

Product Data Sheet

August 2012

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY



H1002V

Engine Bay Repair System Engine Bay System Basic P560-1000 (using P210-8815 HS+ Hardener)

<i>Product</i>	<i>Description</i>
P560-1000	Engine Bay System Basic
P210-8815	HS Plus Hardener
P850-1692/1693/1694	2K Low VOC Thinners
P471-line	2K HS+ Mixing Basics

Product Description

P560-1000 forms part of the Engine Bay Repair System, designed to simplify repairs to cars with a specific Engine Bay colour.

New engine bay colour formulations on colour IT systems and fiche include the addition of P560-1000 Engine Bay System Basic. Once activated and thinned the resultant mix is capable of providing an accurately matched finish for engine bay (and other internal) areas, and a recoatable wet-on-wet layer to all external panels that need to be topcoated.

This removes the need to undercoat and colour the internal area, and allows internal and external areas to be coated in one step, thus saving time.

Substrates and Preparation

P560-1000 should only be applied over :-





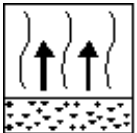


New panels in good quality Electrocoat, for maximum durability it is recommended that the Electrocoat is sanded using Red **Scotch-Brite™**, leaving it as in tact as possible, prior to application of the Engine Bay Colour.

Well scuffed and degreased bare steel : Use **Nexa Autocolor** 2-pack Etch Primer or 2K Epoxy Primer for maximum durability. Aluminium must be Etch or 2K Epoxy primed.

Well flatted GRP, polyester fillers, works primer and old finishes in sound condition

Good preparation is vital in order to obtain the best results from these products.

Process

	<p>Mix the P560-line Engine Bay internal colour in accordance with the colour information on IT systems or microfiche. DO NOT add any matting agent to the P560 engine bay colour.</p> <p>Then:</p> <table border="0"> <tr> <td>P560-engine bay colour</td> <td>5 parts</td> </tr> <tr> <td>P210-8815</td> <td>1 part</td> </tr> <tr> <td>P850-1692/93/94</td> <td>2 parts</td> </tr> </table>	P560-engine bay colour	5 parts	P210-8815	1 part	P850-1692/93/94	2 parts
P560-engine bay colour	5 parts						
P210-8815	1 part						
P850-1692/93/94	2 parts						
	<p>15 - 17secs. DIN4</p> <p>Pot-life: 45 minutes at 20°C</p>						
	<p>Fluid Tip: Gravity Fed: 1.4 - 1.6 mm Suction Fed: 1.6 - 1.8 mm Inlet Pressure: As recommended by spraygun manufacturer. (normally 2 bar or 30 psi).</p>						
	<p>Apply 1 double coat or two single coats to give a film thickness of 25 - 40 microns (1.0 - 1.5 thou)</p>						
	<p>5 minutes flash-off between coats if using single coats.</p>						
	<p>Air-dry at 20°C before topcoating : Flash-off 20 minutes at 20°C before topcoating.</p>						
	<p>Normally P560-line colour does not require flatting and should be directly topcoated. If some dirt inclusion occurs, light wet flatting/denibbing can be carried out after 20 - 30 minutes using P1200 or finer flatting paper.</p>						
<p>TOPCOAT</p>	<p>Areas requiring topcoat can be directly topcoated with AQUABASE® basecoat, AQUABASE® PLUS basecoat and 2K HS Plus Topcoat (P471).</p>						

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GENERAL PROCESS NOTES

PROCESS STEPS

1. Select the correct engine bay colour using the Engine Bay Colour Directory.
2. Using the normal colour retrieval system (Shopwatch paint manager or fiche etc.) mix the P560-line Engine Bay Colour, which includes the addition of P560-1000 Engine Bay System Basic.
3. Activate and thin the P560-line Engine Bay Colour as recommended and apply to both the engine bay (or other internal areas) and all external panels that need topcoating.
4. Flash-off for 25 - 35 minutes (depending on which thinner has been chosen). Mask off the internal area if necessary.
5. Apply the topcoat and bake. P560-line engine bay colours can be topcoated with AQUABASE[®], AQUABASE[®] PLUS and 2K HS Plus Topcoat (P471-line).

ADDITIONAL NOTES

DO NOT add any matting agent to P560-line engine bay colour mixes.

CHOICE OF THINNER

The exact choice of thinner will depend on the size of job, temperature, air movement and gun set-up used. The following temperature ranges should be used for guidance only: -

Recommended Thinner	Temperature range
P850-1692	Up to 25°C
P850-1693	20°C - 30°C
P850-1694	25°C - 35°C

VOC INFORMATION

The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 540g/litre. Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

These products are for professional use only and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information please refer to the material Safety Data Sheet, also available at: www.nexaautocolor.com

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