



PDS N7.3
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NEXA AUTOCOLOR® 2K® Blending Techniques

PRODUCT DESCRIPTION

The NEXA AUTOCOLOR® 2K® Blending Process offers easy and simple techniques to cover all types of work. 2K P850-1401 Fade-Out Thinner or ONECHOICE® SX840/SXA840 Uniform Finish Blender is formulated for easy application and has excellent overspray wetting properties. 2K P273-1051 Basefade helps to provide easy basecoat blending particularly for pastel shades and silver basecoat colors.

Products	
P422-xxxx	2K Basecoat Color
P420-	2K HS Single Layer Color
P190-643	HS Clearcoat
P190-5520	Clearcoat
P190-6100	Fast HS Clearcoat
P190-6330	HS Production Clearcoat
P850-1401	Fade-Out Thinner
P273-1051	Basefade
SWX350	H2O-SO-CLEAN® Waterborne Pre-Cleaner
SX840/SXA840	Uniform Finish Blender

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

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GENERAL PRODUCT INFORMATION

Refer to appropriate Product Data Sheets regarding the use of 2K HS Single Layer, 2K Basecoat and Clearcoats.

SURFACE PREPARATION

Proper preparation is critical to the success of any repair, and great care must be exercised at this stage in order to achieve a satisfactory result.

1. Be sure that all panels that may be involved in the repair or blend are thoroughly cleaned and degreased.
2. Sand repair area with P400 wet for Single Layer colors and P600 wet for Basecoat colors, or P320 dry machine for Single Layer and P400 dry machine for Basecoat.
3. Prepare surrounding area by sanding with P1500 wet or grey scuff pad. If using compound, once the surface has been abraded, remove excess compound with SWX350 *H2O-So-Clean* Waterborne Pre-Cleaner to avoid re-polishing the surface.
4. Before topcoating, degrease the panel(s) with SWX350 *H2O-So-Clean* Waterborne Pre-Cleaner. When degreasing, use one clean white rag for wiping on Waterborne Pre-Cleaner and another for wiping off.
5. Finally tack the entire surface to be painted.

FADE-OUT THINNER METHOD

This is the standard method for spot repairing all finishes, Metallic Basecoat, Solid Basecoat and Two-Stage Pearls. Do not use this method to repair Three-Stage Pearl colors. It is best for older cars, doorjams and less visible areas.

1. Using normal ready to spray paint, cover the area to be painted, using low air pressure, (30 psi at the gun) and extend into the prepared surrounding area using an arching motion of the gun.
2. Add 1 part P850-1401 2K Fade-Out Thinner to 2 - 3 part mix in gun and blend further into the prepared surrounding area using an arching motion of the gun, with low pressure at the gun. Overlap the previous coats, but be sure to remain within the prepared area.
3. As soon as possible, carefully apply straight P850-1401 Fade-Out Thinner or *OneChoice* SX840/SXA840 Uniform Finish Blender to the dry edge using several light passes to dissolve any dry spray.
4. Allow film to dry or flash-off according to the recommended times.

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SINGLE LAYER / CLEARCOAT

1. It is not recommended to blend Single Layer or Clearcoat on exterior panels.
2. For blending less visible areas and doorjambs, follow procedures described previously.

CLEARCOAT AS A BLENDING CLEAR METHOD

This method should be used for P420 Single Layer Systems to give a high quality, glossy finish. It is the best method for highly visible areas.

1. Using normally activated and thinned paint, cover the primed area, using low pressure. Extend into the prepared surrounding areas using an arching motion of the gun.
2. Add 1 part normally activated Clearcoat to 2 parts of the mix in the gun and blend further into the prepared surrounding area, with low pressure at the gun. Use an arching motion of the gun, overlapping the previous coat. Clean the gun after this step.
3. Allow P420 Single Layer to flash-off 20 - 30 minutes before Clearcoating.
4. Apply one full coat of normally activated Clearcoat to the full panel repaired.

BASEFADE BLENDING METHOD

This method should only be used for metallic basecoats and two-stage pearls. It is particularly useful for pastel shades and lighter basecoat colors.

1. Using normally thinned paint, cover the primed area, using low air pressure. Extend into the prepared surrounding area using an arching motion of the gun.
2. Add up to 1 part P273-1051 Basefade to 1 part of the mix in the gun and blend further into the surrounding area, with low air pressure at the gun. Use an arching motion of the gun and overlap previous coats.

or

Alternatively, for small area repairs, add 1 part P273-1051 Basefade to 2 parts normally thinned paint. Use this to cover the primed and prepared surrounding areas as described in 1 above. Then add up to a further 1 part Basefade to 1 part mix in the gun and blend further into the prepared surrounding area as in 2 above.

3. Allow Basecoat to flash-off as normally recommended.
4. Apply Clearcoat edge to edge.
5. Allow Clearcoat to dry according to the recommendations in Product Data Sheet for the clearcoat being sprayed.

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3-STAGE PEARL BLENDING METHOD

Method for blending and spot repair of 3-stage pearls.

1. Apply normally thinned groundcoat to completely cover the primed area, using low pressure. Minimize the overlap into the prepared surrounding area.
2. Add 1 part P850-1401 Fade-Out Thinner to 2 parts of the groundcoat mix in the gun. Use an arcing motion, overlapping the previous coat.
3. Add 1 part normally thinned Pearl Basecoat Color to 2 parts of the mix in the gun and apply 1 to 3 light coats up to the edge of the groundcoated area, with low pressure at the gun. Minimize the overlap into the prepared surrounding area. Discard paint and clean gun after this step.
4. Apply thinned Pearl Basecoat Color to the repair, with low pressure at the gun, up to the edge of the groundcoated area. Minimize overlap into the prepared surrounding area.
5. Add 1 part of P850-1401 Fade-Out Thinner to 2 parts of the mix in the gun and blend further into the prepared surrounding area overlapping the previous coat, with low pressure at the gun.
6. Add 1 part of activated Clearcoat to 2 parts of the mix in the gun and blend further into the prepared surrounding area overlapping this previous coat, with low pressure at the gun. Discard the paint and clean gun after this step.
7. Apply Clearcoat to the entire prepared panel, or to a convenient break line, in the normal way.
8. Allow Clearcoat to dry according to the clearcoat recommendations in the Product Data Sheet.

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PERFORMANCE SPECIFICATIONS

Product	Description	Intended Use	Package VOC
P850-1401	Fade-Out Thinner	Specialty Ctg. - Uniform Finish Ctg.	6.96 lbs. /gal (835 g/L)
P273-1051	Basefade	Specialty Ctg. - Uniform Finish Ctg.	6.66 lbs. /gal (798 g/L)
SWX350	<i>H₂O-So-Clean</i> Waterborne Pre-Cleaner	Substrate Cleaner	0.16 lbs./gal (20 g/L)

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 specified in the product process summary.

HEALTH AND SAFETY

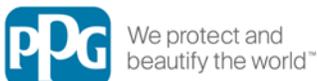
See Safety Data Sheet and Labels for additional safety information and handling instructions.

- 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 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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