



# PDS N4.1.1

April 2017

## NEXA AUTOCOLOR® 2K® P565-5301 & P565-5305 Fast HS Primer-Surfacers

### PRODUCT DESCRIPTION

NEXA AUTOCOLOR® 2K® P565-5301 and P565-5305 Fast HS Primer-Surfacers are acrylic urethane primer-surfacers developed for use under 2K Basecoat or 2K Single Layer Color. They offer easy application and sanding with excellent holdout and durability.

Fast HS Primer Surfacers are a component of the Spectral Grey undercoat system. P565-5301/-5305 and P170-5670 are used to achieve the full range of Spectral Grey colors. Using Spectral Grey undercoats can reduce the amount of colorcoat required.

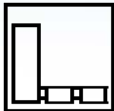






- Spectral Grey System = reduced color costs
- Excellent holdout = less rework

Products	
P565-5301/-5305	Fast HS Primer-Surfacers
P210-796/-798/-842	MS Hardeners
P850-1692/-1693/-1694/-1695	2K Thinners
P170-5670	HS Tinter for Spectral Greys
P100-2020	Flexible Additive

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

# Fast HS Primer-Surfacers

## PROCESS

<b>MIX RATIO</b> 	<b>P565-5301/-5305</b> <b>P210-796/-798/-842</b> <b>P850-16xx</b>  Note: Only P210-796/-798 and P210-842 hardeners can be used in Fast HS Primer-Surfacers	Primer Surfacer Hardener Thinners	5 parts 1 part 1 part
<b>POTLIFE</b> 	<b>Pot Life:</b>  <b>Viscosity:</b>	45 - 60 minutes at 70°F (21°C)  25 - 30 seconds DIN4 at 70°F (21°C)	
<b>SPRAYGUN &amp; AIR PRESSURE</b> 	<b>Fluid Tip:</b> <b>HVLP:</b> <b>Compliant:</b>	1.6 - 1.9 mm 10 PSI cap pressure 29 - 40 PSI at the gun	For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures
<b>APPLICATION</b> 	<b>Apply:</b> <b>Total Dry Film Build:</b>	2 - 3 coats 3.0 - 5.0 mils	Note: Film build will depend on fluid tip selection
<b>FLASH TIME</b> 	<b>Between Coats:</b>	5 minutes at 70°F (21°C)	
<b>DRY TIMES</b> 	<b>Air Dry to Sand:</b>  <b>Force Dry to Sand:</b> With P210-842 With P210-796/798  <b>Infrared:</b> Short Wave:	1.5 - 2.5 hours at 70°F (21°C)  20 minutes at 140°F (60°C) 30 minutes at 140°F (60°C)  8 - 12 minutes after a 5 minute flash	
<b>SANDING</b> 	<b>Wet Sanding:</b> <b>Single Layer Color:</b> <b>Basecoat Color:</b>  <b>Machine Sanding:</b> <b>Single Layer Color:</b> <b>Basecoat Color:</b>	P400 P600  P320 or finer P360 or finer	

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

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

# Fast HS Primer-Surfacers

## GENERAL PROCESS NOTES

### SUBSTRATES

P565-5301 and P565-5305 Fast HS Primer-Surfacers can be applied over factory primer, GRP/ Fiberglass, existing finishes in good condition, and polyester putties after degreasing and machine sanding with P180 - P220 grit dry.

Fast HS Primer-Surfacers can be applied over bare steel, aluminum and galvanized metals after priming with etch primer.

Over thermoplastic acrylic and old lacquer finishes, Primer-Surfacers should 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. (Refer to Selection Guide).

P210-796	MS Hardener - Normal
P210-798	MS Hardener - Slow
P210-842	MS Hardener - Express
P850-1692	Thinner - Low Temperature less than 65°F (18°C)
P850-1693	Thinner - Mid Temperature 65 - 77°F (18 - 25°C)
P850-1694	Thinner - High Temperature 77 - 95°F (25 - 35°C)
P850-1695*	Thinner - Very High Temperature 95°F (35°C)

\* Because of its slow evaporation rate, the use of P850-1695 Thinner in undercoats can extend dry times. Additional flash and dry time may be required prior to sanding or recoating. See Hardener/ Thinner Selection Guide for additional information.

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

### PLASTICS USAGE

		<u>Flexible</u>	<u>Very Flexible</u>
P565-5301/-5305	RTS Fast HS Primer-Surfacers	5 parts	2 parts
P100-2020	Flexible Additive	1 part	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

Primer must be sanded before topcoating. When dry and sanded, Fast HS Primer-Surfacer can be directly topcoated with Nexa Autocolor 2K P420 Single Layer, P422 2K Basecoat or a 2K wet on wet sealer.

### EQUIPMENT CLEANING

Approved PPG Cleaning Solvent

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

# Fast HS Primer-Surfacers

## SPECTRAL GREYS

Mix Ratio (By Volume)			Mix Ratio By Weight (Cumulative Weight in Grams)			
		Ratio	1/4 Pint	1/2 Pint	Pint	Quart
<b>SG01 Sealer</b>	P565-5301	5	128	255	509	1017
	P210-796/-798/-842	1	144	287	574	1147
	P850-16xx	1	157	314	628	1155
<b>GS03 Sealer</b>	P565-5301 (80%)	5	102	202	407	814
	P565-5305 (20%)		128	255	509	1017
	P210-796/-798/-842	1	144	288	574	1147
	P850-16xx	1	157	314	628	1255
<b>SG05 Sealer</b>	P565-5305	5	128	255	509	1017
	P210-796/-798/-842	1	144	287	574	1147
	P850-16xx	1	157	314	628	1255
<b>SG06 Sealer</b>	P565-5305 (99%)	5	126	251	502	1004
	P170-5670 (1%)		127	254	507	1014
	P210-796/-798/-842	1	143	286	572	1143
	P850-16xx	1	157	313	626	1251
<b>SG07 Sealer</b>	P565-5305 (92%)	5	114	228	456	912
	P170-5670 (8%)		124	248	496	992
	P210-796/-798/-842	1	141	281	561	1122
	P850-16xx	1	154	308	615	1229

**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.

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

# Fast HS Primer-Surfacers

INNOVATING REPAIR SOLUTIONS

## GENERAL PROCESS NOTES

RTS Combinations	P565-5301/-5305 w/ P170-5670 : P210-796/798/842 : P850-16xx	P565-3011/-3015 w/ P170-5670 : P100-2020 : P210-96/798/842 : P850-16xx	P565-3011/-3015 w/ P170-5670 : P100-2020 : P210-796/798 : P850-16xx
Volume Ratio	5 : 1 : 1	5 (5 : 1) : 1 : 1	5 (2 : 1) : 1 : 1
Applicable Use Category	Primer Surfacer	Primer Surfacer (Flexed)	Primer Surfacer (Flexed)
VOC Regulatory (g/L) (less water, less exempts)	514 - 558	509 - 545	503 - 532
VOC Regulatory (lbs/Gal) (less water, less exempts)	4.29 - 4.66	4.25 - 4.55	4.20 - 4.44
Solids vol.%	36.0 - 40.6	37.4 - 41.2	38.8 - 41.8
Solids wt.%	56.6 - 61.3	55.9 - 60.1	55.6 - 58.7
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	577 - 651	600 - 661	622 - 670

### VOC COMPLIANCE

To ensure accurate mixing, best performance & VOC compliance:

- Do not add extra hardener, thinner or change the recommended mixing ratio.
- Do not use hardeners or thinners that are not specific in this process summary.

### 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.

For further information please contact:



Nexa Autocolor - USA  
19699 Progress Drive  
Strongsville, OH 44149

Nexa Autocolor - Canada  
2301 Royal Windsor Drive Unit #6  
Mississauga, Ontario L5J 1K5