



PDS N7.2C

October 2008

2K™ PLASTICS PREPARATION SYSTEM

PRODUCT DESCRIPTION

2K™ Plastics Preparation System is designed to simplify the process of preparing automotive plastics for refinishing. The 2K™ Plastics Preparation System is simple and easy to use and delivers fast process times as well as outstanding adhesion to all commonly used automotive plastics.

- Superior adhesion = Less re-work

- Fast System = reduced process time

2K™ Plastics Preparation System

PRODUCTS

<i>P273-1444</i>	<i>Adhesion Cleaner for Plastics</i>
<i>P273-1060</i>	<i>Anti-Static Adhesion Wipe for Plastics</i>
<i>P572-4001</i>	<i>Adhesion Primer for Plastics</i>
<i>P980-251</i>	<i>Waterborne Pre-Cleaner</i>

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

UN-PRIMED PROCESS

<p>PRE-CLEANING</p> 	<p>1) Using the pre-saturated Adhesion Cleaner for Plastics pad (P273-1444), thoroughly clean the surface and then rinse with clean water. Water should sheet (flat run off) from the surface, if not, repeat this process. Be sure the part is uniformly cleaned and completely dry before proceeding to the next step.</p>
<p>ANTI-STATIC CLEANER</p> 	<p>2) Using the Anti-Static Adhesion Wipe for Plastics (P273-1060), apply a light even coat over the entire repair area. Apply in one direction to minimize overlaps. Allow surface to dry for approximately 5 minutes.</p>
<p>PRIMER APPLICATION</p> 	<p>3) Apply a single light coat of P572-4001 to the prepared surface. Allow a 5 minute flash off prior to the application of either an undercoat or topcoat.</p>
<h2>PRE-PRIMED PROCESS</h2>	
<p>PRE-CLEANING</p> 	<p>1) Using the pre-saturated Adhesion Cleaner for Plastics pad (P273-1444), thoroughly clean the surface and then rinse with clean water. Be sure the part is completely dry and verify that the surface has been uniformly cleaned, if not, repeat this process before proceeding to the next step.</p>
<p>FINALCLEANING</p> 	<p>2) Reduce P980-251 Waterborne Pre-Cleaner 1:2 with water and and wipe the entire surface. Be sure the part is completely dry prior to applying either an undercoat or topcoat.</p>

2K™ Plastics Preparation System

SUBSTRATES

2K™ Plastics Preparation System may be overcoated with all Nexa Autocolor primer-surfacers, wet-on-wet sealers, transparent adhesion promoter or topcoats. For optimum performance, apply a flexible primer, sealer or transparent adhesion promoter before topcoating. Flexible additive P100-2020 must be used in 2 pack primers, sealers and topcoats when refinishing plastics. See PDS N7.1C for Flex levels and additional information.

RECOATABILITY

On un-primed plastics, If the surface has not been undercoated or topcoated within 8 hours of the preparation process, lightly scuff and re-apply P572-4001 to ensure maximum adhesion.

On pre-primed plastics parts, it is not as time sensitive although an undercoat or topcoat should be applied as soon as possible to avoid surface contamination. P980-251 Waterborne Pre-Cleaner should be used if the part has not been coated and left open for an extended period before undercoating or topcoating.

2K PERFORMANCE SPECIFICATIONS

Category:	Specialty	
<u>P273-1444</u>		
Applicable Use Category:	Solvent (Substrate Cleaner)	
VOC content:	13 g/L (0.11 lbs/gal)	
<u>P980-251</u>		
Applicable Use Category:	Solvent (Substrate Cleaner)	
VOC content: (concentrate)	68 g/L (0.57 lbs/gal)	(MUST BE DILUTED FOR USE)
VOC content: (1: 2 w/ water)	23 g/L (0.19 lbs/gal)	
RTS Combinations:	P273-1060	P572-4001
Volume Ratio:	As is	As is
Applicable Use Category	Adhesion Promoter	Adhesion Promoter
VOC Actual (g/L)	835	830
VOC Actual (lbs/gal)	6.97	6.93
VOC Regulatory (less water less exempt) (g/L)	835	830
VOC Regulatory (less water less exempt) (lbs/gal)	6.97	6.93
Density (g/L)	858	875
Density (lbs/gal)	7.16	7.3
Volatiles wt. %	97.4	95.0
Water wt. %	0.0	0.0
Exempt wt. %	0.0	0.0
Water vol. %	0.0	0.0
Exempt vol. %	0.0	0.0

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