



PDS N4.12

April 2017

NEXA AUTOCOLOR® 2K® P565-3011 & P565-3015 Fast HS Wet-on-Wet Sealers

PRODUCT DESCRIPTION

NEXA AUTOCOLOR® 2K® P565-3011 and P565-3015 Fast Wet-on-Wet Sealers are 2-pack acrylic urethane sealers, designed for use under P422 2K Basecoat and P420/P421 2K HS Topcoat. Fast HS Wet-on-Wet Sealers give excellent appearance and adhesion over a wide range of substrates.

Fast HS Wet-on-Wet Sealers are a component of the Spectral Grey Undercoat System. P565-3011/-3015 and P170-5670 are used to achieve the full range of Spectral Grey colors. Using Spectral Grey Undercoats can reduce the amount of colorcoats required.

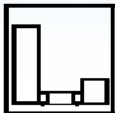





- *Fast dry = reduced process times*
- *Excellent holdout = less rework*
- *Spectral grey system = reduced color coats*

Products	
P565-3011/-3015	Fast HS Wet-On-Wet Sealers
P210-796/-798	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 Wet-On-Wet Sealers

PROCESS

MIX RATIO 	P565-3011/-3015 P210-796/-798/ P850-16xx	Wet-on-Wet Sealers Hardener Thinners	5 parts 1 part 2 part
POTLIFE 	Pot Life: Viscosity:	45 minutes at 70°F (21°C) 16 - 17 seconds DIN4 at 70°F (21°C)	
SPRAYGUN & AIR PRESSURE 	Fluid Tip: HVLP: Compliant:	1.4 - 1.8 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
APPLICATION 	Apply: Total Dry Film Build:	Apply 1 full single coat or 1 double coat 1.0 - 1.4 mils	
DRY TIMES 	Air dry to topcoat:	10 - 15 minutes at 70°F (21°C)	
SANDING 	Normally P565-3011 and P565-3015 Fast HS Wet-on-Wet Sealers do not require sanding and can be directly topcoated. If some dirt inclusion occurs, light wet sanding denibbing can be carried out after 15-20 minutes at 70°F (21°C) using P1200 or finer sandpaper.		

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GENERAL PROCESS NOTES

SUBSTRATES

P565-3011 and P565-3015 Fast HS Wet-on-Wet Sealers can be applied over:

Factory finishes - in good condition after proper cleaning and sanding with P320 - P400 or P400 - P500 wet.

E-Coat - after proper cleaning, Fast HS Wet-on-Wet Sealers P565-3011 and P565-3015 may be applied over OEM e-coat replacement parts without sanding. For optimum performance, exterior parts should be lightly abraded and cleaned prior to the application of Fast HS Wet-on-Wet Sealers.

Bare Metal - after degreasing and sanding with P180 grit and applying etch primer.

Fiberglass - after degreasing and sanding with P320 - P400 dry or P400 - P500 wet.

All Nexa Autocolor 2-pack undercoats properly sanded where necessary.

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
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>
P565-3011/-3015	RTS Fast HS Wet-on-Wet Sealers	5 parts	2 parts
P100-2020	Flexible Additive for Plastics	1 part	1 part
Note: This mixture should then be activated and thinned as normal. More detail on refinishing plastics can be found in PDS N7.1.			

RECOATABILITY

Both P565-3011 and P565-3015 can be recoated with all Nexa Autocolor 2K topcoats. If P565-3011/15 sealers have dried longer than 6 hours, lightly sand using P600 wet and then apply topcoat or force dry for 40 minutes at 140°F (60°C), lightly sand using P600 wet and then topcoat. If P565-3011 or P565-3015 has been left to sit overnight, lightly sand using P600 wet or finer than apply topcoat.

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SPECTRAL GREYS

Mix Ratio (By Volume)			Mix Ratio By Weight (Cumulative Weight in Grams)			
		Ratio	1/4 Pint	1/2 Pint	Pint	Quart
SG01 Sealer	P565-3011	5	113	225	450	900
	P210-796/-798	1	127	254	507	1013
	P850-16xx	2	151	301	601	1202
GS03 Sealer	P565-3011 (80%)	5	89	178	356	712
	P565-3015 (20%)		113	225	445	890
	P210-796/-798	1	126	251	502	1004
	P850-16xx	2	149	298	596	1192
SG05 Sealer	P565-3015	5	107	214	427	853
	P210-796/-798	1	121	242	484	967
	P850-16xx	2	145	289	578	1156
SG06 Sealer	P565-3015 (97.5%)	5	104	207	414	827
	P170-5670 (2.5%)		106	212	424	848
	P210-796/-798	1	121	241	481	961
	P850-16xx	2	144	288	575	1150
SG07 Sealer	P565-3015 (87.5%)	5	91	181	362	723
	P170-5670 (12.5%)		104	207	413	826
	P210-796/-798	1	118	235	470	940
	P850-16xx	2	142	283	565	1129

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 PPG Cleaning Solvent

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INNOVATING REPAIR SOLUTIONS

GENERAL PROCESS NOTES

RTS Combinations	P565-3011/-3015 w/ P170-5670 : P210-796/798 : P850-16xx	P565-3011/-3015 w/ P170-5670 : P100-2020 : P210-796/798 : P850-16xx	P565-3011/-3015 w/ P170-5670 : P100-2020 : P210-796/798 : P850-16xx
Volume Ratio	5 : 1 : 2	5 (5 : 1) : 1 : 2	5 (2 : 1) : 1 : 2
Applicable Use Category	Primer Sealer	Primer Sealer (Flexed)	Primer Sealer (Flexed)
VOC Regulatory (g/L) (less water, less exempts)	543-545	539-540	536-538
VOC Regulatory (lbs/Gal) (less water, less exempts)	4.53-4.55	4.50-4.51	4.47-4.48
Total Solids by vol. %	33.3-33.4	34.3-34.5	35.2-35.3
Total Solids by wt. %	51.7-53.0	51.0-52.1	50.3-51.2
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	534-536	550-553	565-566

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.

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