

PDS N6.25

April 2004

P420

2K™ INTERIOR COLOR

PRODUCT DESCRIPTION

2K™ Interior Color is a high quality system for the painting of rigid interior plastic and vinyl parts.

- Fast dry = reduced process time
- Easy application = consistent results
- Excellent color match = customer satisfaction

2K™ INTERIOR COLOR

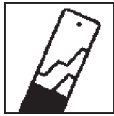
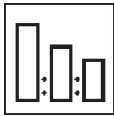
PRODUCTS

| | |
|------------------|---------------------------|
| <i>P420-XXXX</i> | <i>2K™ Interior Color</i> |
| <i>P190-478</i> | <i>Converter</i> |
| <i>P850-1401</i> | <i>Fade-Out Thinner</i> |

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

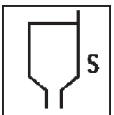
MIXING RATIO



| | | |
|-----------|------------------|--------|
| P420 | Interior Color | 1 part |
| P850-1401 | Fade-Out Thinner | 1 part |
| P190-478 | Converter | 1 part |

Note: Do not add Hardener or other Additives to this mixture.

VISCOSITY & POT LIFE



Viscosity: 4 seconds DIN 4 @ 70°F (21° C)

Pot Life: Indefinite

SPRAY GUN AND AIR PRESSURE



Siphon: 1.4-1.6mm (.055" - .063")

30-35 psi at the gun

Gravity: 1.3-1.6mm (.050" - .063")

30-35 psi at the gun

HVLP: 0.8-1.5mm (.031"-059")

Max 10 psi cap pressure

3-8 psi cap pressure (pressurized cup)

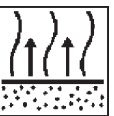
(HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)

APPLICATION



2-3 medium coats.

FLASH-OFF



5 minutes between coats.

DRYING TIME



Air Dry Only

Handleable after **30 minutes** @ 70°F (21°C).

2K™ INTERIOR COLOR

SUBSTRATES

2K™ Interior Color can be applied over interior plastic and vinyl substrates after lightly scuffing with a grey scuff pad, pre-cleaning with Cleaner for Plastics (P273-1333) and the application of 1K Adhesion Primer for Plastics (P572-2000/2001).

Note: This system should not be applied on very flexible vinyl substrates, such as vinyl seat covers.

Do not apply 2K™ Interior Color to external parts such as vinyl top, bumpers, etc.

EQUIPMENT CLEANING

Approved Cleaning Solvents

2K™ PERFORMANCE SPECIFICATIONS

| | | |
|-------------------------|---------------------------------|---------------------------------|
| Product: | P420-XXXX | Interior Color |
| | P190-478 | Converter |
| | P850-1401 | Fade-out Thinner |
| Category: | Specialty | |
| VOC As Packaged: | P420-XXXX | Max. 5.00 lbs. per gal/600 gm/l |
| | P190-478 | 6.19 lbs. per gal/742 gm/l |
| | P850-1401 | 7.00 lbs. per gal/840 gm/l |
| VOC RFU: | Max. 7.00 lbs. per gal/840 gm/l | |

For further information please contact:

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