts P852-1893        15%
<b>Viscosity &amp; Pot Life</b> 	<b>20-25 seconds</b> DIN 4 @ 70° F (20°C)  Pot Life @ 70° F (20°C) <b>1.5-2 hours</b>	<b>20-25 seconds</b> DIN 4 @ 70° F (20°C)  Pot Life @ 70° F (20°C) <b>40-60 minutes</b>	<b>20-25 seconds</b> DIN 4 @ 70° F (20°C)  Pot Life @ 70° F (20°C) <b>20-40 minutes</b>
<b>Spray Gun and Air Pressure</b> 	1.3-1.6 (.050-.063) Max 10 psi cap press.  Refer to gun manufacturers recommended air pressure.		
<b>Application</b> 	<b>2 single coats</b> <b>(approx. 2.0-2.5 mils)</b>		
<b>Flash-off</b> 	<b>5-10 minutes</b> between coats  <b>Note:</b> No flash-off is necessary before force drying		
<b>Drying Time</b> 	Dust Free      20-30 min. Handleable    4-6 hrs Polishing      16 hrs @ 70° F (20° C)  <b>Baking @ 140° F (60° C)</b> P210-6585      30 min. P210-6595      40 min.	Dust Free      20-30 min. Handleable    4-6 hrs Polishing      12-16 hrs @ 70° F (20° C)  <b>Baking @ 140° F (60° C)</b> P210-6575      20 min. P210-6585      30 min.	Dust Free      10-20 min. Handleable    2-4 hrs Polishing      6-8 hrs @ 70° F (20° C)  <b>Baking @ 140° F (60° C)</b> P210-6565      15 min. P210-6575      20 min.

# ***HS PLUS SINGLE LAYER COLOR***

## **SUBSTRATES**

2K HS Plus Single Layer can be applied over existing finishes in good condition, and all Nexa Autocolor 2-pack primer/surfacer after sanding with P400 wet or P320 dry by machine or Nexa Autocolor Wet-on-Wet compliant sealers.

When using over plastic substrates refer to Plastic Application Process  
PDS N7.1C.

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## **FADE-OUT PROCESS**

P471-line 2K HS Plus Solid Colors may be faded-out using P850-1401. Refer to the Fade-out Process PDS N7.3C for details of the technique to achieve a repair. For P471- line 2K HS Plus colors add 1 part P850-1401 to 1 part of the mix in the gun for the first stage of the process. In the next step add a further 50% of P850-1401 to the first stage thinned mix and as soon as possible apply to the repair. If required apply P850-1401 carefully to the dry edge using several light passes to dissolve any dry spray as outlined in the Fade-out Process PDS.

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## **RECOATABILITY**

2K HS Plus Single Layer used with HS Plus Hardeners P210-6565, P210-6575, P210-6585 or P210-6595 is fully recoatable after 16 hours air dry 70° F (20°C).

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

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# HS PLUS SINGLE LAYER COLOR

## POLISHING

Polishing is not normally required as 2K HS Plus Single Layer has a full gloss finish. If however polishing is required to remove minor dirt nibs, wet sand with #1500 / P1500 wet and follow normal polishing procedures.

## CHOICE OF HARDENER / REDUCER

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

For optimum performance paint systems should not be applied cold. For best results allow adequate time for paint to reach 70° F (20°C).

For blending of HS Plus Single Layer refer to PDS N7.3C.

In the event of fish-eyes, add 1-2 inner capfuls of P273-1086, Fish-Eye Preventer to 1 quart of HS Plus, P471 ready for use.

## EQUIPMENT CLEANING

Approved Cleaning Solvent

## 2K PERFORMANCE SPECIFICATIONS

	Standard System:		Flexible System:	Very Flexible System:
			(Premix P471 color w/ P100-2021 5/1)	(Premix P471 color w/ P100-2021 2/1)
RTS Combinations:	P471	P471 : P210-65X5 + P852-1893/4	P471/P100-2021 : P210-65X5 + P852-1893/4	P471/P100-2021 : P210-65X5 + P852-1893/4
Volume Ratio:	Package color	3 : 2 + 15%	3 : 2 + 15%	3 : 2 + 15%
Applicable Use Category	Single-Stage Ctg	Single-Stage Ctg	Single-Stage Ctg (flexed)	Single-Stage Ctg (flexed)
VOC Actual (g/L)	319 - 363	355 - 378	341 - 360	327 - 342
VOC Actual (lbs/gal)	2.66 - 3.03	2.97 - 3.16	2.85 - 3.01	2.74 - 2.86
VOC Regulatory (less water less exempt) (g/L)	319 - 363	381 - 406	376 - 397	370 - 387
VOC Regulatory (less water less exempt) (lbs/gal)	2.66 - 3.03	3.18 - 3.39	3.14 - 3.31	3.09 - 3.23
Density (g/L)	1004 - 1387	1027 - 1227	1041 - 1208	1056 - 1189
Density (lbs/gal)	8.38 - 11.57	8.57 - 10.24	8.69 - 10.08	8.81 - 9.92
Volatiles wt. %	23.0 - 35.9	36.5 - 45.6	38.5 - 46.4	40.7 - 47.1
Water wt. %	0.0	0.0	0.0	0.0
Exempt wt. %	0.0	7.5 - 9.0	10.3 - 11.9	13.2 - 14.8
Water vol. %	0.0	0.0	0.0	0.0
Exempt vol. %	0.0	6.8	9.2	11.7

For further information please contact:

**Nexa Autocolor-USA**  
19699 Progress Drive  
Strongsville, OH 44149

**Nexa Autocolor-Canada**  
2301 Royal Windsor Drive  
Mississauga, Ontario L5J 1K5