



PDS N4.10C

May 2005

ROLLABLE PRIMER PROCESS

PRODUCT DESCRIPTION

Roll priming is an alternative method of applying Nexa Autocolor HS Plus Primer-Surfacers. Used on small singular or multiple repairs, maximum transfer efficiency is achieved as well as labor and material savings translating into higher shop proficiency.

HS Primer-Surfacers are components of the Spectral Grey Undercoat System. P565-5201/5205 along with P170-5267 are used to achieve the full range of Spectral Grey colors. Using Spectral Grey Undercoats can reduce the amount of colors required. Rollable HS Plus Primer-Surfacers are approved products for warranty repair systems.

- High Build = fewer coats
- Fast Dry = reduced process times
- Excellent Holdout = less rework
- Spectral Grey System = reduced color coats
- 100% Transfer efficient = Cost savings

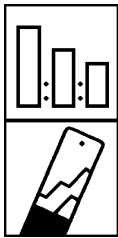
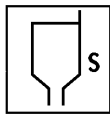

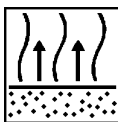
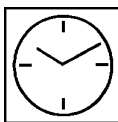

ROLLABLE PRIMER PROCESS

PRODUCTS

| | |
|-------------------------|---|
| <i>P565-5201</i> | <i>HS Plus Primer-Surfacer – White</i> |
| <i>P565-5205</i> | <i>HS Plus Primer-Surfacer – Grey</i> |
| <i>P210-5375</i> | <i>HS Plus Undercoat Hardener</i> |
| <i>8812-1066</i> | <i>Light Build Roller</i> |
| <i>8812-1067</i> | <i>Medium Build Roller</i> |
| <i>8812-1068</i> | <i>Roller Handle</i> |
| <i>8812-1069</i> | <i>Roller Pan</i> |

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

ROLLABLE PRIMER PROCESS

| | |
|---|--|
| MIX RATIO  | <div> <div>P565-5201/52055</div> <div>P210-53751</div> </div> <p>Note: Only P210-5375 hardener may be used.</p> |
| VISCOSITY & POTLIFE  | <p>Mix Ratio 5:1 Viscosity: 52 seconds Din #4 @ 70°F (21°C)</p> <p>Pot Life: 30 minutes at 70°F (21°C)</p> |
| APPLICATION  | <p>2-3 coats (approx. 2-4 mils)</p> <p>See General Process Notes on page 5 for application information.</p> |
| FLASH TIME  | <p>5 minutes between coats</p> <p>Allow 5-minute flash-of before force dry or Infra Red.</p> |
| DRY TIMES  | <p>Air-dry times at 70°F (21°C) 2-4 hours @ 2-4 mils</p> <p>Force Dry (metal temperature): 30 minutes at 140°F (60°C)</p> <p>Infra-Red (short wave): 8-12 minutes after 5 minute flash</p> |
| SANDING  | <p>Wet Sanding: P400 for Single Layer Color P600 for Basecoat color</p> <p>Machine Sanding: P320 or finer for Single Layer colors P400 or finer for Basecoats</p> |

ROLLABLE PRIMER PROCESS

SPECTRAL GREY

| MIX RATIO BY VOLUME | | | MIX RATIO BY WEIGHT Cumulative Weight In Grams | | | |
|----------------------|----------------|---|---|------|----------|----------|
| | MIX RATIO | | Quart | Pint | 1/2 Pint | 1/4 Pint |
| SG01 Surfacer | P565-5201 | 5 | 1261 | 631 | 315 | 158 |
| | P210-5375 | 1 | 1455 | 728 | 364 | 182 |
| SG02 Surfacer | P565-5201 (95) | 5 | 1200 | 600 | 300 | 150 |
| | P565-5205 (5) | | 1263 | 632 | 316 | 158 |
| | P210-5375 | 1 | 1455 | 728 | 364 | 182 |
| SG03 Surfacer | P565-5201 (80) | 5 | 1013 | 507 | 253 | 127 |
| | P565-5205 (20) | | 1263 | 632 | 316 | 158 |
| | P210-5375 | 1 | 1455 | 728 | 364 | 182 |
| SG04 Surfacer | P565-5201 (50) | 5 | 626 | 313 | 157 | 79 |
| | P565-5205 (50) | | 1258 | 629 | 315 | 158 |
| | P210-5375 | 1 | 1449 | 725 | 363 | 181 |
| SG05 Surfacer | P565-5205 | 5 | 1252 | 626 | 313 | 157 |
| | P210-5375 | 1 | 1443 | 722 | 361 | 180 |
| SG06 Surfacer | P565-5205 (96) | 5 | 1202 | 601 | 301 | 151 |
| | P170-5267 (4) | | 1238 | 619 | 310 | 155 |
| | P210-5375 | 1 | 1429 | 715 | 357 | 179 |

NOTE: These weights will produce approximately 97.5% of the volume stated to allow for mixing in the can. If an exact quart, pint and 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 |
|---|----------|---------------|
| P565-5201/5205 HS Plus Primer Surfacers | 5 | 2 |
| P100-2020 Flexible Additive for Plastics | 1 | 1 |
| Note: This mixture should then be activated and thinned as normal. | | |

ROLLABLE PRIMER PROCESS

SUBSTRATES

HS Plus 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.

HS Plus Primer-Surfacers can be applied over aluminum and galvanized metals after priming with either 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, HS Plus Primer-Surfacer should be applied to the complete panel.

RECOATABILITY

When dry and sanded, HS Plus Primer-Surfacers can be directly topcoated with Nexa Autocolor 2K HS Plus Single Layer (P471) or Basecoat (P422).

GENERAL PROCESS NOTES

After the primer has been properly mixed, pour into tray and roll the roller into the primer being sure to completely saturate the cover. After a few minutes, allowing the primer to fully absorb and before starting the application, roll off any excessive material.

Apply the first coat from the center, rolling to the edge of the repair and using a “flicking and lifting” motion, create a primer feather edge.

After the first coat has flashed off, again starting at the center of the repair roll outwards within 1 or 2 inches from the edge of the previous coat using a “flicking and lifting motion”. Repeat this application if a third coat is required. After the primer has dried, guide coat and block sand with P240 followed by P400-P600 wet by hand or P320-P400 machine dry.

If required, 0.5 part thinner P850-1775 may be added to improve flow and leveling.

ROLLABLE PRIMER PROCESS

EQUIPMENT CLEANING

Approved Cleaning Solvent

2K PERFORMANCE SPECIFICATIONS

| | |
|---------------------------|---|
| Product: | P565-5201/P565-5205 HS Plus Primer Surfacer |
| Category: | Primer Surfacer |
| VOC As Packaged: | P565-5201 1.9 lbs per gal./226 gm/l |
| VOC As Packaged: | P565-5205 2.0 lbs per gal./241 gm/l |
| VOC RTU: | <2.1 lbs per gal./250 gm/l @ 5:1 / 5:1:0.5 |
| RTU Weight Solids | P565-5201 59.9% |
| RTU Weight Solids: | P565-5205 60.1% |
| RTU Volume Solids: | P565-5201 47.3% |
| RTU Volume Solids: | P565-5205 47.4% |

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