



**PDS N7.3**

January 2005

## **2K™ *BLENDING TECHNIQUES***

### **PRODUCT DESCRIPTION**

The Nexa Autocolor 2K™ Blending Process offers easy and simple techniques to cover all types of work. 2K™ Fade-Out Thinner (P850-1401) is formulated for easy application and has excellent overspray wetting properties, giving a high gloss finish. Basefade (P273-1051) helps to provide easy basecoat blending particularly for pastel shades and silver basecoat colors.

## **2K™ BLENDING TECHNIQUES**

### **PRODUCTS**

<b><i>P422-XXXX</i></b>	<b><i>2K™ Basecoat Color</i></b>
<b><i>P420 / 421</i></b>	<b><i>2K™ HS Single Layer Color</i></b>
<b><i>P190-643</i></b>	<b><i>HS Clearcoat</i></b>
<b><i>P190-5520</i></b>	<b><i>Clearcoat</i></b>
<b><i>P190-6100</i></b>	<b><i>Fast HS Clearcoat</i></b>
<b><i>P190-6330</i></b>	<b><i>HS Production Clearcoat</i></b>
<b><i>P850-1401</i></b>	<b><i>Fade-Out Thinner</i></b>
<b><i>P273-1051</i></b>	<b><i>Basefade</i></b>

**THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY**

# 2K™ BLENDING TECHNIQUES

## GENERAL PRODUCT INFORMATION

Refer to the appropriate Product Data Sheets information regarding the use of 2K™ HS Single Layer, 2K Basecoat and Clearcoats.

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## SURFACE PREPARATION

**Proper preparation is critical to the success of any repair, and great care must be exercised at this stage in order to achieve a satisfactory result.**

1. Be sure that all panels that may be involved in the repair or blend are thoroughly cleaned and degreased.
2. Sand repair area with P400 wet for Single Layer colors and P600 wet for Basecoat colors, or P320 dry machine for Single Layer and P400 dry machine for Basecoat.
3. Prepare surrounding area by sanding with P1500 wet or Grey scuff pad used wet with P562-100. If using compound, once the surface has been abraded, remove excess compound with Body Cleaner (P273-901) to avoid re-polishing the surface.
4. Before topcoating, degrease the panel(s) with Waterborne Pre-Cleaner (P980-251). When degreasing, use one rag for wiping on Waterborne Pre-Cleaner and another for wiping off.
5. Finally tack the entire surface to be painted.

# 2K™ BLENDING TECHNIQUES

## FADE-OUT THINNER METHOD

**This is the standard method for spot repairing all finishes, Metallic Basecoat, Solid Basecoat and Two-Stage Pearls). Do not use this method to repair Three-Stage Pearl colors. It is best for older cars, doorjamb and less visible areas.**

1. Using normal ready to spray paint, cover the painted area, using low air pressure, (30 psi at the gun) and extend into the prepared surrounding area using an arcing motion of the gun.
2. Add 1 part 2K™ Fade-Out Thinner (P850-1401) to 2-3 parts mix in gun and blend further into the prepared surrounding area using an arcing motion of the gun, with low pressure at the gun. Overlap the previous coats, but be sure to remain within the prepared area.
3. As soon as possible, carefully apply straight Fade-Out Thinner to the dry edge using several light passes to dissolve any dry spray, with low pressure at the gun.
4. Allow film to dry or flash-off according to the recommended times

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## SINGLE LAYER/CLEARCOAT

1. It is not recommended to blend Single Layer or Clearcoat on exterior panels.
2. For blending less visible areas and doorjamb, follow procedures described above.

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## CLEARCOAT AS A BLENDING CLEAR METHOD

**This method should be used for Single Layer Systems (P420 / 421), to give a high quality, glossy finish. It is the best method for highly visible areas.**

1. Using normally activated and thinned paint, cover the primed area, using low pressure. Extend into the prepared surrounding areas using an arcing motion of the gun.
2. Add 1 part normally activated Clearcoat to 2 parts of the mix in the gun and blend further into the prepared surrounding area, with low pressure at the gun. Use an arcing motion of the gun, overlapping the previous coat. Clean the gun after this step.
3. Allow Single Layer (P420 / 421) to flash-off 20-30 minutes before Clearcoating.
4. Apply one full coat of normally activated Clearcoat to the full panel repaired.

## BASEFADE BLENDING METHOD

**This method should only be used for metallic basecoats and two-stage pearls. It is particularly useful for pastel shades and lighter basecoat colors.**

1. Using normally thinned paint, cover the primed area using low air pressure. Extend into the prepared surrounding area using an arcing motion of the gun.
2. Add up to 1 part Basefade (P273-1051) to 1 part of the mix in the gun and blend further into the surrounding area, with low air pressure at the gun. Use an arcing motion of the gun and overlap previous coats.

**or**

Alternatively, for small area repairs, add 1 part Basefade (P273-1051) to 2 parts normally thinned paint. Use this to cover the primed and prepared surrounding areas as described in 1 above. Then add up to a further 1 part Basefade to 1 part mix in the gun and blend further into the prepared surrounding area as in 2 above.

3. Allow Basecoat to flash-off as normally as recommended.
4. Apply Clearcoat in the normal way.
5. Allow Clearcoat to dry according to the recommendations in Product Data Sheet for Clearcoat.

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## 3-STAGE PEARL BLENDING METHOD

### **Method for blending and spot repair of 3-stage pearls**

1. Apply normally thinned Groundcoat to completely cover the primed area, using low pressure. Minimize the overlap into the prepared surrounding area.
2. Add 1 part Fade-Out Thinner (P850-1401) to 2 parts of the Groundcoat mix in the gun. Use an arcing motion, overlapping the previous coat.
3. Add 1 part normally thinned Pearl Basecoat Color to 2 parts of the mix in the gun and apply 1 or 2 light coats up to the edge of the groundcoated area, with low pressure at the gun. Minimize the overlap into the prepared surrounding area. Discard paint and clean gun after this step.

# 2K™ BLENDING TECHNIQUES

## 3-STAGE PEARL BLENDING METHOD (cont.)

4. Apply thinned Pearl Basecoat Color to the repair, with low pressure at the gun, up to the edge of the groundcoated area. Minimize overlap into the prepared surrounding area.
5. Add 1 part of Fade-Out Thinner (P850-1401) to 2 parts of the mix in the gun and blend further into the prepared surrounding area overlapping the previous coat, with low pressure at the gun.
6. Add 1 part of activated Clearcoat to 2 parts of the mix in the gun and blend further into the prepared surrounding area overlapping the previous coat, with low pressure at the gun. Discard the paint and clean gun after this step.
7. Apply Clearcoat to the entire prepared panel, or to a convenient break line, in the normal way.
8. Allow Clearcoat to dry according to the recommendations in the Product Data Sheet.

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## 2K™ PERFORMANCE SPECIFICATIONS

<b>Product:</b>	P850-1401 Fade-Out Thinner
	P273-1051 Basefade
<b>Category:</b>	Speciality
<b>VOC As Packaged:</b>	P850-1401 7.00 lbs. per gal/840 gm/l
	P273-1051 6.51 lbs. per gal/806 gm/l

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