



## PDS N4.12C

May 2005

### **P565-3111 & P565-3115**

## ***HS PLUS WET-ON-WET SEALERS***

### **PRODUCT DESCRIPTION**

**P565-3111** and **P565-3115** are 2-pack acrylic urethane sealers, designed for use under 2K Basecoat (P422) and 2K HS Plus Topcoat (P471). HS Plus Sealers give excellent appearance and adhesion over a wide range of substrates.

HS Plus Primer-Sealers are a component of the Spectral Grey Undercoat System. P565-3111/3115 and HS Plus Spectral Grey SG06 are used to achieve the full range of Spectral Grey colors. Using Spectral Grey Undercoats can reduce the amount of colorcoats required.

- Fast dry = reduced process time
- Spectral Grey System = reduced color coats
- Excellent holdout = less rework
- Meets VOC regulations

## ***HS PLUS WET-ON-WET SEALERS***

### **PRODUCTS**

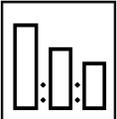
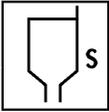
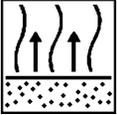
<b><i>P565-3111</i></b>	<b><i>HS Plus Wet-on-Wet Sealer - White</i></b>
<b><i>P565-3115</i></b>	<b><i>HS Plus Wet-on-Wet Sealer - Grey</i></b>
<b><i>P210-5375</i></b>	<b><i>HS Plus Undercoat Hardener – Mid-Temp</i></b>
<b><i>P850-1775</i></b>	<b><i>HS Plus Mid-Temp Reducer</i></b>
<b><i>P170-5267</i></b>	<b><i>HS Plus Tinter for Spectral Grey 6</i></b>

### **VOC COMPLIANCE**

When used according to the recommendation set out in this datasheet, products will comply with 2.8lb/gal VOC limits for wet-on-wet sealers.

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

# PROCESS

<p><b>MIX RATIO</b></p>   <p style="text-align: right;">1B</p>	<p style="text-align: right;">P565-3111/3115                    5  P210-5375                                1  P850-1775                                2</p>
<p><b>VISCOSITY &amp; POTLIFE</b></p> 	<p style="text-align: right;">Activated viscosity:    14 -16 seconds    Din#4</p> <p style="text-align: right;">Pot Life:                                45 minutes at 70°F (21°C)</p>
<p><b>SPRAYGUN &amp; AIR PRESSURE</b></p> 	<p style="text-align: center;">1.4 -1.6mm  Max. 10 psi cap press</p> <p style="text-align: center;">Refer to gun manufacturers recommended air pressure.</p>
<p><b>APPLICATION</b></p> 	<p>Apply 1 full single coat or 1 double coat to give a film thickness of 1.0-1.4 mils.</p>
<p><b>DRY TIME</b></p> 	<p>10-15 minutes at 70° F (21° C) before topcoating at a film build of 1.0-1.4 mils.</p>
<p><b>WET SANDING</b></p> 	<p>Normally P565-3111 &amp; P565-3115 Wet-on-Wet sealers do not require sanding and can be directly topcoated. If some dirt inclusion occurs, light wet sanding/denibbing can be carried out after 15-20 minutes at 70° F (21° C) using P1200 or finer sandpaper.</p>
<p><b>TOPCOAT</b></p> 	<p>P565-3111/3115 can be directly topcoated with 2K HS Plus (P471) and 2K Basecoat (P422) at the specified time.</p>

# HS PLUS WET-ON-WET SEALERS

## TINTING – SPECTRAL GREYS

MIX RATIO BY VOLUME			MIX RATIO BY WEIGHT Cumulative Weight In Grams			
	MIX RATIO		Quart	Pint	1/2 Pint	1/4 Pint
<b>SG01 Sealer</b>	P565-3111	5	962	481	240	120
	P210-5375	1	1105	553	276	138
	P850-1775	2	1404	702	351	176
<b>SG02 Sealer</b>	P565-3111 (95)	5	915	456	229	114
	P565-3115 (5)		962	481	240	120
	P210-5375	1	1105	553	276	138
	P850-1775	2	1404	702	351	176
<b>SG03 Sealer</b>	P565-3111 (80)	5	774	387	194	97
	P565-3115 (20)		962	481	241	120
	P210-5375	1	1105	553	276	138
	P850-1775	2	1404	702	351	176
<b>SG04 Sealer</b>	P565-3111 (50)	5	474	237	119	59
	P565-3115 (50)		948	474	237	118
	P210-5375	1	1093	546	273	137
	P850-1775	2	1379	696	348	174
<b>SG05 Sealer</b>	P565-3115	5	937	469	234	117
	P210-5375	1	1080	540	270	135
	P850-1775	2	1379	690	345	172
<b>SG06 Sealer</b>	P565-3115 (94)	5	881	441	220	110
	P170-5267 (6)		922	461	231	115
	P210-5375	1	1065	533	266	133
	P850-1775	2	1364	682	341	171

**NOTE:** These weights will produce approximately 97.5% of the volume stated to allow for mixing in the can. If an exact quart, pint and half-pint etc. is required multiply all weights by 1.025. All weights have been rounded off to whole numbers.

# HS PLUS WET-ON-WET SEALERS

## SUBSTRATES

HS Plus Wet-on-Wet Sealers can be applied over :

**Factory finishes-** In good condition after proper cleaning, degreasing and sanding with P320-400 or P400-500 wet.

**E-Coat-** After proper cleaning and degreasing, HS Plus Wet-on-Wet Sealers P565-3111 and P565-3115 may be applied over OEM e-coat replacement parts without sanding. For optimum performance, exterior parts should be cleaned and lightly abraded prior to the application of HS Plus Wet-on-Wet Sealers.

**Bare metal-** after degreasing and sanding with P180 grit and applying Chromate Free Etch or 1K aerosol Etch Primer.

**Plastics-** When using HS Plus Wet-on-Wet Sealers on plastics, they must be flexed at a 5:1 ratio with P100-2020 flexible additive prior to activating and thinning.

**Fiberglass-** after degreasing and sanding with P320-400 dry or P400-500 wet.

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

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## RECOATABILITY

Both P565-3111 and P565-3115 can be recoated with all Nexa Autocolor 2K topcoats.

If P565-3511/15 sealers have dried longer than 6 hours, lightly sand using P600 wet and then apply topcoat or force dry for 40 minutes @ 140°F (60°C), lightly sand using P600 wet and then topcoat.

If P565-3111 or P565-3115 has been left to sit overnight, lightly sand using P600 wet or finer then apply topcoat.

# HS PLUS WET-ON-WET SEALERS

## VOC COMPLIANCE:

### To ensure accurate mixing, best performance & VOC compliance:

- Use the correct mixing ratio for the regulated areas.
- Use an appropriate mixing stick.
- Do not add extra hardener, thinner or change the recommended mixing ratio.
- Do not use Hardeners & Thinner not specified in this process summary.
- Do not tint with Topcoat colors.
- Achieve SG6 with only the correct Tinter at the ratio specified in this process summary.

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## EQUIPMENT CLEANING

Approved Cleaning Solvent

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## 2K PERFORMANCE SPECIFICATIONS

<b>Product:</b>	P565-3111/P565-3115 HS Plus Primer Sealer	
<b>Category:</b>	Primer Sealer	
<b>VOC As Packaged:</b>	P565-3111	2.40 lbs per gal./286 gm/l
<b>VOC As Packaged:</b>	P565-3115	2.43 lbs per gal./292 gm/l
<b>VOC RTU:</b>	P565-3111	2.47 lbs per gal./293gm/l
<b>VOC RTU:</b>	P565-3115	2.55 lbs per gal./303gm/l
<b>Weight Solids RTU:</b>	P565-3111	46.0%
<b>Weight Solids RTU:</b>	P565-3115	46.3%
<b>Volume Solids RTU:</b>	P565-3111	34.4%
<b>Volume Solids RTU:</b>	P565-3115	34.9%

For further information please contact:

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