



**PDS N4.0**

January 2005

## ***P565-510 & P565-511*** ***HS PRIMER-SURFACERS***

### **PRODUCT DESCRIPTION**

HS Primer-Surfacers **P565-510** and **P565-511** are high performance, acrylic urethane primers delivering excellent build and fast dry with superior sanding and color holdout. HS Primer-Surfacers can be used as a primer-surfacer or high build primer. HS Primer-Surfacers are approved for warranty repair systems.

HS Primer-Surfacers are components of the Spectral Grey Undercoat System. P565-510/511 and P170-5670 are used to achieve the full range of Spectral Grey colors. Using Spectral Grey Undercoats can reduce the amount of colors required.

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

## **HS PRIMER-SURFACERS**

### **PRODUCTS**

***P565-510***

***HS Primer Surfacer – Grey***

***P565-511***

***HS Primer Surfacer – White***

***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***

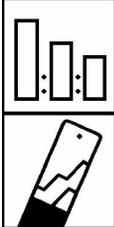
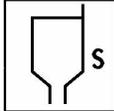
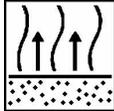
***Thinner – Very High Temperature\****

***P170-5670***

***HS Tinter for Spectral Greys***

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

# PROCESS

MIX RATIO	PRIMER-SURFACER	HIGH BUILD
	P565-510/511      5 P210-796/798      1 P850-16XX          1	P565-510/511      5 P210-796/798      1 P850-16XX          0.5
<p><b>Note:</b> Only P210-796 or P210-798 MS Hardeners should be used in HS Primer Surfacer.</p>		
<b>VISCOSITY &amp; POTLIFE</b> 	<b>Viscosity:</b> 19-23 seconds Din#4 @ 70°F (21°C)  <b>Pot Life:</b> 1 hour at 70°F (21°C)	<b>Viscosity:</b> 30-35 seconds Din#4 @ 70°F (21°C)  <b>Pot Life:</b> 30 Minutes at 70°F (21°C)
<b>SPRAYGUN &amp; AIR PRESSURE</b> 	<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 press. (pressurized cup)	<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 press. (pressurized cup)
<p>(HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)</p>		
<b>APPLICATION</b> 	<b>Apply 3 coats</b> (approx. 3.0-5.0 mils)  <b>Note:</b> Film build will depend on fluid tip selection.	<b>Apply 3 coats</b> (approx. 7.5-10 mils)  <b>Note:</b> Film build will depend on fluid tip selection.
<b>FLASH TIME</b> 	<b>5 minutes</b> between coats  Allow 5-minute flash-off before force dry or Infra Red.	<b>5 minutes</b> between coats  Allow 5-minute flash-of before force dry or Infra Red.
<b>DRY TIMES</b> 	<b>Air-dry times at 70°F (21°C)</b> 1.5-2 hours @ 3-4 mils 2.5-3 hours @ 5 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	<b>Air-dry times at 70°F (21°C)</b> 4-6 hours minimum @ 3-4 mils *Overnight Preferred <b>Force Dry (metal temperature):</b> 30 minutes at 140°F (60°C) <b>Infra-Red (short wave):</b> 8-12 minutes after 5 minute flash
<b>SANDING</b> 	<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	<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

# HS PRIMER-SURFACERS

## SPECTRAL GREYS

MIX RATIO BY VOLUME			MIX RATIO BY WEIGHT Cumulative Weight in Grams			
	Mix Ratio		Quart	Pint	½ Pint	¼ Pint
<b>SG01 Surfacer</b>	P565-511	5	1017	509	255	128
	P210-796/8	1	1147	574	287	144
	P850-16XX or	1	1255	628	314	157
	P850-16XX	0.5	1201	601	301	151
<b>SG02 Surfacer</b>	P565-511 (95)	5	966	483	242	121
	P565-510 ( 5)		1017	509	255	128
	P210-796/8	1	1147	574	287	144
	P850-16XX or	1	1255	628	314	157
<b>High Build</b>	P850-16XX	0.5	1201	601	301	151
<b>SG03 Surfacer</b>	P565-511 (80)	5	814	407	202	102
	P565-510 (20)		1017	509	255	128
	P210-796/8	1	1147	574	288	144
	P850-16XX or	1	1255	628	314	157
<b>High Build</b>	P850-16XX	0.5	1201	601	301	151
<b>SG04 Surfacer</b>	P565-511 (50)	5	508	254	127	64
	P565-510 (50)		1017	509	255	128
	P210-796/8	1	1147	574	287	144
	P850-16XX or	1	1255	628	314	157
<b>High Build</b>	P850-16XX	0.5	1201	601	301	151
<b>SG05 Surfacer</b>	P565-510	5	1017	509	255	128
	P210-796/8	1	1147	574	287	144
	P850-16XX or	1	1255	628	314	157
	P850-16XX	0.5	1201	601	301	151
<b>SG06 Surfacer</b>	P565-510 (99)	5	1004	502	251	126
	P170-5670 (1)		1014	507	254	127
	P210-796/8	1	1143	572	286	143
	P850-16XX or	1	1251	626	313	157
<b>High Build</b>	P850-16XX	0.5	1197	599	300	150
<b>SG07 Surfacer</b>	P565-510 (92)	5	912	456	228	114
	P170-5670 (8)		992	496	248	124
	P210-796/798	1	1122	561	281	141
	P850-16XX or	1	1229	615	308	154
<b>High Build</b>	P850-16XX	0.5	1176	588	294	147

**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
P565-510/511 HS Primer-Surfacers	5	2
P100-2020 Flexible Additive for Plastics	1	1

**Note:** This mixture should then be activated and thinned as normal.  
More detail on refinishing plastics can be found in PDS N7.1.

# **HS PRIMER-SURFACERS**

## **SUBSTRATES**

HS 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 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, HS Primer-Surfacer should be applied to the complete panel.

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## **RECOATABILITY**

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

\*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.

# HS PRIMER-SURFACERS

## EQUIPMENT CLEANING

Approved Cleaning Solvent

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## 2K PERFORMANCE SPECIFICATIONS

<b>Product:</b>	P565-510/511 HS Primer-Surfacers	
<b>Category:</b>	Primer Surfacer	
<b>VOC As Packaged:</b>	P565-510	3.75 lbs. per gal/450 gm/l
<b>VOC As Packaged:</b>	P565-511	3.87 lbs. per gal/464 gm/l
<b>VOC RFU:</b>	P565-510/511	4.16 lbs. per gal/499 gm/l @ 5:1:1
<b>VOC RFU:</b>	P565-510/511	4.35 lbs. per gal/522 gm/l @ 5:1:0.5
<b>RFU Weight Solids</b>	P565-510	54.1% @ 5:1:1 / 59.9% @ 5:1:0.5
<b>RFU Weight Solids:</b>	P565-511	55.6% @ 5:1:1 / 59.9% @ 5:1:0.5
<b>RFU Volume Solids:</b>	P565-510	39.4% @ 5:1:1 / 45.4% @ 5:1:0.5
<b>RFU Volume Solids:</b>	P565-511	38.9% @ 5:1:1 / 41.9% @ 5:1:0.5

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