

Product Data Sheet

November 2007

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY



L1100V

Undercoating Plastic Substrates P565-line & P100-2020

Description
Wet-on-Wet Primers/Surfacers
High-Build Fillers/Surfacers
Fine Texturing Base for Plastics
Coarse Texturing Base for Plastics
Flexible Additive for Plastics

Product Description

The **Nexa Autocolor** Plastic Painting System gives a step by step approach to the successful painting of all paintable plastic substrates*, from cleaning and preparation through to texturing** and topcoating.

The **Nexa Autocolor** Wet-on-Wet surfacers can be applied directly over most plastics other than PE, PP and PP/EPDM.

The **Nexa Autocolor** wet-on-wet surfacers and build primers can be applied over the appropriate **Nexa Autocolor** Plastic Primer after following the recommended preparation method.

Addition of Flexible additive for plastics (P100-2020) will be necessary depending on the flexibility of the plastic. (See Flexibilising for mixing ratios).

Textures can be achieved by varying the spraying pressure when applying the 2-pack undercoat. This process not only allows for a wider range of textures to be achieved but enables the existing plastic texture to be matched.

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Product Description (continued)

P565-660 (Fine texturing base) and P565-768 (Coarse texturing base) can also be added to the wet-on-wet surfacers to achieve texture.

For details on usage of **Nexa Autocolor** 2 pack undercoats please refer to the relevant PDS's.

* Note; Some grades of PE are considered unpaintable. Some primers are not suitable for use on very solvent sensitive substrates such as Polystyrene (PS). See relevant PDS for details.

** Note: Users of Nexa Autocolor Compliant topcoats should use Texturing Bases, P565-7210 (Fine) and P565-7220 (Coarse), added directly to the topcoat to achieve the correct textured effect. Refer to relevant compliant topcoat PDS for mixing ratio's.

FLEXIBILISING GUIDELINES USING P100-2020

Flexible Additive for Plastics, P100-2020, is a plasticising additive to enhance the flexibility of 2-pack undercoats when used over flexible plastics.

Note: The use of Flexible Additive for Plastics will extend the normal dry time.

		PROCESS FOR FLEXIBLE PLASTICS	PROCESS FOR VERY FLEXIBLE PLASTICS
	.	2 pack undercoat 5 parts P100-2020 1 part	2 pack undercoat 2 parts P100-2020 1 part
-		Then add hardener and thinner in the same way	Then add hardener and thinner in the same way

TEXTURING GUIDELINES - USING TEXTURING BASES

For use with wet-on-wet surfacers only, texturing bases should not be added to flattable primers. To spot repair a textured bumper the texturing base should be added to a 2 pack undercoat in the following way;

	TEXTURING PROCESS		
	2-pack undercoat2 partsTexturing base P565-660 / 7681 partThen add hardener and thinner in the normal way		
Note :	Do not strain There is no need to add P100-2020; Flexible additive for plastics, when using texturing bases. Texturing bases should be stirred thoroughly before use.		

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TEXTURING GUIDELINES - SPRAYING TECHNIQUE				
The following gives general guidance and recommendations on achieving a textured effect, however due to differing guns, environments and spraying conditions we suggest that each user creates their own library of achievable textures. (The library should consist of finished panels as texture may diminish when topcoated).				
After the application of the appropriate plastics primer, apply one coat of the chosen 2- pack undercoat activated and thinned in the normal manner (See relevant PDS), and flash off for 5 mins.				
Mix the chosen undercoat and activator BUT DO NOT THIN				
***	Gravity Fed : 1.3 - 1.5 mm Suction Fed : 1.6 - 1.8 mm <u>Hold the gun 12" - 18" from the panel</u> .	Spray Pressure Guidelines: 3-5 psi - very coarse texture 20-25 psi - very fine texture		
HVLP	Gravity Fed : 1.4 - 1.6 mm Suction Fed : 1.6 - 1.8 mm Hold the gun 12" - 18" from the panel	Spray Pressure Guidelines: 3-5 psi - very coarse texture 20-25 psi - very fine texture		
	Apply 2-3 coats of texture			
) † { † { \$\$\$\$**\$\$\$	Generally 2 minutes flash-off is recommended between coats, depending on the type of texture required. 10 mins at 60°C bake prior to topcoating			
Note: if the texture is uneven or too harsh, lightly flat after 30-40 minutes, with a fine abrasive				
ТОРСОАТ	Topcoat as usual			

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VOC INFORMATION

P565-660	Fine Texturing Base for Plastics
P565-768	Coarse Texturing Base for Plastics
P100-2020	Flexible Additive for Plastics

The EU limit value for these products (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of these products 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: http://www.ppg.com/Autocolor_MSDS

For further information please contact:

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