

**PDS N6.25**

April 2011

**P420**

## **2K™ INTERIOR COLOR**

### **PRODUCT DESCRIPTION**

**2K™ Interior Color** is a high quality system for the painting of rigid interior plastic and vinyl parts.

- Fast dry = reduced process time
- Easy application = consistent results
- Excellent color match = customer satisfaction

## **2K™ INTERIOR COLOR**

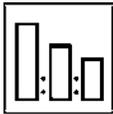
### **PRODUCTS**

<i>P420-XXXX</i>	<i>2K™ Interior Color</i>
<i>P190-478</i>	<i>Converter</i>
<i>P850-1401</i>	<i>Fade-Out Thinner</i>

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

# PROCESS

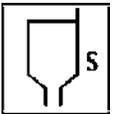
## MIXING RATIO



P420	Interior Color	1 part
P850-1401	Fade-Out Thinner	1 part
P190-478	Converter	1 part

**Note:** Do not add Hardener or other Additives to this mixture.

## VISCOSITY & POT LIFE



**Viscosity:** 4 seconds DIN 4 @ 70°F (21° C)

**Pot Life:** Indefinite

## SPRAY GUN AND AIR PRESSURE



**Siphon:** 1.4-1.6mm (.055" - .063")

30-35 psi at the gun

**Gravity:** 1.3-1.6mm (.050" - .063")

30-35 psi at the gun

**HVLP:** 0.8-1.5mm (.031"-059")

Max 10 psi cap pressure

3-8 psi cap pressure (pressurized cup)

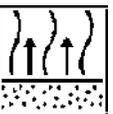
(HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)

## APPLICATION



**2-3 medium coats.**

## FLASH-OFF



**5 minutes** between coats.

## DRYING TIME



**Air Dry Only**

Handleable after **30 minutes** @ 70°F (21°C).

# 2K™ INTERIOR COLOR

## SUBSTRATES

2K™ Interior Color can be applied over interior plastic and vinyl substrates after lightly scuffing with a grey scuff pad, pre-cleaning with Cleaner for Plastics (P273-1333) and the application of 1K Adhesion Primer for Plastics (P572-2001/P572-4000/4001).

**Note:** This system should not be applied on very flexible vinyl substrates, such as vinyl seat covers.

**Do not** apply 2K™ Interior Color to external parts such as vinyl top, bumpers, etc.

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## EQUIPMENT CLEANING

Approved Cleaning Solvents

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## 2K™ PERFORMANCE SPECIFICATIONS

<b>Product:</b>	P420-XXXX	Interior Color
	P190-478	Converter
	P850-1401	Fade-out Thinner
<b>Category:</b>	Specialty	
<b>VOC As Packaged:</b>	P420-XXXX	Max. 5.00 lbs. per gal/600 gm/l
	P190-478	6.19 lbs. per gal/742 gm/l
	P850-1401	7.00 lbs. per gal/840 gm/l
<b>VOC RFU:</b>	Max. 7.00 lbs. per gal/840 gm/l	

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