

# Product Data Sheet

March 2016



INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY

## H5672V

### Premium Surfacer P565-5701, P565-5705 & P565-5707 (With P210-8815 HS+ Hardener)

<i>Product</i>	<i>Description</i>
P565-5701	Premium Surfacer – White SG01
P565-5705	Premium Surfacer – Grey SG05
P565-5707	Premium Surfacer – Dark Grey SG07
P210-8815	2K HS+ Hardener
P850-1692/1693/1694	2K Low VOC Thinners
P100-2020	Flexible Additive for Plastics

#### Product Description

P565-5701, P565-5705 and P565-5707 (P565-570X Premium Surfacers) are 2K HS acrylic primer surfacers, designed for use under NEXA AUTOCOLOR® 2K topcoat systems. They are easy to apply and sand and give excellent final appearance.

A range of Spectral Grey primers can be achieved using P565-5701/5705/5707, which ensure that high quality colour matches can be achieved quickly and easily while optimising topcoat usage.





Process	
	<p><b>Air-dry at 20°C:</b> 3 – 4 hours</p> <p><b>Air-dry below 20°C:</b> Overnight</p>
	<p><b>Baking at a metal temperature of 60°C:</b> 20 – 30 minutes depending on film thickness</p>
	<p><b>Medium Wave:</b> 12 minutes</p> <p>Allow P565-570X surfacers to flash off for 5 minutes before drying with the infrared lamp. Drying times will depend on the type of infrared lamp used.</p>
	<p><b>Finish with P500 grade-</b></p>
<p><b>TOPCOAT</b></p>	<p>P565-570X surfacers can be directly topcoated with <i>Nexa Autocolor 2K</i> topcoat systems.</p> <p>If P565-570X surfacers are left for more than 2 days after sanding, they should be sanded again prior to application of further undercoat or topcoat.</p>

## Process

### PAINTING PLASTICS

P565-570x primer fillers may be applied over primed plastic.  
 If P565-570x primer fillers are applied over a flexible plastic, e.g. PP/EPDM, PBT (Pocan) or PUR then they must be mixed as follows: -

P565-570x 5 parts  
 P100-2020 (Flexible additive for plastics) 1 part  
Then activate and thin in the normal manner.

Addition of P100-2020 can cause a reduction in the drying and sanding performance.  
 For more detailed information on the painting of plastic substrates, refer to the Painting Plastics PDS.

### SPECTRAL GREYS

For each of the Spectral Grey primer variants specified the following mixing ratio applies:

SG01	P565-5701	100		100g	250g	500g
SG03	P565-5701	75	3	75g	188g	375g
	P565-5705	25	1	25g	62g	125g
SG05	P565-5705	100		100g	250g	500g
SG06	P565-5705	48	0.95	48g	120g	240g
	P565-5707	52	1.05	52g	130g	260g
SG07	P565-5707	100		100g	250g	500g

### CHOICE OF THINNER

The choice of thinner should be made according to application temperature, air movement and size of job. The recommendations below are for guidance only :-

<b>Thinner:</b>	<b>Ideal temperature range:</b>
P850-1692	Below 20°C
P850-1692/-1693	15 - 25°C
P850-1693	20 - 30°C
P850-1693/-1694	25 - 35°C
P850-1694	30 - 40°C

**Process**

Weight Activations for use with HS hardeners (P210-8815)  
Ratio 7 : 1 : 1 - 2

1 Litre RFU Sprayable Volume (@ 7 : 1 : 2 ratio)	Please note the weights are cumulative. Do not tare or zero scale between additions			
<b>SG 01</b>	<b>Wt. Primer P565-5701 Grams (7 Parts)</b>	<b>Wt Hardener P210-8815 Grams (1 Part)</b>	<b>Wt. Thinner P850-1692/3/4 Grams (1 Part)</b>	<b>Wt. Thinner P850-1692/3/4 Grams (2 Parts)</b>
1.0 L	1078	1184	1266	1384
<b>SG 05</b>	<b>Wt. Primer P565-5705 Grams (7 Parts)</b>	<b>Wt Hardener P210-8815 Grams (1 Part)</b>	<b>Wt. Thinner P850-1692/3/4 Grams (1 Part)</b>	<b>Wt. Thinner P850-1692/3/4 Grams (2 Parts)</b>
1.0 L	1077	1183	1266	1346
<b>SG 07</b>	<b>Wt. Primer P565-5707 Grams (7 Parts)</b>	<b>Wt Hardener P210-8815 Grams (1 Part)</b>	<b>Wt. Thinner P850-1692/3/4 Grams (1 Part)</b>	<b>Wt. Thinner P850-1692/3/4 Grams (2 Parts)</b>
1.0 L	959	1065	1147	1229

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## Roll Prime Process

	<p>P565-5701/5705/5707                      7 parts</p> <p>P210-8815                                      1 part</p> <p>P850-1692/3/4                              0.25 parts</p>
<p>Pot-life:                                      40 min at 20°C</p> <p>Note: It is recommended to use the material immediately after mixing.</p> <p>Clean roller tray immediately after use.</p>	
<p><b>APPLICATION</b></p>	<ol style="list-style-type: none"> <li>1. Use of good quality high density foam rollers is essential. Use of a suitable roller tray allows easy control of paint loading on the roller.</li> <li>2. Load the roller from a suitable roller tray. Removed excess paint from the roller.</li> <li>3. The first coat covers the largest area. Subsequent coats cover smaller areas.</li> <li>4. Apply paint from the centre of the repair patch, rolling outwards using light pressure.</li> <li>5. Use the roller with less paint loading to fade hard edges of each coat.</li> <li>6. Allow the paint to flow out on the panel; avoid over- working, which can leave an uneven surface.</li> </ol> <p>When one coat becomes matt, it is ready for the next coat.</p>
	<p>Number of coats: Apply 4 coats to give a film thickness of 75 - 125 microns (3 - 5 thou.)</p> <p><b>Between Coats:</b>                      Approx. 5 minutes depending on spraying conditions</p>
	<p><b>Drying Times</b></p> <p><b>Air-dry at 20°C:</b> 3 - 4 hours (Depending on film thickness)</p> <p><b>Stoving at a metal temperature of 60°C :</b> 20 - 30 minutes</p> <p><b>Infra-red drying</b> times given require the short wave infra-red lamp to be positioned 70-100 cm away from the panel. Use IR unit on half power for 5 minutes before applying full power for approximately 15 minutes. Drying times will depend on the type of infra-red lamp used.</p> <p>Drying time will depend on film thickness.</p>



## Roll Prime Process

Weight Activations for use with HS hardener (P210-8815) Ratio 7 : 1 : 0.25 for roller application			
1 Litre RFU for Roll application (@ 7 : 1 : 0.25 ratio)	Please note the weights are cumulative. Do not tare or zero scale between additions		
SG 01	P565-5701 Grams (7 Parts)	Wt Hardener P210-8815 Grams (1 Part)	Wt. Thinner P850-1692/3/4 Grams (0.25 Parts)
1.0 L	1307	1435	1460
SG 05	P565-5705 Grams (7 Parts)	Wt Hardener P210-8815 Grams (1 Part)	Wt. Thinner P850-1692/3/4 Grams (0.25 Parts)
1.0 L	1305	1433	1458
SG 07	P565-5707 Grams (7 Parts)	Wt Hardener P210-8815 Grams (1 Part)	Wt. Thinner P850-1692/3/4 Grams (0.25 Parts)
1.0 L	1162	1291	1316
<b>VOC INFORMATION</b> The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC. The VOC content of this product in ready to use form is max. 540g/litre. Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.			

These products are for professional use only and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information please refer to the material Safety Data Sheet, also available at: [www.nexaautocolor.com](http://www.nexaautocolor.com)

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