

**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

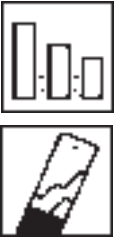





## **TRANSPARENT ADHESION PROMOTER**

### **PRODUCTS**

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

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

# PROCESS

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

# TRANSPARENT ADHESION PROMOTER

## 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

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

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