

Product Data Sheet

May 2011

INTERNATIONAL MASTER
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M1000V

Blending Process P850-1621 & P273-1105

<i>Product</i>	<i>Description</i>
P850-1621	Aerosol Fade-Out Thinner
P273-1105	Express Blender (For Use Through Spraygun)

Product Description

The **Nexa Autocolor** Aerosol Fade-Out Thinner and Express Blender offer an easy and simple fade-out process to cover all types of work.

P850-1621 Aerosol Fade-Out Thinner and P273-1105 Express 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

2K Clearcoat Process	<p style="text-align: center;">P850-1621 Aerosol Fade-Out Thinner</p> <ol style="list-style-type: none"> 1) 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. 2) Apply P850-1621 Aerosol Fade-Out Thinner to the 2K Clearcoat edge, applying in light coats to melt the overspray edge. DO NOT apply heavily. 3) Allow the paint film to cure. 4) 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. 	<p style="text-align: center;">P273-1105 Express Blender</p> <ol style="list-style-type: none"> 1) 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. 2) Using a spraygun, apply P273-1105 Express Blender to the 2K Clearcoat edge, applying in light coats to melt the overspray edge. DO NOT apply heavily. 3) Allow the paint film to cure. 4) 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.
P471-2K HS Plus Solid Colour Process	<p style="text-align: center;">P850-1621 Aerosol Fade-Out Thinner</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) 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. 3) Apply P850-1621 Aerosol Fade-Out Thinner to the 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. 	<p style="text-align: center;">P273-1105 Express Blender</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) 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. 3) Using a spraygun, apply P273-1105 Express 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.

VOC INFORMATION**AEROSOL FADE OUT THINNER, P850-1621**

The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC.
The VOC content of this product in ready to use form is max. 840g/litre.


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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