NEXA AUTOCOLOR

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.

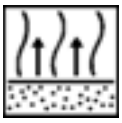
- **High Build = fewer coats, material savings**
- **Good Holdout = less rework**
- **Fast Dry = reduced process times**
- **Spectral Grey System = reduced color coats**
- **Good Sanding = labor savings**

PRIMER-SURFACERS

PRODUCTS	
P565-888	*Primer-Surfacer - Grey*
P565-889	*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

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

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
SG01 Surfacer	P565-889	5	1070	535	268	134
	P210-796/8	1	1201	601	301	151
	P850-16XX or	15%	1300	650	325	163
High Build	P850-16XX	5%	1251	626	313	157
SG02 Surfacer	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
High Build	P850-16XX	5%	1251	626	313	157
SG03 Surfacer	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
High Build	P850-16XX	5%	1251	626	313	157
SG04 Surfacer	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
High Build	P850-16XX	5%	1251	626	313	157
SG05 Surfacer	P565-888	5	1071	536	268	134
	P210-796/8	1	1203	602	301	151
	P850-16XX or	15%	1301	651	326	163
High Build	P850-16XX	5%	1252	626	313	156
SG06 Surfacer	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
High Build	P850-16XX	5%	1248	624	312	156
SG07 Surfacer	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
High Build	P850-16XX	5%	1209	605	303	152

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

Note: 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.

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.

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.

EQUIPMENT CLEANING

Approved Cleaning Solvent

2K™ PERFORMANCE SPECIFICATIONS

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

For further information please contact:

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