



PDS N4.1.2C

April 2017

NEXA AUTOCOLOR® 2K® P565-5005 HS Express Primer-Surfacer

PRODUCT DESCRIPTION

NEXA AUTOCOLOR® 2K® P565-5005 HS Express Primer-Surfacer is a highly productive primer-surfacer designed for use under 2K Basecoat (P422– line), 2K HS Topcoat (P420/P421– line) and AQUABASE® Plus Waterborne Basecoat. This surfacer provides exceptional film build and sandability while delivering premium adhesion, surface leveling and gloss holdout.









- *Fast dry = reduced process time*
- *High build = fewer coats, materials savings*
- *Superior sanding = labor savings*
- *Excellent holdout = less rework*

Products	
P565-5005	HS Express Primer Surfacer
P210-5585/-5595	HS Undercoat Hardeners
P850-1692/-1693/-1694/-1695	2K Thinners
P100-2020	Flexible Additive

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

HS Express Primer-Surfacer

PROCESS

<div>MIX RATIO</div> <div></div>	<div>Primer Surfacer</div> <div>P565-5005 Primer Surfacer 4 parts</div> <div>P210-55x5 Hardener 1 part</div> <div>P850-16xx Thinner 1 part</div>	<div>Rollable Primer Surfacer</div> <div>P565-5005 Primer Surfacer 4 parts</div> <div>P210-55x5 Hardener 1 part</div>
<div>POTLIFE</div> <div></div>	Standard with P210-5585: 4 : 1 : 1 25 - 30 minutes at 70°F (21°C) High Temp with P210-5595: 4 : 1 : 1 15 - 20 minutes at 90°F (32°C) Rollable Primer Surfacer: 4 : 1 20 minutes at 70°F (21°C) Note: Pot Life may be considerably shorter when temperatures exceed 70°F (21°C). Clean equipment immediately after each use. Best practice is to Mix, Shoot, Clean	
<div>SPRAYGUN & AIR PRESSURE</div> <div></div>	Fluid Tip: 1.4 - 1.8 mm HVLP: 10 PSI cap pressure Compliant: 29 - 40 PSI at the gun For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures	
<div>APPLICATION</div> <div></div>	Apply: 2 - 3 medium wet coats Total Dry Film Build: After sanding maintain a minimum of 2.0 mils and a maximum of 6.0 mils total dry film build.	
<div>FLASH TIME</div> <div></div>	Between Coats: 3 - 5 minutes at 70°F (21°C) As temperatures increase over 70°F (21°C), flash times will be shortened. Back to back coats may be necessary with increased temperatures.	
<div>DRY TIMES</div> <div> </div>	Air dry to Sand: 30 - 45 minutes at 70°F (21°C) Force dry to Sand: 10 - 15 minutes at 140°F (60°C) Infrared: Short Wave: 5 minutes Medium Wave: 10 minutes NOTE: Increased film build will increase dry to sand times.	
<div>SANDING</div> <div></div>	Wet Sanding: Single Layer Color: P400 Basecoat Color: P600 Machine Sanding: Single Layer Color: P320 or finer Basecoat Color: P360 or finer	

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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GENERAL PROCESS NOTES

SUBSTRATES

P565-5005 HS Express Primer Surfacer may be applied directly over etch primer, factory primer, GRP/ Gel Coated Fiberglass, existing finishes in good condition and polyester putties after degreasing and sanding with P180-P220 grit dry.

P565-5005 HS Express Primer-Surfacer may be applied over bare steel, aluminum, and galvanized metals after priming with an appropriate *Nexa Autocolor* or ONECHOICE® Etch Primer.

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. (Refer to Selection Guide).

P210-5585	HS Undercoat Hardener up to 90°F (32°C)
P210-5595	HS Undercoat Hardener - High Temp 90°F (32°C) and above
P850-1692	Thinner - Low Temperature less than 65°F (18°C)
P850-1693	Thinner - Mid Temperature 65 - 77°F (18 - 25°C)
P850-1694	Thinner - High Temperature 77 - 95°F (25 - 35°C)
P850-1695	Thinner - Very High Temperature 95°F (35°C)

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).

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

Infrared drying times given require the short wave infrared lamp to be positioned 28 - 40 inches away from the panel. Allow product to flash off for 5 minutes before drying with the infrared lamp. Drying times will depend on the type of infrared lamp used.

PLASTICS USAGE

P565-5005	Ready to Spray HS Express Primer Surfacer	5 parts
P100-2020	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

Primer must be sanded before topcoating.

When dry and sanded, P565-5005 HS Express Primer Surfacer can be directly topcoated with *Nexa Autocolor 2K* Single Layer (P420/P421-line), 2K Basecoat (P422-line) or a 2K wet-on-wet sealer.

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

EQUIPMENT CLEANING

Approved PPG Cleaning Solvent

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INNOVATING REPAIR SOLUTIONS

GENERAL PROCESS NOTES

RTS Combinations	Rollable Primer Surfacer P565-5005 : P210-5585/5595	Primer Surfacer P565-5005 : P210-5585/5595 : P850-169x	Primer Surfacer (Flexible) P565-5005 : P210-5585/5595 : P850-169x + P100-2020
Volume Ratio	4 : 1	4 : 1 : 1	4 : 1 : 1 +5%
Applicable Use Category	Primer Surfacer	Primer Surfacer	Specialty Coating (Flexed Primer Surfacer)
VOC Regulatory (g/L) (less water, less exempts)	392 - 394	468 - 472	459 - 460
VOC Regulatory (lbs/Gal) (less water, less exempts)	3.27 - 3.31	3.91 - 3.94	3.83 - 3.84
Solids vol. %	49.3	41.0 - 41.1	43.3
Solids wt. %	66.5-66.7	59.6 - 59.8	59.9 - 60.1
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	790	659	695

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 specific in this process summary.

HEALTH AND SAFETY

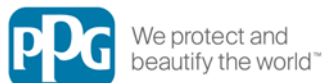
See Safety Data Sheet and Labels for additional safety information and handling instructions.

- 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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