

PDS N4.9

March 2005

P565-357 & P565-358

GREY AND TINTABLE WET-ON-WET SEALERS

PRODUCT DESCRIPTION

Grey and Tintable Wet-on-Wet Sealers are premium quality, 2-pack acrylic urethane wet-on-wet sealers. Both are specifically designed for new panel work and for OEM paint work in good condition. **P565-357** and **P565-358** are designed to be high production one step Wet-on-Wet undercoats. Additionally, both P565-357 and P565-358 can also be utilized in high build sandable mode.

Both Wet-on-Wet Sealers are components of the Spectral Grey Undercoat System. P565-357/358 and P170-5670 are used to achieve the full range of Spectral Grey colors. Using Spectral Grey Undercoats can reduce the amount of color coats required.

- Fast Dry = reduced process time
- Excellent Holdout = less rework
- Spectral Grey System = reduced color coats

**AUTOCOLOR**

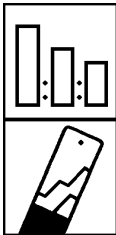
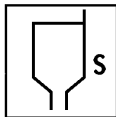


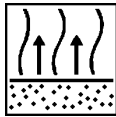
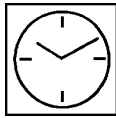

GREY AND TINTABLE WET-ON-WET SEALERS

PRODUCTS

<i>P565-357</i>	<i>Grey Wet-on-Wet Sealer</i>
<i>P565-358</i>	<i>Tintable Wet-on-Wet Sealer</i>
<i>P210-796</i>	<i>MS Hardener – Normal</i>
<i>P210-798</i>	<i>MS Hardener – Slow</i>
<i>P850-1692</i>	<i>Thinner – Low Temperature</i>
<i>P850-1693</i>	<i>Thinner – Mid Temperature</i>
<i>P850-1694</i>	<i>Thinner – High Temperature</i>
<i>P850-1695</i>	<i>Thinner – Very High Temperature*</i>
<i>P170-5670</i>	<i>HS Tinter for Spectral Greys</i>

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

MIX RATIO 	WET-ON-WET	PRIMER/SURFACER
	P565-357/8 3 P210-796/8 1 P850-16XX 1	P565-357/8 3 P210-796/8 1 P850-16XX 0.5
Note: P565-357/8 are tintable up to 10% by volume with 2K Solid Color P425 Mixing Tints prior to activating and thinning.		
VISCOSITY & POTLIFE 	13-16 seconds Din#4 @ 70°F (21°C) Pot Life: 1 hour at 70°F (21°C) from time of activation.	17-19 seconds Din#4 @ 70°F (21°C) Pot Life: 1 hour at 70°F (21°C) from time of activation.
SPRAY GUN & AIR PRESSURE 	Siphon: 1.4-1.8mm (.055" - .070") 45-50 psi at the gun Gravity: 1.3-1.6 mm (.050" - .063") 45-50 psi at the gun HVLP: 0.8-1.5mm (.031" - .059") Max 10 psi cap press. 3-8 psi fluid press (pressurized cup) (HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)	Siphon: 1.8-2.2mm (.070" - .086") 50-55 psi at the gun Gravity: 1.6-1.8mm (.063" - .070") 45-50 psi at the gun HVLP: 0.8-1.5mm (.031" - .059") Max 10 psi cap press. 3-8 psi fluid press (pressurized cup)
APPLICATION 	Apply 1 double or 2 single coats (approx. 1.2-1.8 mils).	Apply 2-3 single coats (approx. 3-4.5 mils).
FLASH TIME 	Allow 5-10 minute flash-off between single coats.	Allow 5-10 minute flash-off between coats.
DRY TIMES 	20-30 minutes @ 70°F (21°C) prior to topcoating.	Air-dry times at 70°F(21°C) Overnight Force Dry (metal temperature): 30 minutes at 140°F (60°C) Infra-Red: Not recommended
SANDING 	P565-357/8, used in the wet-on-wet mode does not require sanding, however minor dirt nibs may be removed by lightly sanding with P1000 wet after a 30-40 minute dry.	Wet Sanding: P400 Single Layer Color P600 Basecoat Color Machine Sanding: P320 for Single Layer and Basecoat Colors.

GREY AND TINTABLE WET-ON-WET SEALERS

SPECTRAL GREYS

MIX RATIO BY VOLUME			MIX RATIO BY WEIGHT Cumulative Weight in Grams			
	Mix Ratio		Quart	Pint	½ Pint	¼ Pint
SG01 Sealer	P565-358	3	825	413	207	104
	P210-796/8	1	1006	503	252	126
	P850-16XX or	1	1158	579	290	145
	P850-16XX	0.5	1082	541	271	136
Primer/Surfacer						
SG02 Sealer	P565-358 (95)	3	783	392	196	98
	P565-357 (5)		824	412	206	103
	P210-796/8	1	1005	503	252	126
	P850-16XX or	1	1157	579	290	145
	P850-16XX	0.5	1081	541	271	136
Primer/Surfacer						
SG03 Sealer	P565-358 (80)	3	657	329	165	83
	P565-357 (20)		821	411	206	103
	P210-796/8	1	1002	501	251	126
	P850-16XX or	1	1153	577	289	145
	P850-16XX	0.5	1078	539	270	135
Primer/Surfacer						
SG04 Sealer	P565-357 (50)	3	407	204	102	51
	P565-358 (50)		815	408	204	102
	P210-796/8	1	996	498	249	125
	P850-16XX or	1	1147	574	287	144
	P850-16XX	0.5	1072	536	268	134
Primer/Surfacer						
SG05 Sealer	P565-357	3	804	402	201	101
	P210-796/8	1	986	493	247	124
	P850-16XX or	1	1137	569	285	143
	P850-16XX	0.5	1062	531	266	133
Primer/Surfacer						
SG06 Sealer	P565-357 (98.5)	3	790	395	198	99
	P170-5670 (1.5)		802	401	201	101
	P210-796/8	1	971	486	243	122
	P850-16XX or	1	1122	561	281	141
	P850-16XX	0.5	1047	524	262	131
Primer/Surfacer						
SG07 Sealer	P565-357 (92)	3	726	363	182	91
	P170-5670 (8)		789	395	198	99
	P210-796/8	1	908	454	227	114
	P850-16XX or	1	1059	530	265	133
	P850-16XX	0.5	983	492	246	123
Primer/ Surfacer						

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
P565-357/358 Wet-on-Wet Sealers	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.		

GREY AND TINTABLE WET-ON-WET SEALERS

SUBSTRATES

P565-357 E-Coat / Factory Primer - after proper cleaning and degreasing with Spirit Wipe. For optimum performance, sand the factory primer with P220-P320 dry or P320-P400 wet.

P565-358 E-Coat/Factory Primer – After proper cleaning, **sanding** and degreasing with Spirit Wipe.

Note: E-Coat/Factory Primer must be sanded when applying P565-358.

Bare Metal - after degreasing and sanding with P180 Grit and applying either Long Life Etch or Chromate Free Etch.

Fiberglass – after degreasing and sanding with P220-P320 dry or P320-P400 Wet.

Polyester Fillers – after a final sand with P220 dry.

All **Nexa Autocolor 2-pack undercoats** properly sanded where necessary.

When using P565-357/58 on plastics, refer to PDS N7.1

RECOATABILITY

P565-357 and P565-358 can be recoated with all Nexa Autocolor 2K topcoats.

If P565-357 or P565-358 in the wet mode have flashed for more than 1.5 hours, allow vehicle to sit until the next day, lightly sand using P1000 wet, then apply topcoat.

or

Force dry for 40 minutes @ 140°F (60°C). Allow surface to cool, lightly sand and topcoat.

*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.

GREY AND TINTABLE WET-ON-WET SEALERS

EQUIPMENT CLEANING

Approved Cleaning Solvent

2K PERFORMANCE SPECIFICATIONS

Product:	P565-357 Wet-on-Wet Sealer P565-358 Wet-on-Wet Sealer	
Category:	Primer Sealer @ 3:1:1 Primer Surfacer @ 3:1:0.5	
VOC As Packaged:	P565-357	3.31 lbs. per gal/396 gm/l
	P565-358	3.31 lbs. per gal/396 gm/l
VOC RFU:	P565-357/8	@3:1:1=4.41-4.45 lbs. per gal/528-533 gm/l
	P565-357/8	@3:1:0.5=4.4 lbs. per gal max/528 gm/l
RFU Weight Solids:	P565-357	52.6% @ 3:1:1 / 58.4% @ 3:1:0.5
RFU Weight Solids:	P565-358	54.1% @ 3:1:1 / 60.1% @ 3:1:0.5
RFU Volume Solids:	P565-357	41.1% @ 3:1:1 / 45.6% @ 3:1:0.5
RFU Volume Solids:	P565-358	42.9% @ 3:1:1 / 47.7% @ 3:1:0.5

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