



PDS N4.4

July 2005

P565-668

TRANSPARENT ADHESION PROMOTER

PRODUCT DESCRIPTION

P565-668 is a high quality acrylic urethane transparent adhesion promoter. This product can be used Wet-on-Wet prior to topcoating with Nexa Autocolor 2K™ products.

Transparent Adhesion Promoter is an approved product for warranty systems.

- Wet-on-Wet = reduced process time
- Excellent adhesion = less rework

- Transparent = less masking

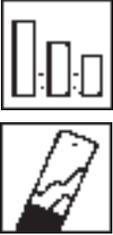
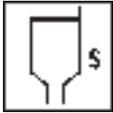
TRANSPARENT ADHESION PROMOTER

PRODUCTS

<i>P565-668</i>	<i>Transparent Adhesion Promoter</i>
<i>P210-796</i>	<i>MS Hardener-Normal</i>
<i>P210-798</i>	<i>MS Hardener-Slow</i>
<i>P850-1692</i>	<i>Thinner-Low Temperature</i>
<i>P850-1693</i>	<i>Thinner-Mid-Temperature</i>
<i>P850-1694</i>	<i>Thinner-High Temperature</i>
<i>P850-1695</i>	<i>Thinner-Very High Temperature*</i>

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

	Adhesion Promoter	Tintable Adhesion Promoter
MIX RATIO 	P565-668 3 parts P210-796/798 1 part P850-16XX 2 parts	P565-668 2 parts P425-HS Solid Tint 1 part Activate the above mixture @ 3:1:2
	Note: Only P210-796/798 Hardener should be used with P565-668.	
VISCOSITY & POT LIFE 	Viscosity: 14-16 seconds Din 4 @ 70°F (21°C) Pot Life: 4-5 hours @ 70°F (21°C)	Viscosity: 14-16 seconds Din 4 @ 70°F (21°C) Pot Life: 4-5 hours @ 70°F (21°C)
SPRAY GUN AND AIR PRESSURE 	Siphon: 1.6-1.8mm (.063" - .070") 50-55 psi at the gun Gravity: 1.3-1.5mm (.050" - .063") 50-55 psi at the gun HVLP: 0.8-1.5mm (.031" - .059") Max 10 psi cap pressure 3-8 psi fluid pressure (pressurized cup) (HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)	
APPLICATION 	1 double coat or 2 single coats with a 5 minute flash-off between coats. (approx. 1.0-1.5 mils). NOTE: Transparent Adhesion Promoter is recommended for complete panels only.	
DRY TIMES 	Allow Transparent Adhesion Promoter to flash-off 15-20 minutes before topcoating. Note: If Transparent Adhesion Promoter has dried longer than 1 hour, see process notes for instructions.	
SANDING 	Transparent Adhesion Promoter does not require sanding, and should be directly topcoated.	

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SUBSTRATES

Transparent Adhesion Promoter

P565-668 used as an adhesion promoter can be applied over factory primer, existing finishes in good condition and GRP / Fiberglass after degreasing and scuffing with a grey scuff pad.

P565-668 used as an adhesion promoter can be applied over bare steel, aluminum and galvanized metals after etch priming with an Etch Primer.

When using P565-668 on plastics, refer to PDS N7.1

RECOATABILITY

When dry P565-668 can be recoated with 2K™ HS Topcoat (P420/421) and 2K™ Basecoat (P422).

Note: If P565-668 has flashed-off for more than 1 hour: Either let vehicle air dry until the next day, lightly sand P565-668 using P1000 wet and apply topcoat. Or when force drying, bake P565-668 for 40 minutes at 140° F (60°C), lightly scuff the surface when cool and apply topcoat.

If P565-668 has been left longer than 24 hours, wet sand with P600 then topcoat.

*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.

2K™ PERFORMANCE SPECIFICATIONS

Product:	P565-668 Transparent Adhesion Promoter
Category:	Specialty
VOC As Packaged:	3.92 lbs. per gal/459 gm/l
VOC RFU:	5.07-5.32 lbs. per gal/608-638 gm/l
RFU Weight Solids:	32.9%
RFU Volume Solids:	29.9%

For further information please contact:

Nexa Autocolor-USA
19699 Progress Drive
Strongsville, OH 44149

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