



PDS N5.3.1

July 2005

P422

2K™ BASECOAT

PRODUCT DESCRIPTION

2K™ Basecoat is a high quality fast drying acrylic basecoat available in solid, metallic and pearlescent colors. This product offers exceptional hiding power.

2K™ Basecoat is suitable for spot and panel repairs, as well as complete resprays.

- Great Coverage = fewer coats, materials savings
- Excellent Color Match = customer satisfaction
- Fast Dry = reduced process time
- Easy application = consistent results

2K™ BASECOAT COLOR

PRODUCTS

P422-XXXX

2K™ Basecoat Color

P850-1692

Thinner-Low Temperature

P850-1693

Thinner-Mid-Temperature

P850-1694

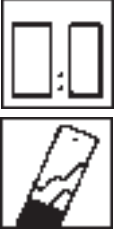



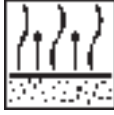

Thinner-High Temperature

P850-1695

Thinner-Very High Temperature

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

MIX RATIO	STANDARD	ACTIVATED (Optional*)
	<p>P422- Basecoat 1 part</p> <p>P850-16XX Thinner 1 part</p>	<p>P422- Basecoat 10 parts</p> <p>P210-796/798 Hardener 1 part</p> <p>The above mixture should mixed @ 1:1 with P850-16XX Thinner.</p> <p>Note: Use only P210-796/798 for Basecoat Activation.</p>
<p>VISCOSITY & POT LIFE</p> 	<p>Thin by volume only.</p> <p>Pot Life: Indefinite</p>	<p>Pot Life: 6-8 hours</p>
<p>SPRAY GUN & AIR PRESSURE</p> 	<p>Siphon: 1.4-1.6mm (.055"-063") 40-45 psi at the gun</p> <p>Gravity: 1.3-1.4mm (.050"-055") 40-45 psi at the gun</p> <p>HVLP: 0.8-1.5mm (.031"-059") Max. 10 psi cap pressure 3-8 psi fluid pressure (pressurized cup) (HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)</p>	
<p>APPLICATION</p> 	<p>2-3 single coats to coverage.</p>	
<p>FLASH TIME</p> 	<p>5 minutes between coats.</p>	
<p>DRYING TIME</p> 	<p>AIR DRY @ 70° F (21°C). Minimum 15 minutes before application of Clearcoat. Note: Allow a minimum of 20-30 minutes dry before taping.</p>	

2K™ BASECOAT COLOR

SUBSTRATES

2K™ Basecoat Color P422 can be applied over existing finishes in good condition, Nexa Autocolor 2-pack primers after sanding with P600 wet or P400 dry by machine, Wet on Wet Sealer and Plastics Adhesion Primers (P572-2000/2001). When using 2K™ Basecoat on plastics, refer to PDS N7.1.

RECOATABILITY

2K™ Basecoat should be clearcoated after recommended dry times.

NOTE: If 2K™ Basecoat has dried longer than 24 hours, lightly scuff and apply additional basecoat before clearcoating.

If 2K™ Basecoat has been sanded, reapply 2K™ Basecoat prior to clearcoating.

GENERAL PROCESS NOTES

*Optional activation of basecoat on leading edge parts such as bumper covers and hoods will improve stone chip resistance.

CHOICE OF THINNER

Thinner selection will depend mainly on temperature, but also air movement and size of repair. Refer to Hardener and Thinner Selection Guide.

For optimum application, paint systems should not be applied cold. Best results will be obtained by allowing adequate time for paint to reach 70° F (21° C).

In the event of fish-eyes in 2K™ Basecoat, allow basecoat to dry fully remove fish-eyes by lightly sanding with P1000 and re-apply 2K™ Basecoat.

For blending of 2K™ Basecoat Color, refer to PDS N7.3. Blending Techniques.

EQUIPMENT CLEANING

Approved Cleaning Solvent

2K™ BASECOAT COLOR

2K™ PERFORMANCE SPECIFICATIONS

Product:	P422-XXXX
Category:	Topcoat (Component of bc/cc system or 3 / 4 stage)
VOC As Packaged:	Maximum 5.93 lbs. per gal/711gm/l
VOC RFU:	Maximum 6.40 lbs. per gal/767 gm/l @ 1:1
VOC RFU (Activated):	Maximum 6.40 lbs. per gal/767 gm/l @ 10:1:11

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