

Product Data Sheet

July 2014

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

M1200

Blending Process P850-1622 & P273-1106

<i>Product</i>	<i>Description</i>
P850-1622	Spot Blender Aerosol
P273-1106	Spot Blender (For Use Through Spraygun)

Product Description

The NEXA AUTOCOLOR[®] Spot Blender Aerosol and Spot Blender offer an easy and simple fade-out process to cover all types of work.

P850-1622 Spot Blender Aerosol and P273-1106 Spot Blender offer a simple and easy way to implement local repairs with all *Nexa Autocolor* 2K Clearcoats and Solid Colours. They are formulated for easy application and has excellent overspray wetting properties, giving a high gloss and quality finish to the fade-out process.

Refer to individual Technical Data Sheets for general process information on the use of *Nexa Autocolor* Topcoats. This Technical Data Sheet covers the fade-out processes.

General Process Notes

Preparation

- 1) Ensure that the panels involved are thoroughly cleaned.
- 2) Flat the area of primer with no coarser than P800 wet and dry, or P400 dry machine sand.
- 3) Key the surrounding area with a wet 1000 grade **Trizact™** pad on a DA sander (3mm orbit). Where or if Clearcoat or Direct Gloss is to be faded out (up a pillar) this area should be finished with a wet Trizact™ 3000 pad.

Prepare less accessible areas using P562-106 Water-based Flattening Paste with an abrasive **Scotchbrite™** Ultrafine (Grey) or Extra Fine (Copper) pad.

- 4) Thoroughly clean the area to be refinished with suitable pre-cleaner, Tak rag off before spraying.
- 5) With a large blend area, e.g. wing into a door, it is often easier to temporarily mask off the panel to be blended.
- 6) Paint the primed panel in the usual way.
- 7) Remove the temporary masking and using an arcing motion with the spray gun, extend the application into the blend out area, arcing the gun away from the panel and leaving a dry spray blend.

General Process Notes

General Process Notes		
2K Clearcoat Process	P850-1622 Spot Blender Aerosol <ol style="list-style-type: none"> After normal application the gun is arced slightly into the fade-out area, which will leave an overspray edge. Care should be taken not apply the Clearcoat beyond the prepared fade-out area. Apply P850-1622 Spot Blender Aerosol to the 2K Clearcoat edge, applying in light coats to melt the overspray edge. DO NOT apply heavily. Allow the paint film to cure. Polish the fade-out area with a polishing compound (SPP 1001), taking care not to polish through the blend, and finish with a finishing polish. 	P273-1106 Spot Blender <ol style="list-style-type: none"> After normal application the gun is arced slightly into the fade-out area, which will leave an overspray edge. Care should be taken not apply the Clearcoat beyond the prepared fade-out area. Using a spraygun, apply P273-1106 Spot Blender to the 2K Clearcoat edge, applying in light coats to melt the overspray edge. DO NOT apply heavily. Allow the paint film to cure. Polish the fade-out area with a polishing compound (SPP 1001), taking care not to polish through the blend, and finish with a finishing polish.
Direct Gloss Solid Colour Process	P850-1622 Spot Blender Aerosol <ol style="list-style-type: none"> After normal application the gun is arced slightly part way into the fade-out area, which will leave an overspray edge. Apply Clearcoat over the colour edge. Use the same hardener in the clearcoat that was used in the original 2K colour. After normal application the gun is arced slightly away from the panel in the fade-out area leaving a clearcoat overspray edge. Care should be taken not apply the Clearcoat beyond the prepared fade-out area. Apply P850-1622 Spot Blender Aerosol to the clearcoat edge, applying in light coats to melt the overspray edge. DO NOT apply heavily. Allow the paint film to cure. Polish the fade-out area with a polishing compound (SPP 1001), taking care not to polish through the blend, and finish with a finishing polish. 	P273-1106 Spot Blender <ol style="list-style-type: none"> After normal application the gun is arced slightly part way into the fade-out area, which will leave an overspray edge. Apply Clearcoat over the colour edge. Use the same hardener in the clearcoat that was used in the original 2K colour. After normal application the gun is arced slightly away from the panel in the fade-out area leaving a clearcoat overspray edge. Care should be taken not apply the Clearcoat beyond the prepared fade-out area. Using a spraygun, apply P273-1106 Spot Blender to the 2K Clearcoat edge, applying in light coats to melt the overspray edge. DO NOT apply heavily. Allow the paint film to cure. Polish the fade-out area with a polishing compound (SPP 1001), taking care not to polish through the blend, and finish with a finishing polish.

General Process Notes

Alternative Process for Non VOC Regulated Regions

2K Clearcoat Process	<p>Clearcoat “Step down” process</p> <ol style="list-style-type: none"> 1. After normal application the gun is arced slightly part way into the fade-out area, which will leave an overspray edge. 2. Mix the original activated Clearcoat, 1 part Clearcoat to 3 parts P273-1106. Apply this reduced clearcoat mix over the overspray edge, arcing slightly further into the fade-out area. Care should be taken not apply the Clearcoat beyond the prepared fade-out area. 3. If necessary, using a spraygun, apply P273-1106 Spot Blender to the 2K Clearcoat edge, applying in light coats to melt any remaining overspray edge. DO NOT apply heavily. 4. Allow the paint film to cure. 5. Polish the fade-out area with a polishing compound (SPP 1001), taking care not to polish through the blend, and finish with a finishing polish.
Direct Gloss Solid Colour Process	<p>Clearcoat over DG process</p> <ol style="list-style-type: none"> 1. After normal application the gun is arced away slightly away from the panel part way into the fade-out area, to blend the colour into the original to minimize any slight colour difference. leaving an overspray edge. 2. Using the same hardener in the clearcoat that was used in the original 2K colour, mix a small amount of Clearcoat. Mix this activated Clearcoat, 1 part Clearcoat to 3 parts P273-1106. Apply this reduced clearcoat mix over the overspray edge, arcing slightly further into the fade-out area. Care should be taken not apply the Clearcoat beyond the prepared fade-out area. 3. If necessary, using a spraygun, apply P273-1106 Spot Blender to the 2K Clearcoat edge, applying in light coats to melt the overspray edge. DO NOT apply heavily. 4. Allow the paint film to cure. 5. Polish the fade-out area with a polishing compound (SPP 1001), taking care not to polish through the blend, and finish with a finishing polish.

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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