



PDS N4.1

January 2005

P565-693

PRIMER-SURFACER

PRODUCT DESCRIPTION

P565-693 is a high quality acrylic urethane primer with excellent build and color holdout. It can be used as a Primer-Surfacer or High Build Primer.

Primer-Surfacer (P565-693) is an approved product for warranty repair systems.

- High Build = fewer coats, material savings
- Superior Sanding = labor savings
- Excellent Holdout = less rework
- Fast Dry = reduced process times

**AUTOCOLOR**

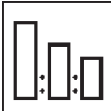

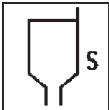





PRIMER-SURFACER

PRODUCTS

P565-693***Primer-Surfacer******P210-796******MS Hardener – Normal******P210-798******MS Hardener – Slow******P850-1692******Thinner – Low Temperature******P850-1693******Thinner – Mid Temperature******P850-1694******Thinner – High Temperature******P850-1695******Thinner – Very High Temperature****

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

MIX RATIO  	PRIMER-SURFACER	HIGH BUILD PRIMER
	P565-693 6 Parts P210-796/798 1 Part P850-16XX 2 Parts Note: P565-693 may be tinted up to 5% by weight with P425 HS tints prior to activating and thinning.	P565-693 6 Parts P210-796/798 1 Part P850-16XX 10%
VISCOSITY & POT LIFE 	Activated Viscosity: 17-19 seconds DIN#4 @70°F (21°C). Pot Life: 1-2 hours @70°F (21°C)	Activated Viscosity: 29-34 seconds Din#4 @70°F (21°C). Pot Life: 1 hour @70°F (21°C)
SPRAY GUN & AIR PRESSURE 	Siphon: 1.6-1.8mm (.063" - .070") 50-55 psi at the gun Gravity: 1.6-1.8mm (.063" - .070") 50-55 psi at the gun HVLP: 1.0-1.8mm (.039" - .070") Max 10 psi cap press 3-8 psi fluid press (pressurized cup).	Siphon: 1.8-2.2mm (.070" - .086") 50-55 psi at the gun Gravity: 1.6-2.2mm (.063" - .086") 50-55 psi at the gun HLVP: 1.0-1.8mm (.039"-.070") Max 10 psi cap press. 3-8 psi fluid press (pressurized cup).
	(HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)	
APPLICATION 	Apply 3 coats (approx. 3-4 mils) Apply first coat light.	Apply 3 coats (approx. 6-8 mils). Apply first coat light.
FLASH-OFF 	5 minutes between coats. Allow 10-15 minute flash-off before force dry or Infra-Red.	5 minutes between coats. Allow 10-15 minute flash-off before force dry or Infra-Red.
DRY TIME 	Air-dry times at 70°F (21°C): 1.5 - 2 hours Force Dry (metal temperature): 30 minutes at 140°F (60°C) Infra-Red: 20 minutes	Air-dry times at 70°F (21°C): 3 hours Force Dry (metal temperature): 30 minutes at 140°F (60°C) Infra-Red: 20 minutes
SANDING 	Wet Sanding: P400 for Single Layer colors P600 for Basecoat colors Machine Sanding: P320 for Single Layer and Basecoat colors.	Wet Sanding: P400 for Single Layer colors P600 for Basecoat colors Machine Sanding: P320 for Single Layer and Basecoat colors.

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SUBSTRATES

P565-693 can be applied directly over bare steel, factory primer, GRP / Fiberglass, existing finishes in good condition, polyester putties, after degreasing and machine sanding with P180-P220 grit dry.

P565-693 can be applied over aluminum and galvanized metals after etch priming with either Long Life Etch Primer, Chromate Free Etch Primer or 1K Etch Primer.

Note: For maximum durability over steel, an Nexa Autocolor Etch Primer should first be applied.

Over thermoplastic acrylic and old lacquer finishes, P565-693 must be applied to the complete panel.

When using P565-693 on plastics, refer to PDS N7.1.

RECOATABILITY

When dry and sanded, P565-693 can be recoated with Nexa Autocolor 2K™ Single Layer (P420/P421) or Basecoat (P422).

If desired, P565-693 can be recoated with any Nexa Autocolor Wet-on-Wet Sealer or Transparent Adhesion Promoter (P565-668).

*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.

GENERAL PROCESS NOTES

1. Hardener and Thinner selection will depend mainly on temperature, but also on air movement and size of repair.
2. When used as a High Build Primer, dry time is very dependent upon film build. Depending on film build, the product will be ready to sand in 3-5 hours.

PRIMER-SURFACER

EQUIPMENT CLEANING

Approved Cleaning Solvent

2K™ PERFORMANCE SPECIFICATIONS

Product:	P565-693 Primer-Surfacer
Category:	Primer-Surfacer
VOC As Packaged:	P565-693 4.10 lbs. per gal/491 gm/l
VOC RFU:	P565-693 – High Build Mode (Untinted) @6:1:10% = 4.42 –4.43 lbs per gal/529-531 gm/l P565-693 – Primer-Surfacer Mode (Untinted) @6:1:2 = 4.77-4.79 lbs per gal or 571-574 gm/l
RFU Weight Solids:	P565-693 49.9% @ 6:1:2 / 58.4% @ 6:1:10%
RFU Volume Solids:	P565-693 34.0% @ 6:1:2 / 39.8% @ 6:1:10%

For further information please contact:

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