



PDS N5.2

January 2006

P420 **ENGINE BAY COLOR**

PRODUCT DESCRIPTION

P420-XXXX is part of the new Engine Bay Repair System designed to simplify and reproduce the factory appearance for repairs made to cars with a specific engine bay color.

Engine Bay Color is a single layer topcoat providing an accurately matched finish for engine bay areas and can be directly applied to scuffed electrocoat and etch primed bare metal areas. This removes the need to undercoat and colorcoat the internal area; saving time and materials.

- Eliminates Steps = reduced process time
- Accurate Color Match = customer satisfaction

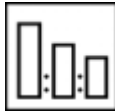



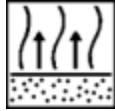


ENGINE BAY COLOR

PRODUCTS

<i>P420-XXXX</i>	<i>Engine Bay Color</i>
<i>P210-854</i>	<i>HS Hardener - Low-Mid Temperature</i>
<i>P210-856</i>	<i>HS Hardener - Mid Temperature</i>
<i>P210-857</i>	<i>HS Hardener - High Temperature</i>
<i>P850-1692</i>	<i>Thinner - Low Temperature</i>
<i>P850-1693</i>	<i>Thinner - Mid Temperature</i>
<i>P850-1694</i>	<i>Thinner - High Temperature</i>
<i>P850-1695</i>	<i>Thinner - Very High Temperature</i>

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

<p>MIX RATIO</p> 	<p>P420-XXXX Engine Bay Color 5 parts P210-85X Hardener 1 part P850-16XX Thinner 2 parts</p> <p>Note: Do not add Matting Agent or Blending Clear to the Engine Bay Color.</p>
<p>VISCOSITY & POT LIFE</p> 	<p>Viscosity: 18-19 seconds DIN 4 @ 70° F (21°C)</p> <p>Pot Life: 30-45 minutes @ 70° F (21°C) with P210-854. 60-90 minutes @ 70° F (21°C) with P210-856/857.</p>
<p>SPRAY GUN & AIR RESSURE</p> 	<p>Siphon: 1.4-1.8mm (.055" - .070") 45-55 psi at the gun Gravity: 1.3-1.6mm (.050" - .063") 45-50 psi at the gun HVLP: 0.8-1.5mm (.031" - .059") Max. 10 psi cap press. 3-8 psi fluid pressure (pressurized cup)</p> <p>(HVLP: Refer to gun manufacture's recommendations for required inlet pressure.)</p>
<p>APPLICATION</p> 	<p>Apply 1 double coat or 2 single coats to give a film thickness of 1-1.5 mils.</p>
<p>FLASH-OFF</p> 	<p>5 minutes between coats 15-20 minutes to topcoat 30-45 minutes to tape 1 Hour to Handle</p>
<p>SANDING</p> 	<p>Engine Bay Colors do not require sanding or topcoating. If engine bay color needs recoating, or if some dirt inclusion occurs, light sanding/denibbing can be carried out after 15-20 minutes at 70°F (23°C) using P1200 or finer sandpaper. If allowed to dry more than 6 hours, overnight or force dried, lightly scuff prior to recoating or topcoating.</p>
<p>DRY TIMES</p> 	<p>Air dry 6 hours @ 70°F (21°C) or bake 20 minutes @ 140°F (60°C) with P210-854 Air dry 8 hours @ 70°F (21°C) or bake 30 minutes @ 140°F (60°C) with P210-856 Air dry 12 hours @ 70°F (21°C) or bake 40 minutes @ 140°F (60°C) with P210-857</p>

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SUBSTRATES

Engine Bay Colors can be applied over:

Factory Finishes in good condition after proper cleaning, degreasing and sanding with P320-400 Dry or P400-500 Wet.

E-Coat: After degreasing, Engine Bay Color may be applied over OEM e-coat replacement parts without sanding. For optimum performance, exterior parts should be lightly abraded and cleaned prior to the application of Engine Bay Color.

Plastics: When using Engine Bay color as a sealer on plastics, It must be flexed at a 5:1 ratio with P100-2020 flexible additive prior to activating and thinning.

Bare Metal – after degreasing and sanding with P180 Grit and applying Chromate Free Etch, Long Life Etch or 1K Etch Primer.

Fiberglass – after degreasing and sanding with P320-400 Dry or P400-500 Wet.

PROCESS NOTES

Select the correct engine bay color using Engine Bay Fan Decks. Activate and thin the engine bay color and apply directly to the repair area.

CHOICE OF HARDENER/THINNER

Hardener and reducer selection will depend mainly on temperature, but also on air movement and size of repair (refer to the Hardener/Thinner Selection Guide).

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EQUIPMENT CLEANING

Approved Cleaning Solvent

2K PERFORMANCE SPECIFICATIONS

Product:	P420-XXXX Engine Bay Color
Category:	Topcoat
VOC As Packaged:	3.38 - 3.62 lbs. per gal/406-434 gm/l
VOC RFU:	4.25 - 4.40 lbs. per gal/510-528 gm/l
RFU Weight Solids:	49% - 55%
RFU Volume Solids:	32% - 35%

For further information please contact:

Nexa Autocolor-USA
19699 Progress Drive
Strongsville, OH 44149

Nexa Autocolor-Canada
2301 Royal Windsor Drive
Mississauga, Ontario L5J 1K5