

Product Data Sheet

July 2014

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY



I1542V

2K HS Plus P471-Single Layer Solid Colour System (using P210-8815 HS+ Hardener)	
<i>Product</i>	<i>Description</i>
P471-	2K HS Plus Solid Colour Mixing Basics
P472-	2K HS Plus Solid Colour Mixing Basics
P210-8815	HS Plus Hardener
P850-1692/1693/1694	2K Low VOC Thinners
P852-1689	2K HS Plus Express Thinner
P565-554	2K Matting Agent
P565-7210 / -7220	Fine / Coarse Texturing Bases
P100-2020	Flexible Additive

Product Description

The NEXA AUTOCOLOR® 2K HS Plus Single Stage Solid Colour System provides all the benefits of high solids technology in delivering a hard, durable finish with superb gloss. Coupled with its ease of application, it is suitable for all types of repair.

The P471-line 2K HS Plus Solid Colour System is completely lead free and when used according to the recommendations set out in this datasheet, will have a maximum ready for use VOC of 420 g/litre.

Substrates/Preparation

P471-line solid colours should only be applied over:

- Nexa Autocolor 2-pack compliant filler / surfacer hand-flatted with P600 or finer grade wet or dry paper, or machine sanded with P320 grade or finer, prior to topcoat application.
- Nexa Autocolor 2-pack Wet-on-wet primer
- Prepared existing paintwork in sound condition. Existing paintwork should first be abraded (e.g. using Scotch-Brite™ Ultrafine Grey with P562-106 and cleaned with the appropriate Nexa Autocolor pre-cleaner prior to application of P471-line colours.

Note: On new panels coated in works primer/electrocoat a Nexa Autocolor 2-pack primer must be applied.





Standard & Express Process		
	Standard System	Express System
	P471- 2.5 parts P210-8815 1 part P850-1692/3/4 0.7 parts	P471- 2.5 parts P210-8815 1 part P852-1689 0.7 parts
	19 - 24 secs DIN4 at 20°C Pot-Life at 20°C: 1.5 - 2 hours	19 - 24 secs DIN4 at 20°C Pot-Life at 20°C: 15 - 20 minutes
	Fluid Tip Gravity Fed : 1.2-1.4 mm Suction Fed : 1.4-1.6 mm Inlet Pressure : Refer to spraygun manufacturers instructions, normally 2 bar/30 psi (inlet)	Fluid Tip Gravity Fed : 1.2-1.4 mm Suction Fed : 1.4-1.6 mm Inlet Pressure : Refer to spraygun manufacturers instructions, normally 2 bar/30 psi (inlet)
	<p>Conventional 2 coat Process Apply 2 single coats to give 50 - 75 microns (2-3 thou) dry film thickness Allow 5 mins flash-off between coats.</p> <p>Express Single Visit Process Apply 1 light/medium coat followed by a full coat to give 50 microns (2 thou) dry film thickness The first coat should be applied to all repair panels before the second coat is applied. For less than 3 panels, allow 2-3 minutes flash between spray coats. For more than 3 panels, no flash off is required.</p>	
	No flash-off required before baking (5 minutes before IR drying.)	
	<p>Bake at metal temperature of : 50°C 60 minutes 60°C 35 minutes</p> <p>Into-service : When cool</p> <p>Recoatable : After into-service time</p>	<p>Bake at metal temperature of : 50°C 30 minutes 60°C 15 minutes</p> <p>Into-service : When cool</p> <p>Recoatable : After into-service time</p>
	<p>Infra-red drying (depending on colour and equipment.) Short wave :4-5 mins full power Medium wave 5-7 mins full power</p>	

General Process Notes



COLOUR IDENTIFICATION AND CHECKING

As with all Refinish paint systems, a colour check should be carried out before painting the vehicle.

2K HS PLUS SOLID COLOUR SYSTEM COLOUR MIXING

P471-line 2K HS Plus Solid Colour System colours are mixed from 2K HS Plus solid colour P471/2-line mixing basics. This mix should be thoroughly stirred for at least 2 minutes before activation to achieve colour-match.

In order to ensure colour accuracy, it is essential that new cans of P471/2-line 2K HS Plus solid colour mixing basics are thoroughly hand-stirred when opened followed by 10 minutes stirring on a mixing machine. Thereafter, mixing basics should be machine stirred twice a day for a minimum of 10 minutes each time.

FADE-OUT PROCESS

P471-line 2K HS Plus solid colours may be faded-out using the **Spot Blender Aerosol P850-1622** or **Spot Blender P273-1106**. Please refer to the Fade-out / Blending Processes Technical Data Sheet M1200V for details of the technique to achieve a successful repair.

CHOICE OF THINNER

Choose according to application temperature, air movement and size of job.
For guidance only :-

P210-8815 For applications in all temperature conditions

Thinner :	Ideal temperature range :
P850-1692	Up to 25°C
P850-1693	20°C - 30°C
P850-1694	25°C - 35°C
P852-1689 Express Thinner	18 - 22°C for small jobs

Use slower thinners in faster air movement booths, large jobs and high temperatures.
Use faster thinner in slower air movement booths, small jobs and cooler temperatures.

PAINT TEMPERATURE

As with other paint systems, optimum spray application is achieved if the paint is allowed to reach room temperature (20°C) before use. This is particularly important for high solids systems. It is strongly recommended that cold paint is warmed to a *minimum* of 15°C before application. Below this temperature paint application performance may be adversely affected.

RECOATABILITY

P471-line 2K HS Plus Solid Colour System is fully recoatable after the recommended "into-service" times.

General Process Notes

PAINTING PLASTICS

For matted, flexible and textured finishes, P471-line 2K HS Plus solid colours may be converted and made ready for use using the following volume table:

Substrate	Appearance	P471-	P565-554	P565-7210	P565-7220	P100-2020	HS Hardener	Thinner
Rigid	Semi-gloss	2 vol.	2 vol.				1 vol.	1 vol.
	Matt	1.5 vol.	2.5 vol.				1 vol.	1 vol.
	Fine Textured	2 vol.	1 vol.	3 vol.			1 vol.	2 vol.
	Coarse Textured	2 vol.	1 vol.		1.5 vol.		1 vol.	1 vol.
Flexible	Gloss	2 vol.				0.5 vol.	1 vol.	0.4 vol.
	Semi-gloss	2 vol.	2 vol.			0.5 vol.	1 vol.	0.6 vol.
	Matt	1.5 vol.	2.5 vol.			0.5 vol.	1 vol.	0.6 vol.
	Fine Textured	2 vol.	1 vol.	3 vol.		0.5 vol.	1 vol.	2 vol.
	Coarse Textured	2 vol.	1 vol.		1 vol.	0.5 vol.	1 vol.	1 vol.

RECTIFICATION AND POLISHING

Polishing is not normally required as the P471-line 2K HS Plus Solid Colour System has a full gloss finish straight from the gun. However, if dirt is a problem, denib with P1500 or finer, then polish by machine using a quality polish such as SPP Polishing System (refer to SPP TDS).

Polishing P471-line 2K HS Plus Solid Colour System is easiest between 1 and 24 hours after "into service" drying times.

OTHER POINTS TO NOTE

1. When using 2-pack products it is recommended to clean the gun thoroughly immediately after use.
2. All recent single-layer metallic colours will be found as basecoat matches in P965-line AQUABASE[®] basecoat or AQUABASE[®] PLUS P989-line.



General Process Notes

P471 Line 2K HS Plus Weight Mixing Chart

The weight of the hardener and thinner required by certain volumes of mixed colour to produce ready-for-use paint is detailed below. The weights correspond to the mixing ratio: 2.5 parts P471 Line colour: 1 part P210-8815: and 0.7 parts P850-16xx or P852-1689.

'TARE' the scale after mixing or measuring out the colour. The weights of hardener and thinner are **CUMULATIVE** – DO NOT TARE THE SCALE BETWEEN ADDITIONS.

Volume of P471-Line colour mix	Final ready-for-use volume		Weight of P210-8815 Hardener	Weight of P850-16xx Thinner or P852-1689
Litres	Litres (@ 2.5/1/0.7 ratio)		Grams	Grams to 0.7 parts
0.10	0.17		41	64
0.20	0.33	TARE	82	129
0.25	0.42	SCALES	106	163
0.50	0.84		212	326
1.00	1.68		414	644

VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC. The VOC content of this product in ready to use form is max. 420g/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.

NOTE:

Combinations of this product with P565-554, P100-2020, P565-7210 or P565-7220 will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: 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. 840g/litre

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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