



PDS N7.1

January 2005

PLASTICS PAINTING PROCESS

PRODUCT DESCRIPTION

The Nexa Autocolor plastic painting process offers a complete and high quality range of products for the painting of new and repaired plastic parts. The system has been specifically designed to work with Nexa Autocolor undercoat and topcoat products.



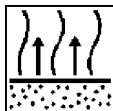

PLASTIC PAINTING PROCESS

PRODUCTS

| | |
|-------------------------|---|
| <i>P273-1333</i> | <i>Cleaner For Plastics</i> |
| <i>P980-251</i> | <i>Waterborne Pre-Cleaner</i> |
| <i>P562-100</i> | <i>Waterbased Sanding Paste</i> |
| <i>P273-1050</i> | <i>Anti-Static Cleaner for Plastics</i> |
| <i>P572-2000</i> | <i>1K Adhesion Primer For Plastics (Aerosol)</i> |
| <i>P572-2001</i> | <i>1K Adhesion Primer For Plastics</i> |
| <i>P100-2020</i> | <i>Flexible Additive For Plastics</i> |
| <i>P565-660</i> | <i>Fine Texturing Base</i> |
| <i>P565-768</i> | <i>Coarse Texturing Base</i> |
| <i>P565-554</i> | <i>Matting Agent</i> |

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PLASTIC PAINTING PROCESS

| | P572-2001 Overall | P572-2000 Repairs |
|--|--|-----------------------------|
| MIX RATIO | Supplied ready for use | |
| SPRAY GUN & AIR PRESSURE  | 1.3-1.5 mm (.051-.060) HVLP: 10 psi max (air cap) Refer to gun manufacturers recommended air pressure. | Aerosol |
| APPLICATION  | 1 double coat or 2 single coats | |
| FLASH-OFF  | Allow 2 minutes flash off time between coats | |
| DRYING  | Air-dry 10 minutes @ 70°F (21°C) | |

PLASTIC PAINTING PROCESS

UN-PRIMED PLASTICS

The following procedure outlines the **preferred** method for refinishing of **un-primed** factory replacement plastic parts.

1. Wash part with warm soap and water and rinse.
2. Mix **P273-1333** (Cleaner for Plastics) at a ratio of 1:1 with water.
3. Dampen a Grey or finer scuff pad with the above cleaner mixture and apply **P562-100** (Waterbased Sanding Paste) directly to the pad.
4. Using the dampened pad and paste mixture, clean and abrade the entire area to be painted.
5. Rinse thoroughly with clean water. Water should sheet (flat run-off) from the surface. If water beads up, repeat the process.
6. Wipe entire part with **P980-251** (Waterborne Pre-Cleaner) to remove any cleaning residue.
7. With a lint-free cloth, wipe down the entire area to be painted with **P273-1050** (Anti-Static Cleaner) and use another lint-free cloth to remove. Be sure that the part is completely dry prior to applying 1K Adhesion Primer for Plastics. For best results, refinishing should be started within **1 hour** of cleaning.
8. Apply **P572-2000/2001** (1K Adhesion Primer for Plastics) to the entire area to be painted (see "Plastic Primer Process").
9. Apply a Wet-on-Wet Sealer, Primer-Surfacer or Transparent Adhesion Promoter flexed with **P100-2020** Flexible Additive at a ratio of 5:1* (20%) and then activate and thin this mixture as normal. (For mix ratio and application process, see the appropriate 2K PDS for product selected).
10. For Basecoat Color, the addition of Flexible Additive **is not** necessary. When applying Single Layer Color or Clearcoat, a 5:1* (20%) ratio with Flexible Additive **is required**.

*For very flexible plastics such as a PUR spoiler, a mix ratio of 2:1 with flexible additive will be required. (See "Painting of Flexible Plastics" tables for additional primers, sealers, basecoat and topcoats with their appropriate mix ratios which may also be used in the refinishing of plastics.)

PLASTIC PAINTING PROCESS

PRE-PRIMED PLASTICS

The following procedure outlines the **preferred** method for refinishing of **pre-primed** factory replacement plastic parts.

1. Wash part with warm soap and water, and rinse.
2. Clean with **P980-251** (Waterborne Pre-Cleaner).
3. Dampen a Grey or finer scuff pad with the above cleaner and apply **P562-100** (Waterbased Sanding Paste) directly to the pad.
4. Using the dampened pad and paste mixture, clean and abrade the entire surface to be painted being careful not to sand through the factory primer.
5. Rinse thoroughly with clean water.
6. Wipe entire part with **P980-251** (Waterborne Pre-Cleaner). **DO NOT** use **P273-1050** (Anti-Static Cleaner) or **P572-2000/2001** (1K Adhesion Primer) on pre-primed parts. Be sure that the part is completely dry prior to applying a Wet-on-Wet Sealer or Primer-Surfacer.
7. Apply a Wet-on-Wet Sealer, Primer-Surfacer or Transparent Adhesion Promoter flexed with **P100-2020** Flexible Additive at a ratio of 5:1* (20%) and then activate and thin this mixture as normal. (For mix ratio and application process, see the appropriate 2K PDS for product selected).
8. For Basecoat Color, the addition of Flexible Additive **is not** necessary. When applying Single Layer Color or Clearcoat, a 5:1* (20%) ratio with Flexible Additive **is required**.

*For very flexible plastics such as a PUR spoiler, a mix ratio of 2:1 with flexible additive will be required. (See "Painting of Flexible Plastics" tables for additional primers, sealers, basecoat and topcoats with their appropriate mix ratios, which may also be used in the refinishing of plastics.)

RECOATABILITY OF PLASTIC PRIMERS

Plastic primers or pre-primed plastics can be recoated with 2K Single Layer (P420 / 421) and 2K Basecoat (P422).

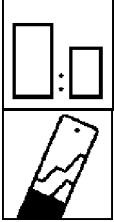
Note: For optimum performance, apply Flexed Primer, Sealer or Transparent Adhesion Promoter over Nexa Autocolor Plastic Primers or pre-primed plastic parts before application of topcoat.

When painting flexible plastics, P100-2020 (Flexible Additive) **must** be used in 2-pack Primers, Primer Sealers and Topcoats.

PLASTIC PAINTING PROCESS

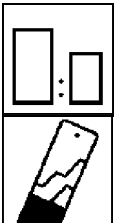
PAINTING OF FLEXIBLE PLASTICS

When painting flexible plastics, P100-2020 (Flexible Additive) must be used in 2-pack Primers, Sealers, Adhesion Promoters and Single Layer Topcoat and Clearcoat.

| MIXING RATIO  | FLEXIBLE PLASTICS PROCESS | |
|--|---|---|
| | PRIMERS / SEALERS | TOPCOATS |
| | P565-693 5 parts P565-668 P565-510/511 P565-357/358 P565-3011/3015 P565-2910 P565-2960 P565-888/889 P100-2020 1 part Activate and thin primers/sealers as normal | 2K Topcoats 5 parts (P420/421 P190-XXXX) P100-2020 1 part Activate and thin topcoats as normal |

PAINTING OF VERY FLEXIBLE

When painting very flexible plastics, such as (PUR), P100-2020 (Flexible Additive) must be used in Nexa Autocolor Primers, Sealers, Adhesion Promoters, Single Layer, Basecoat and Clearcoats, it must be mixed as directed below:

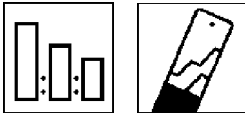
| MIXING RATIO  | VERY FLEXIBLE PLASTICS (PUR) PROCESS | | |
|--|---|--|---|
| | PRIMER/SEALER | BASECOAT | TOPCOATS |
| | P565-510/511 2 parts P565-3011/3015 P565-357/358 P565-668 P565-2910 P565-2960 P565-693 P565-888/889 P100-2020 1 part Activate and thin primers/sealers as normal | 2K Basecoat 3 parts (P422) P100-2020 1 part Thin Basecoat as normal | 2K Topcoats 2 parts (P420/421 P190-XXXX) P100-2020 1 part Activate and thin topcoats as normal |

The use of Flexible Additive (P100-2020) will extend dry time.

PLASTIC PAINTING PROCESS

MATT FINISHES

In order to produce a matt finish, the use of P565-554 (Matting Agent) is required. 2K Matting Agent produces a smooth matt finish. It is designed for use in 2K HS Single Layer Color and 2K Clearcoat.

| MIXING RATIO  | MATting PROCESS | | | |
|--|---|---|---|---|
| | SEMI-GLOSS | EGGSHELL | MATT | MAXIMUM |
| Matt Clearcoat* P190-XXXX / P420 / 421 P565-554 | 2 parts 1 part | 3 parts 2 parts | 1 part 1 part | 1 part 1 part |
| Flexibilized Matt Clearcoat* P190-XXXX P100-2020 P565-554 | 2 parts 1 part 1.5 parts | 2 parts 1 part 2 parts | 2 parts 1 part 3 parts | 2 parts 1 part 3 parts |
| Flexibilized Matt Single Layer* P420/421 P100-2020 P565-554 | 2 parts 1 part 1.5 parts | 2 parts 1 part 2 parts | 2 parts 1 part 3 parts | 2 parts 1 part 3 parts |

*Activate and thin mixtures as normal.

Dry Times: Refer to PDS for Single Layer (P420/421) and 2K Clearcoats for additional mix ratios, activation and thinner recommendations.

TEXTURED FINISHES

Fine Texturing Base, (P565-660) and Coarse Texturing Base, (P565-768) are additives designed to reproduce the textured finishes of many OEM bumpers.

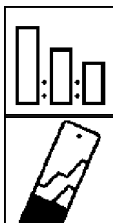
MIXING OF TEXTURED COLORS

Textured color formulations are available through the Color System and Microfiche. Additional colors can be produced by mixing 2K Single Layer, Matting Agent and either of the texturing bases as follows.

Note: Texturing bases should not be added to Nexa Autocolor Primers, 2K Basecoat or Clearcoats.

PLASTIC PAINTING PROCESS

MIXING RATIO



TEXTURING PROCESS

| | |
|----------------------|--------|
| P420/421 | 1 part |
| P565-660 or P565-768 | 1 part |
| P565-554 | 1 part |

This mixture should be activated and thinned as normal

Texturing Process Notes

NOTE: Do not add Flexible Additive to this mixture.

Dry Times: Follow normal dry times for Single Layer Color (P420/421).

2K PERFORMANCE SPECIFICATIONS

| | | |
|-------------------------|-------------------------------------|---------------------------------------|
| Products: | Components for refinishing plastics | |
| Category: | Specialty | |
| | P273-1050 | Anti-Static Cleaner for Plastics |
| | P273-1333 | Cleaner For Plastics |
| | P572-2000 | 1K Plastics Adhesion Primer (Aerosol) |
| | P572-2001 | 1K Plastics Adhesion Promoter |
| | P100-2020 | Flexible Additive |
| | P562-100 | Waterbased Sanding Paste |
| | P565-660 | Fine Texture Base |
| | P565-768 | Coarse Texture Base |
| | P565-554 | Matting Base |
| | P980-251 | Waterborne Pre-Cleaner |
| VOC As Packaged: | P273-1050 | 7.1 lbs. per gal/840 gm/l |
| | P273-1333 | 6.3 lbs. per gal/760 gm/l |
| | P572-2000 | 7.0 lbs. per gal/833 gm/l |
| | P572-2001 | 7.0 lbs. per gal/833 gm/l |
| | P100-2020 | 3.3 lbs. per gal/395 gm/l |
| | P562-100 | 0.0 lbs. per gal/000 gm/l |
| | P565-660 | 3.3 lbs. per gal/395 gm/l |
| | P565-768 | 3.3 lbs. per gal/395 gm/l |
| | P565-554 | 5.6 lbs. per gal/674 gm/l |
| | P980-251 | 0.58 lbs. per gal/70 gm/l |

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