



# PDS N4.1.2C NR

## October 2018

### AQUABASE<sup>®</sup> PLUS P565-5401, P565-5405, P565-5407 HS Plus Primer-Surfacers / National Rule

*For National Rule Markets*

#### PRODUCT DESCRIPTION

AQUABASE<sup>®</sup> Plus HS Plus Primer-Surfacers are 2-pack acrylic urethane sandable primers designed for use under the *Aquabase Plus Waterborne Basecoat*. They are easy to apply and sand and give excellent final appearance and durability.










HS Plus Primer-Surfacers are a component of the Spectral Grey Undercoat System. HS Plus Primer-Surfacers; available in white, grey and black, are used to achieve the full range of Spectral Grey shades. HS Plus Primer-Surfacers may also be accelerated for faster air dry process as needed.

- *High Build = Fewer Coats / Materials savings*
- *Excellent Holdout = Less rework*
- *Spectral Grey System = Reduced color costs*
- *Fast Dry = Reduced Process Time*

Products	
P565-5401 (White)/-5405 (Grey) /-5407 (Black)	Fast HS Primer Surfacers
P210-5475/-5476	Hardeners
P850-1692/-1693/-1694/-1695	Thinners
P100-2020	Flexible Additive
SL814	Universal Flexibilizer
SL93LV	Accelerator

**THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY**

# HS Plus Primer-Surfacers

PROCESS					
<div>MIX RATIO</div> <div></div> <div></div>	<div>Spray Filler</div> <div>P565-540x: 4 parts P210-5475/-5476: 1 part</div>	<div>Primer-Surfacer</div> <div>P565-540x: 4 parts P210-5475/-5476: 1 part P850-169x: 1 part</div>	<div>Accelerated Primer-Surfacer</div> <div>P565-540x: 4 parts P210-5475/-5476: 1 part P850-1692/-1693: 1 part SL93LV: +10%</div>		
	Accelerated Primer-Surfacer Mix Ratio by Cumulative Weight in Parts (Grams) 4:1:1+10%				
	Volume	4 oz. / ¼ pint	8 oz. / ½ pint	16 oz. / 1 pint	32 oz. / 1 quart
	P565-540x Primer-Surfacer	131 (116)	263 (233)	525 (466)	1050 (931)
	P210-5475/-5476 Hardener	156 (139)	314 (278)	627 (556)	1253 (1111)
	P850-1692/-1693 Reducer	173 (154)	347 (307)	693 (615)	1386 (1229)
	SL93LV Accelerator	189 (168)	379 (336)	748 (673)	1516 (1344)
	Note: Use fast reducer only. Additional mix volumes may be found on PAINTMANAGER®				
	<div>POTLIFE</div> <div></div>	<div>Sprayable Pot Life:</div> <div>Spray Filler: 30 minutes at 70°F (21°C) Primer-Surfacer: 1 hour at 70°F (21°C) Accelerated Primer-Surfacer: 30 minutes at 70°F (21°C)</div>			
	<div>SPRAYGUN &amp; AIR PRESSURE</div> <div></div>	<div>Fluid Tip:</div> <div>Spray Filler: 1.7 - 2.0 mm Primer-Surfacer: 1.6 - 1.8 mm Accelerated Primer-Surfacer: 1.6 - 1.8 mm</div> <div>HVLP: 10 PSI cap pressure Compliant: 29 - 40 PSI at the gun*</div> <div>Note: Refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.</div>			
<div>APPLICATION</div> <div></div>	<div>Apply:</div> <div>Spray Filler: Maximum of 4 coats Primer-Surfacer: 2 - 3 full coats to give a dry film thickness of 4 - 6 mils</div>				
<div>FLASH TIME</div> <div></div>	<div>Between coats:</div> <div>5 - 10 minutes</div>				
<div>DRY TIMES</div> <div></div> <div></div> <div></div>	<div>Air Dry:</div> <div>Spray Filler:* 6 hours or overnight at 70°F (21°C) at 4 - 6 mils Primer-Surfacer: 1.5 hour at 70°F (21°C) at 2 - 3 mils Accelerated Primer-Surfacer:* 20 - 30 minutes at 70°F (21°C) at 2 - 3 mils</div> <div>Force Dry:*</div> <div>Primer-Surfacer: 30 minutes at 140°F (60°C)</div> <div>Infrared:*</div> <div>Primer-Surfacer: 8 - 12 minutes Short Wave</div> <div>* Do not force or infra-red dry when using in the accelerated or spray filler mode.</div>				

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

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

# HS Plus Primer-Surfacers

## GENERAL PROCESS NOTES

### SUBSTRATES

P565-5401, P565-5405 and P565-5407 can be applied directly over factory primer, GRP / Fiberglass, existing finishes in good condition after degreasing and sanding with P180-P220 grit dry.

P565-5401, P565-5405 and P565-5407 can be applied over bare steel, aluminum, and galvanized metals after etch priming with ONECHOICE® SX1071 Etch Primer or preparation with SX Metal Treatments.

Over thermoplastic acrylic and old lacquer finishes, P565-540x must be applied to the complete panel.

### PROCESS NOTES

#### CHOICE OF HARDENER AND THINNER

Hardener and thinner selection will depend mainly on temperature, but also on air movement and size of repair.

P210-5475	HS Plus Surfacer / Sealer Hardener
P210-5476	Undercoat Hardener - Slow
P850-1692	Thinner - Low Temperature
P850-1693	Thinner - Mid Temperature
P850-1694	Thinner - High Temperature
P850-1695	Thinner - Very High Temperature

All drying times in this summary will depend on the film thickness applied and temperature.

Infra-red drying times given require the short wave infra-red lamp to be positioned 28 - 40 inches away from the panel. Allow P565-540x to flash off for 5 minutes before drying with the infra-red lamp.

Drying times will depend on the type of infra-red lamp used. Do not infra-red dry when used in the Spray Filler or Accelerated mode.

For optimum performance, paint systems should not be applied cold. For best results, allow adequate time for paint to reach 70°F (21°C).

### PLASTICS USAGE

P565-540x	HS Plus Primer-Surfacer	5 parts
P100-2020/SL814	Flexible Additive	1 part

This mixture should then be activated and thinned as normal  
More detail on refinishing plastics can be found in PDS N7.1

### RECOATABILITY

P565-5401, P565-5405 and P565-5407 must be sanded before top coating with *Aquabase Plus Basecoat*.

Wet Sanding: P600 / P800

Machine Sanding: P360 / P400

After sanding, if P565-540x is left for longer than 3 days, it must be re-sanded prior to further application of additional primer, sealer or topcoat.

### THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

# HS Plus Primer-Surfacers

## SPECTRAL GREYS

### Aquabase Plus Spectral Grey Mixing Chart

### P565-540x HS Plus Primer-Surfacers

This chart can be used to mix P565-540x HS Plus Primer-Surfacers. The SG01-SG07 ratios will help to achieve better hiding when used as a guide for mixing the Spectral Grey Primer-Surfacers

MIX RATIO BY VOLUME			MIX RATIO BY WEIGHT Cumulative Weight in Grams						
Ratio			¼ Pint	½ Pint	1 Pint	1 Quart	2 Quarts	3 Quarts	1 Gallon
SG01	P565-5401	4	129	258	515	1030	2060	3090	4119
	P210-5475/6	1	151	301	603	1207	2414	3622	4829
	P850-169x	1	167	333	666	1332	2664	3995	5327
SG03	P565-5401	3	96	192	384	768	1537	2306	3074
	P565-5405	1	129	258	516	1031	2062	3093	4124
	P210-5475/6	1	151	302	604	1208	2417	3626	4834
	P850-169x	1	167	333	666	1333	2666	3999	5332
SG05	P565-5405	4	129	258	517	1034	2068	3102	4137
	P210-5475/6	1	152	303	606	1212	2423	3635	4847
	P850-169x	1	167	334	668	1336	2672	4008	5345
SG06	P565-5405	Mix By Weight Only	64	128	255	510	1019	2038	2717
	P170-5407		128	255	510	1021	2041	3062	4082
	P210-5475/6		150	300	599	1198	2396	3594	4792
	P850-169x		165	330	661	1322	2645	3968	5290
SG07	P170-5407	4	124	248	497	995	1989	2984	3978
	P210-5475/6	1	147	293	586	1172	2344	3516	4688
	P850-169x	1	161	322	644	1287	2593	3890	5186

**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.

## EQUIPMENT CLEANING

Approved NEXA AUTOCOLOR® or PPG Cleaning Solvent

## VOC COMPLIANCE

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

- When mixed as directed these products will achieve <2.1lbs, 250 g/L VOC
- Use the correct mixing ratio for the regulated areas.
- 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.
- Do not tint except where as referenced in the Spectral Grey chart.

**THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY**



# HS Plus Primer-Surfacers

## GENERAL PROCESS NOTES

RTS Combinations	Spray Filler P565-540x : P210-5475/6	Primer-Surfacer P565-540x : P210-5475/6 : P850-169x	Accelerated Primer-Surfacer P565-540x : P210-5475/6 : P850-169x + SL93LV	Flexible Primer-Surfacer (Premix P565-540x : P100-2020/ SL814 at 5:1 ratio) P565-540x : P210-5475/6 : P850-169x
Volume Ratio	4 : 1	4 : 1 : 1	4 : 1 : 1 + 10%	4 : 1 : 1
Applicable Use Category	Primer	Primer	Primer	Primer
VOC Actual (g/L)	137-143	250-258	228-234	277-306
VOC Actual (lbs./Gal)	1.14-1.19	2.09-2.15	1.90-1.95	2.31-2.55
VOC Regulatory (g/L) (less water, less exempts)	241-252	391-403	389-403	404-448
VOC Regulatory (lbs./Gal) (less water, less exempts)	2.01-2.10	3.26-3.36	3.25-3.36	3.57-3.74
Solids vol. %	40.1-40.8	33.4-34.0	30.5-31.1	32.3-35.5
Solids wt. %	51.8-54.1	46.7-48.9	42.7-44.9	44.6-48.9
Sq. Ft. Coverage /US Gal 1 mil at 100% transfer efficiency	830-863	749-784	685-720	715-784

### 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 warranted 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.

For further information please contact:



Nexa Autocolor - USA  
19699 Progress Drive  
Strongsville, OH 44149

Nexa Autocolor - Canada  
2301 Royal Windsor Drive Unit #6  
Mississauga, Ontario L5J 1K5