

Product Data Sheet

November 2007



**INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY**

L1100V

Undercoating Plastic Substrates P565-line & P100-2020

<i>Product</i>	<i>Description</i>
P565-line	Wet-on-Wet Primers/Surfacers
P565-line	High-Build Fillers/Surfacers
P565-660	Fine Texturing Base for Plastics
P565-768	Coarse Texturing Base for Plastics
P100-2020	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.


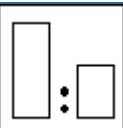



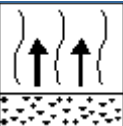

Addition of Flexible additive for plastics (P100-2020) will be necessary depending on the flexibility of the plastic. (See Flexibilising for mixing ratios).

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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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
	Gravity Fed : 1.4 - 1.6 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
	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
TOPCOAT	Topcoat as usual

VOC INFORMATION

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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

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