

**PDS N4.5**

July 2005

# ***P565-888 & P565-889***

## ***PRIMER-SURFACERS***

### **PRODUCT DESCRIPTION**

Primer-Surfacers P565-888 Grey and P565-889 White acrylic urethane primers developed for use under 2K™ Basecoat or 2K™ Single Layer colors. Both are easy to apply and sand and give good holdout and durability. They can be used in either a primer-surfacer or high build mode.

P565-888 and P565-889 are components of the Spectral Grey undercoat system. Used with P170-5670, the full range Spectral Greys undercoats can be achieved.

- High Build = fewer coats, material savings
- Good Holdout = less rework
- Fast Dry = reduced process times
- Spectral Grey System = reduced color coats
- Good Sanding = labor savings





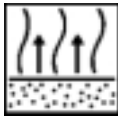


## ***PRIMER-SURFACERS***

### ***PRODUCTS***

<b><i>P565-888</i></b>	<b><i>Primer-Surfacer - Grey</i></b>
<b><i>P565-889</i></b>	<b><i>Primer-Surfacer- White</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>
<b><i>P170-5670</i></b>	<b><i>HS Tinter for Spectral Greys</i></b>

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

# PROCESS

MIX RATIO	PRIMER-SURFACER	HIGH BUILD
	 <p>P565-888/889 5 P210-796/798 1 P850-16XX 15%</p>	<p>P565-888/889 5 P210-796/798 1 P850-16XX 5%</p>
	<b>Note:</b> Only P210-796 or P210-798 MS Hardeners should be used in Primer Surfacers.	
VISCOSITY & POTLIFE	 <p><b>Viscosity:</b> 16-18 seconds Din #4 @ 70°F (21°C) <b>Pot Life:</b> 2 hour at 70°F (21°C)</p>	<p><b>Viscosity:</b> 30-35 seconds Din #4 @ 70°F (21°C) <b>Pot Life:</b> 45 Minutes at 70°F (21°C)</p>
SPRAYGUN & AIR PRESSURE	 <p><b>Siphon:</b> 1.6-1.9mm (.063"-.075") 45-55 psi at the gun <b>Gravity:</b> 1.7-1.9mm (.069"-.075") 45-55 psi at the gun <b>HVLP:</b> 1.7-2.2mm (.069"-.087") Max 10 psi cap press. 3-8 fluid pressure (pressurized cup)</p>	<p><b>Siphon:</b> 1.8-2.2mm (.070"-.086") 45-55 psi at the gun <b>Gravity:</b> 1.8-2.2mm (.071"-.086") 45-55 psi at the gun <b>HVLP:</b> 1.7-2.2mm (.069"-.087") Max 10 psi cap press. 3-8 fluid pressure (pressurized cup)</p>
	(HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)	
APPLICATION	 <p><b>Apply 2-3 coats</b> (approx. 3.0-5.0 mils) <b>Note:</b> Film build will depend on fluid tip selection.</p>	<p><b>Apply 3-4 coats</b> (approx. 7.5-10 mils) <b>Note:</b> Film build will depend on fluid tip selection.</p>
FLASH TIME	 <p><b>5 minutes</b> between coats Allow 5-minute flash-off before force dry or Infra Red.</p>	<p><b>5 minutes</b> between coats Allow 5-10 minute flash-of before force dry or Infra Red.</p>
DRY TIMES	 <p><b>Air-dry times at 70°F (21°C)</b> 2-4 hours @ 3-4 mils <b>Force Dry (metal temperature):</b> 20 minutes at 140°F (60°C) <b>Infra-Red (short wave):</b> 8-12 minutes after 5 minute flash</p>	<p><b>Air-dry times at 70°F (21°C)</b> 5-6 hours minimum @ 3-4 mils *Overnight Preferred <b>Force Dry (metal temperature):</b> 40 minutes at 140°F (60°C) <b>Infra-Red (short wave):</b> 8-12 minutes after 5 minute flash</p>
SANDING	 <p><b>Wet Sanding:</b> P400 for Single Layer Color P600 for Basecoat color <b>Machine Sanding:</b> P320 or finer for Single Layer colors P360 or finer for Basecoats</p>	<p><b>Wet Sanding:</b> P400 for Single Layer Color P600 for Basecoat color <b>Machine Sanding:</b> P320 or finer for Single Layer colors P360 or finer for Basecoats</p>

# PRIMER-SURFACERS

## SPECTRAL GREYS

MIX RATIO BY VOLUME				MIX RATIO BY WEIGHT Cumulative Weight in Grams			
	Mix Ratio			Quart	Pint	1/2 Pint	1/4 Pint
<b>SG01 Surfacer</b>	P565-889	5		1070	535	268	134
	P210-796/8	1		1201	601	301	151
	P850-16XX or	15%		1300	650	325	163
	P850-16XX	5%		1251	626	313	157
	<b>High Build</b>						
<b>SG02 Surfacer</b>	P565-889 (95)	5		1016	508	254	127
	P565-888 ( 5)			1070	535	268	134
	P210-796/8	1		1201	601	301	151
	P850-16XX or	15%		1300	650	325	163
	P850-16XX	5%		1251	626	313	157
	<b>High Build</b>						
<b>SG03 Surfacer</b>	P565-889 (80)	5		856	428	214	67
	P565-888 (20)			1070	535	268	134
	P210-796/8	1		1202	601	301	151
	P850-16XX or	15%		1300	650	325	163
	P850-16XX	5%		1251	626	313	157
	<b>High Build</b>						
<b>SG04 Surfacer</b>	P565-889 (50)	5		535	268	134	67
	P565-888 (50)			1071	536	268	134
	P210-796/8	1		1202	601	301	151
	P850-16XX or	15%		1301	651	326	163
	P850-16XX	5%		1251	626	313	157
	<b>High Build</b>						
<b>SG05 Surfacer</b>	P565-888	5		1071	536	268	134
	P210-796/8	1		1203	602	301	151
	P850-16XX or	15%		1301	651	326	163
	P850-16XX	5%		1252	626	313	156
	<b>High Build</b>						
<b>SG06 Surfacer</b>	P565-888 (99)	5		1057	529	265	133
	P170-5670 (1)			1067	534	267	134
	P210-796/8	1		1199	600	300	150
	P850-16XX or	15%		1297	649	325	163
	P850-16XX	5%		1248	624	312	156
	<b>High Build</b>						
<b>SG07 Surfacer</b>	P565-888 (88.5)	5		910	455	228	114
	P170-5670 (11.5)			1028	514	257	129
	P210-796/8	1		1159	580	290	145
	P850-16XX or	15%		1258	629	315	158
	P850-16XX	5%		1209	605	303	152
	<b>High Build</b>						

**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.

## PLASTICS USAGE

	Flexible	Very Flexible
P565-888/889 Primer-Surfacers	5	2
P100-2020 Flexible Additive for Plastics	1	1
<b>Note:</b> This mixture should then be activated and thinned as normal. More detail on refinishing plastics can be found in PDS N7.1.		

# ***PRIMER-SURFACERS***

## **SUBSTRATES**

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

Primer-Surfacers can be applied over aluminum and galvanized metals after priming with either \*Long Life Etch Primer, Chromate Free Etch Primer, or 1K Etch Primer.

\*For optimum performance over bare steel, an Nexa Autocolor Etch Primer should first be applied.

Over thermoplastic acrylic and old lacquer finishes, Primer-Surfacers should be applied to the complete panel.

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## **RECOATABILITY**

When dry and sanded, Primer-Surfacers can be directly topcoated with Nexa Autocolor 2K™ Single Layer (P420/P421), Basecoat (P422) or a 2K™ wet-on wet sealer.

\*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.

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## **GENERAL PROCESS NOTES**

### **CHOICE OF HARDENER/THINNER**

Hardener and Thinner selection will depend mainly on temperature, but also on air movement and size of repair. Refer to hardener and Thinner Selection Guide.

# PRIMER-SURFACERS

## EQUIPMENT CLEANING

Approved Cleaning Solvent

## 2K™ PERFORMANCE SPECIFICATIONS

<b>Product:</b>	P565-888/889	Primer-Surfacers
<b>Category:</b>	Primer Surfacers	
<b>VOC As Packaged:</b>	P565-888	4.21 lbs. per gal / 505gm/l
<b>VOC As Packaged:</b>	P565-889	4.40 lbs. per gal / 528gm/l
<b>VOC RFU: (Max.)</b>	P565-888/889	4.65 lbs. per gal/ 554gm/l @ 5:1:15%
<b>VOC RFU: (Max.)</b>	P565-888/889	4.44 lbs. per gal/ 529gm/l @ 5:1:5%
<b>RFU Weight Solids</b>	P565-888	62.1 % @ 5:1:15% / 65.4% @ 5:1:5%
<b>RFU Weight Solids:</b>	P565-889	62.7% @ 5:1:15% / 66.1% @ 5:1:5%
<b>RFU Volume Solids:</b>	P565-888	39.2% @ 5:1:15% / 43.0% @ 5:1:5%
<b>RFU Volume Solids:</b>	P565-889	39.8% @ 5:1:15% / 43.6% @ 5:1:5%

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