

PDS N4.1.2C

November 2021

AQUABASE[®] PLUS P565-5401, P565-5405, P565-5407 HS Plus Primer-Surfacers

PRODUCT DESCRIPTION

AQUABASE[®] Plus HS Plus Primer-Surfacers are 2-pack acrylic urethane sandable primers designed for use under the Aquabase Plus Waterborne Basecoat. They are easy to apply and sand and give excellent final appearance and durability.










HS Plus Primer-Surfacers are a component of the Spectral Grey Undercoat System. HS Plus Primer-Surfacers; available in white, grey and black, are used to achieve the full range of Spectral Grey shades. HS Plus Primer-Surfacers may also be accelerated for faster air dry process as needed.

- *High Build = Fewer Coats / Materials savings*
- *Excellent Holdout = Less rework*
- *Spectral Grey System = Reduced color costs*
- *Fast Dry = Reduced Process Time*

Products	
P565-5401 (White)/-5405 (Grey) /-5407 (Black)	Fast HS Primer Surfacers
P210-5475/5476	Hardeners
P850-1772/-1775	Thinners
P100-2021	LV Flexible Additive
SLV814	Universal Flexibilizer
SL93LV	Accelerator

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

HS Plus Primer-Surfacers

PROCESS					
<div>MIX RATIO</div> <div></div> <div></div>	<div>Spray Filler</div> <div>P565-540x: 4 parts P210-5475/-5476: 1 part</div>	<div>Primer-Surfacer</div> <div>P565-540x: 4 parts P210-5475/-5476: 1 part P850-1775: 1 part</div>	<div>Accelerated Primer-Surfacer</div> <div>P565-540x: 4 parts P210-5475/-5476: 1 part P850-1772: 1 part SL93LV: +10%</div>		
	Accelerated Primer-Surfacer Mix Ratio by Cumulative Weight in Parts (Grams) 4:1:1+10%				
	Volume	4 oz. / ¼ pint	8 oz. / ½ pint	16 oz. / 1 pint	32 oz. / 1 quart
	P565-540x Primer-Surfacer	132 (117)	264 (234)	528 (468)	1055 (960)
	P210-5475/-5476 Hardener	157 (140)	315 (279)	630 (558)	1258 (1116)
	P850-1772 Reducer	179 (159)	358 (317)	716 (634)	1430 (1269)
	SL93LV Accelerator	195 (173)	390 (346)	781 (692)	1560 (1384)
	Note: Use fast reducer only. Additional mix volumes may be found on PAINTMANAGER®				
	<div>POTLIFE</div> <div></div>	<div>Sprayable Pot Life:</div> <div>Spray Filler: 30 minutes at 70°F (21°C) Primer-Surfacer: 1 hour at 70°F (21°C) Accelerated Primer-Surfacer: 30 minutes at 70°F (21°C)</div>			
	<div>SPRAYGUN & AIR PRESSURE</div> <div></div>	<div>Fluid Tip:</div> <div>Spray Filler: 1.7 - 2.0 mm Primer-Surfacer: 1.6 - 1.8 mm Accelerated Primer-Surfacer: 1.6 - 1.8 mm</div> <div>HVLP: 10 PSI cap pressure Compliant: 29 - 40 PSI at the gun*</div> <div>Note: Refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.</div>			
<div>APPLICATION</div> <div></div>	<div>Apply:</div> <div>Spray Filler: Maximum of 4 coats Primer-Surfacer: 2 - 3 full coats to give a dry film thickness of 4 - 6 mils</div>				
<div>FLASH TIME</div> <div></div>	<div>Between coats:</div> <div>5 - 10 minutes</div>				
<div>DRY TIMES</div> <div></div> <div></div> <div></div>	<div>Air Dry:</div> <div>Spray Filler:* 6 hours or overnight at 70°F (21°C) at 4 - 6 mils Primer-Surfacer: 1.5 hour at 70°F (21°C) at 2 - 3 mils Accelerated Primer-Surfacer:* 20 - 30 minutes at 70°F (21°C) at 2 - 3 mils</div> <div>Force Dry:*</div> <div>Primer-Surfacer: 30 minutes at 140°F (60°C)</div> <div>Infrared:*</div> <div>Primer-Surfacer: 8 - 12 minutes Short Wave</div> <div>* Do not force or infra-red dry when using in the accelerated or spray filler mode.</div>				

All force dry times are quoted for surface temperature.
Additional time must be allowed during force dry to allow surface to reach recommended temperature.

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HS Plus Primer-Surfacers

GENERAL PROCESS NOTES

SUBSTRATES

P565-5401, P565-5405 and P565-5407 can be applied directly over factory primer, GRP / Fiberglass, existing finishes in good condition after degreasing and sanding with P280-P320 grit dry.

P565-5401, P565-5405 and P565-5407 can be applied over bare steel, aluminum, and galvanized metals after etch priming with ONECHOICE® SX1071 Etch Primer or preparation with SX Metal Treatments.

Over thermoplastic acrylic and old lacquer finishes, P565-540x must be applied to the complete panel.

PROCESS NOTES

CHOICE OF HARDENER AND THINNER

Hardener and thinner selection will depend mainly on temperature, but also on air movement and size of repair.

P210-5475	HS Plus Surfacer / Sealer Hardener
P210-5476	Undercoat Hardener - Slow
P850-1772	Fast Reducer
P850-1775	Slow Reducer

All drying times in this summary will depend on the film thickness applied and temperature.

Infra-red drying times given require the short wave infra-red lamp to be positioned 28 - 40 inches away from the panel. Allow P565-540x to flash off for 5 minutes before drying with the infra-red lamp.

Drying times will depend on the type of infra-red lamp used. Do not infra-red dry when used in the Spray Filler or Accelerated mode.

For optimum performance, paint systems should not be applied cold. For best results, allow adequate time for paint to reach 70°F (21°C).

PLASTICS USAGE

P565-540x	HS Plus Primer-Surfacer	5 parts
P100-2021/SLV814	Flexible Additive	1 part

This mixture should then be activated and thinned as normal
More detail on refinishing plastics can be found in PDS N7.1

RECOATABILITY

P565-5401, P565-5405 and P565-5407 must be sanded before top coating with *Aquabase Plus* Basecoat.

Wet Sanding:	P600 / P800
Machine Sanding:	P360 / P400

After sanding, if P565-540x is left for longer than 3 days, it must be re-sanded prior to further application of additional primer, sealer or topcoat.

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SPECTRAL GREYS

Aquabase Plus Spectral Grey Mixing Chart

P565-540x HS Plus Primer-Surfacers

This chart can be used to mix P565-540x HS Plus Primer-Surfacers. The SG01-SG07 ratios will help to achieve better hiding when used as a guide for mixing the Spectral Grey Primer-Surfacers

MIX RATIO BY VOLUME			MIX RATIO BY WEIGHT Cumulative Weight in Grams						
Ratio			¼ Pint	½ Pint	1 Pint	1 Quart	2 Quarts	3 Quarts	1 Gallon
SG01	P565-5401	4	128	257	513	1026	2052	3079	4105
	P210-5475/6	1	153	306	612	1225	2449	3674	4899
	P850-1775	1	180	359	718	1437	2874	4310	5747
SG03	P565-5401	3	96	192	385	770	1539	2309	3079
	P565-5405	1	128	257	514	1027	2055	3082	4109
	P210-5475/6	1	153	306	613	1226	2452	3677	4903
	P850-1775	1	180	360	719	1438	2876	4314	5751
SG05	P565-5405	4	129	258	515	1031	2061	3092	4122
	P210-5475/6	1	154	307	615	1229	2458	3687	4916
	P850-1775	1	180	360	721	1441	2882	4323	5765
SG06	P565-5405	Mix By Weight Only	84	168	335	670	1340	2010	2680
	P170-5407		127	254	509	1017	2034	3051	4068
	P210-5475/6		152	304	608	1215	2430	3645	4860
	P850-1775		178	357	714	1427	2854	4281	5708
SG07	P170-5407	4	124	248	495	991	1981	2972	3962
	P210-5475/6	1	149	297	595	1189	2378	3567	4756
	P850-1775	1	175	350	701	1401	2802	4203	5605

Note: These weights will produce approximately 97.5% of the volume stated to allow for mixing in the can. If an exact quart, pint, half-pint, etc. is required, multiply all weights by 1.025. All weights have been rounded off to whole numbers.

EQUIPMENT CLEANING

Approved NEXA AUTOCOLOR® or PPG Cleaning Solvent

VOC COMPLIANCE

To ensure accurate mixing, best performance & VOC compliance:

- When mixed as directed these products will achieve <2.1lbs, 250 g/L VOC
- Use the correct mixing ratio for the regulated areas.
- Do not add extra hardener, thinner or change the recommended mixing ratio.
- Do not use hardeners or thinners that are not specified in this process summary.
- Do not tint except where as referenced in the Spectral Grey chart.

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HS Plus Primer-Surfacers

GENERAL PROCESS NOTES

RTS Combinations	Spray Filler P565-540x : P210-5475/6	Primer-Surfacer P565-540x : P210-5475/6 : P850-1772/5	Accelerated Primer-Surfacer P565-540x : P210-5475/6 : P850-1772/5 + SL93LV	Flexible Primer-Surfacer (Premix P565-540x : P100-2021/ SLV814 at 5:1 ratio) P565-540x : P210-5475/6 : P850-1772/5
Volume Ratio	4 : 1	4 : 1 : 1	4 : 1 : 1 + 10%	4 : 1 : 1
Applicable Use Category	Primer	Primer	Primer	Primer
VOC Actual (g/L)	137-143	114-119	104-108	101-117
VOC Actual (lbs./Gal)	1.14-1.19	0.95-0.99	0.87-0.90	0.84-0.98
VOC Regulatory (g/L) (less water, less exempts)	241-252	240-252	238-250	225-241
VOC Regulatory (lbs./Gal) (less water, less exempts)	2.01-2.10	2.00-2.10	1.99-2.09	1.88-2.01
Density (g/L)	1502-1554	1429-1520	1421-1503	1385-1474
Density (lbs./Gal)	12.54-12.97	11.93-12.68	11.86-12.54	11.56-12.30
Volatiles wt. %	45.9-48.2	52.5-56.0	56.3-59.6	53.0-59.0
Water wt. %	0.0	0.0	0.0	0.0
Exempt wt. %	37.1-38.7	44.7-48.0	49.2-52.2	45.0-51.7
Water vol. %	0.0	0.0	0.0	0.0
Exempt vol. %	43.0-43.4	52.4-52.8	56.6-57.0	51.1-55.5
Solids vol. %	40.1-40.8	33.4-34.0	30.5-31.1	32.4-35.5
Solids wt. %	51.8-54.1	44.0-47.5	40.4-43.7	41.0-47.0
Sq. Ft. Coverage US Gal. 1 mil at 100% transfer efficiency	830-868	705-764	648-701	658-754

HEALTH AND SAFETY

See Safety Data Sheet and Labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDSs of all the components since the mixture will have the hazards of all of its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statement listed on label. Statement and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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