



PDS N4.10

December 2003

P565-2960

WET-ON-WET SEALER

PRODUCT DESCRIPTION

P565-2960 Wet-on-Wet Sealer is a quality acrylic urethane sealer developed for use under 2K™ Basecoat or Single Layer color. Wet-on-Wet sealer gives easy application and good holdout.

- **Fast Dry = reduced process times**

- **Good Holdout = less rework**

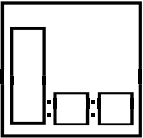
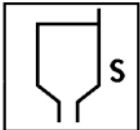




WET-ON-WET SEALER

PRODUCTS

<i>P565-2960</i>	<i>Wet-on-Wet Sealer</i>
<i>P210-5260</i>	<i>Low Temperature Hardener</i>
<i>P210-5275</i>	<i>Mid Temperature Hardener</i>
<i>P210-5290</i>	<i>High Temperature Hardener</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>

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

MIX RATIO 	<div> P565-2960 3 part P210-52XX 1 part P850-16XX 1 part </div>
VISCOSITY & POTLIFE 	<p>Viscosity: 13-16 seconds DIN 4</p> <p>Pot Life: 1 hour at 70°F (21°C)</p> <p>Note: Higher temperatures will shorten pot life</p>
SPRAYGUN & AIR PRESSURE 	<div> <p>Siphon: 1.4-1.6mm (.055"-.063") 45-50 psi at the gun</p> <p>Gravity: 1.3-1.6mm (.050"-.063") 45-50 psi at the gun</p> <p>*HVLP: 0.8-1.5mm (.031"-.059") Max 10 psi cap pressure</p> </div> <p>(*HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)</p>
APPLICATION 	<p>Apply 1 double or 2 single coats Allow 5-10 minutes flash time between coats</p> <p>Note: Film build will depend on fluid tip selection.</p>
DRY TIMES 	<p>Air-dry at 70°F (21°C) before topcoating</p> <p>20-30 minutes</p>
SANDING 	<p>Sanding is not normally required. Prior to topcoating if needed, de-nibbing may be done after 30 -40 minutes.</p> <p>Note: If not topcoated within 1.5 hours, allow to dry overnight, lightly sand and then apply topcoat.</p>

WET-ON-WET SEALER

SUBSTRATES

Wet-on-Wet Sealer can be applied over factory primer, GRP/Fiberglass, existing finishes in good condition, 2 Pack Primer-Surfacer or polyester putties after degreasing and machine sanding with P220-P320 grit dry. Steel, galvanized steel, aluminum must be primed with either Long Life Etch Primer, Chromate Free Etch Primer or 1K etch prior to application.

Over thermoplastic acrylic or old lacquer finishes, P565-2960 must be applied to the complete panel.

For plastics, refer to N7.1 Plastic Painting Process

EQUIPMENT CLEANING

Approved cleaning solvent

PERFORMANCE SPECIFICATIONS

Product:	Wet-on-Wet sealer
Category:	Primer-Sealer
VOC As Packaged:	3.33 lbs per gal. / 396 gm/l
VOC RFU:	4.44 - 4.48 lbs per gal. / 528 - 533 gm/l
RFU Weight Solids	52.6%
RFU Volume Solids:	41.1%
Theoretical Sq. ft. coverage:	640 sq. ft. @ 1 mil dry film per U.S. gal.

For further information please contact:

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