

PDS N4.12C

May 2005

A background image showing a person in a white protective suit and mask, using a spray gun to apply a product to a car's headlight area.

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

**AUTOCOLOR**

HS PLUS WET-ON-WET SEALERS

PRODUCTS

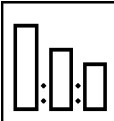

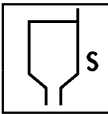


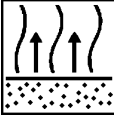


<i>P565-3111</i>	<i>HS Plus Wet-on-Wet Sealer - White</i>
<i>P565-3115</i>	<i>HS Plus Wet-on-Wet Sealer - Grey</i>
<i>P210-5375</i>	<i>HS Plus Undercoat Hardener – Mid-Temp</i>
<i>P850-1775</i>	<i>HS Plus Mid-Temp Reducer</i>
<i>P170-5267</i>	<i>HS Plus Tinter for Spectral Grey 6</i>

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

MIX RATIO   1B	<div> P565-3111/31155 P210-53751 P850-17752 </div>
VISCOSITY & POTLIFE 	<div> Activated viscosity:14 -16 seconds Din#4 Pot Life:45 minutes at 70°F (21°C) </div>
SPRAYGUN & AIR PRESSURE 	<div> 1.4 -1.6mm Max. 10 psi cap press Refer to gun manufacturers recommended air pressure. </div>
APPLICATION 	Apply 1 full single coat or 1 double coat to give a film thickness of 1.0-1.4 mils.
DRY TIME 	10-15 minutes at 70° F (21° C) before topcoating at a film build of 1.0-1.4 mils.
WET SANDING 	Normally P565-3111 & 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.
TOPCOAT 	P565-3111/3115 can be directly topcoated with 2K HS Plus (P471) and 2K Basecoat (P422) at the specified time.

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
SG01 Sealer	P565-3111 5	962	481	240	120
	P210-5375 1	1105	553	276	138
	P850-1775 2	1404	702	351	176
SG02 Sealer	P565-3111 (95) 5	915	456	229	114
	P565-3115 (5) 5	962	481	240	120
	P210-5375 1	1105	553	276	138
	P850-1775 2	1404	702	351	176
SG03 Sealer	P565-3111 (80) 5	774	387	194	97
	P565-3115 (20) 5	962	481	241	120
	P210-5375 1	1105	553	276	138
	P850-1775 2	1404	702	351	176
SG04 Sealer	P565-3111 (50) 5	474	237	119	59
	P565-3115 (50) 5	948	474	237	118
	P210-5375 1	1093	546	273	137
	P850-1775 2	1379	696	348	174
SG05 Sealer	P565-3115 5	937	469	234	117
	P210-5375 1	1080	540	270	135
	P850-1775 2	1379	690	345	172
SG06 Sealer	P565-3115 (94) 5	881	441	220	110
	P170-5267 (6) 5	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.

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 overnite, 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.

EQUIPMENT CLEANING

Approved Cleaning Solvent

2K PERFORMANCE SPECIFICATIONS

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

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