



# PDS N4.1.5

September 2017

## NEXA AUTOCOLOR® P565-2910 Primer-Surfacer

### PRODUCT DESCRIPTION

NEXA AUTOCOLOR® P565-2910 Primer-Surfacer is an acrylic urethane primer developed for use under *Nexa Autocolor 2K®* Basecoat or Single Layer Color. P565-2910 Primer-Surfacer gives easy application and sanding with good holdout and durability. It can be used in either a primer-surfacer or high build mode.

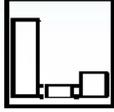
- *High build = fewer coats, materials savings*
- *Good sanding = labor savings*
- *Good holdout = less rework*

| Products                          |                 |
|-----------------------------------|-----------------|
| P565-2910                         | Primer-Surfacer |
| P210-5260/-5275/-5290             | Hardeners       |
| P850-1692/-1693/-1694/-1695/-1696 | 2K Thinners     |

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

# Primer-Surfacers

## PROCESS

| MIX RATIO  | Primer-Surfacers   | High Build Primer   |
|--|--|---|
|   | <b>P565-2910</b> Primer-Surfacers 6 parts<br><b>P210-85xx</b> Hardener 1 part<br><b>P850-16xx</b> Thinner 2 parts  | <b>P565-2910</b> Primer-Surfacers 6 parts<br><b>P210-52xx</b> Hardener 1 part<br><b>P850-16xx</b> Thinner 10-15%  |
| <b>POTLIFE</b><br>  | <b>Pot Life:</b><br>2-3 hours at 70°F (21°C)<br><b>Viscosity:</b><br>17-21 second DIN 4 at 70°F (21°C)   | <b>Pot Life:</b><br>1-2 hours at 70°F (21°C)<br><b>Viscosity:</b><br>31-34 second DIN 4 at 70°F (21°C)  |
| Note: Higher temperature will shorten pot life   |  |   |
| <b>SPRAYGUN &amp; AIR PRESSURE</b><br>  | <b>Gun Setup:</b><br>1.1-2.2 mm<br><b>HVLP:</b><br>Maximum of 10 psi cap pressure<br><b>Compliant:</b><br>29-40 psi at the gun   | <b>Gun Setup:</b><br>1.1-2.2 mm<br><b>HVLP:</b><br>Maximum of 10 psi cap pressure<br><b>Compliant:</b><br>29-40 psi at the gun  |
| For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures   |  |   |
| <b>APPLICATION</b><br>  | <b>Apply:</b><br>2-3 coats<br><br><b>Total Dry Film Build:</b><br>4.0-4.5 mils   | <b>Apply:</b><br>2-3 single coats<br><br><b>Total Dry Film Build:</b><br>7.5-10.0 mils  |
| Note: Film build will depend on fluid tip selection  |  |   |
| <b>FLASH TIME</b><br>   | <b>Between Coats:</b><br>5-10 minutes at 70°F (21°C)   | <b>Between Coats:</b><br>5-10 minutes at 70°F (21°C)  |
| <b>DRY TIMES</b><br><br> | <b>Air Dry to Sand:</b><br>2-3 hours at 70°F (21°C)<br><b>Force Dry to Sand:</b><br>5-10 minutes flash then<br>15-20 minutes bake at<br>140°F (60°C)<br><br><b>Infrared:</b><br>Medium Wave<br>10-15 minutes<br>Short Wave<br>5-10 minutes | <b>Air Dry to Sand:</b><br>2-3 hours at 70°F (21°C)<br><b>Force Dry to Sand:</b><br>5-10 minutes flash then<br>30-40 minutes bake at<br>140°F (60°C)<br><br><b>Infrared:</b><br>Not recommended |

All force dry times are quoted for surface temperature. Additional time must be allowed during force dry to allow surface to reach recommended temperature.

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# Primer-Surfacer

## GENERAL PROCESS NOTES

### SANDING



#### Wet Sanding:

P400 for Single Layer

P600 for Basecoat

#### Machine Sanding:

P320 for Single Layer and Basecoat

### SUBSTRATES

P565-2910 Primer-Surfacer can be applied directly over factory primer, GRP / Fiberglass, existing finishes in good condition and polyester putties after degreasing and machine sanding with P180-P220 grit dry.

After degreasing and sanding, bare steel, aluminum and galvanized must be primed with etch primer.

Over thermoplastic acrylic or old lacquer finishes, P565-2910 Primer-Surfacer must be applied to the complete panel.

When using over plastic substrates, refer to "Plastics Painting Process" PDS N7.1.

### PROCESS NOTES

For optimum application, these paint systems should not be applied cold. Best results will be obtained by allowing adequate time for paint to reach 70°F (21°C).

### EQUIPMENT CLEANING

Approved PPG Cleaning Solvent

# Primer-Surfacer

| <b>RTS Combinations</b>                                      | P565-2910 : P210-52xx :<br>P850-169x | P565-2910 : P210-52xx :<br>P850-169x |
|--|--------------------------------------|--------------------------------------|
| Volume Ratio   | 6 : 1 : 2                            | 6 : 1 + 10-15%                       |
| Applicable Use Category                                      | Primer Surfacer                      | Primer Surfacer                      |
| VOC Regulatory (g/L) (less water, less exempts)              | 561-564                              | 531-532                              |
| VOC Regulatory (lbs./Gal) (less water, less exempts)         | 4.68-4.71                            | 4.43-4.44                            |
| Solids vol.%   | 35.1-35.3                            | 39.2-39.5                            |
| Solids wt.%  | 57.8-57.9                            | 61.9-62.0                            |
| Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency | 563-566                              | 629-634                              |

## VOC COMPLIANCE

To ensure accurate mixing, best performance & VOC compliance:

- Do not add extra hardener, thinner or change the recommended mixing ratio.
- Do not use hardeners or thinners that are not specified in this process summary.

## HEALTH AND SAFETY

See Safety Data Sheet and Labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDSs of all the components since the mixture will have the hazards of all of its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

## EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statement listed on label. Statement and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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