



# Technical Data Sheet

# U3800V

March 2020 Update

INTERNATIONAL MASTER  
FOR PROFESSIONAL USE ONLY

## Universal 2K Primer

Product	Description
P565-38xx	Universal 2K Primer – Light Grey
P565-3880	Universal 2K Primer – Dark Grey
P210-987	EHS Plural Mix Hardener
P210-982	EHS Turbo Plus Hardener - Medium
P210-9652	EHS Turbo Plus Medium Hardener
P852-1792	EHS Thinner - Medium
P852-1790	EHS Thinner - Slow
SPP4000	Potlife Extender

### Product Description

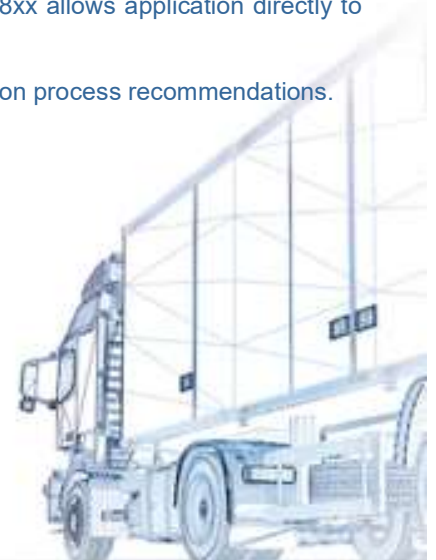
Universal 2K Primer P565-38xx, is based on the latest technical developments in primer technology, and should be used where optimisation of the repair and building processes are key requirements.

Universal 2K Primer is designed for use under **2K EHS Turbo Plus topcoat (P498)** or Aquabase Plus basecoat (P989) provides a truly productive process.

This product can be applied direct to metal and can be topcoated up to five days later without the need for primer sanding.

The strong adhesion and anti-corrosion properties of Universal 2K Primer, P565-38xx allows application directly to bare metal as long as high build mode is respected.

Substrates must be properly prepared and cleaned according to substrate preparation process recommendations.



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## Substrates and Preparation

### Prepare the Substrate as follows:

#### Substrates:

Steel

Shot Blasted Steel  
Aluminium (\*)

Anodized Aluminium  
Galvanised Steel

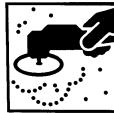
Stainless Steel  
GRP

#### Sanding:

Sanded with P80-150

SA 2,5 (Rz not above 35µm)  
Sanded with P360-P400 or shot  
Blasted (Rz not above 35µm)  
Without any mechanical treatment  
Scuffed with Scotch Brite®  
Red pads

Sanded with P80-P150  
Sanded with P320-400



### Cleaning:



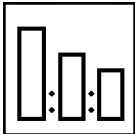
The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

Substrates need to be thoroughly wiped using the appropriate degreaser (P850-1367 Degreaser & P850-1378 Spirit Wipe or P980-9010 low V.O.C cleaner)

(\*) 3003 – 1050 alloys have been evaluated

## Process

### Conventional or Pressure Pot or Air Assisted Airless Application



#### Activation ratio by volume

P565-38xx	3,5 parts
P210-982 or -9652	1 part
P852-179x or SPP4000	1-1,5 parts

#### Pluralmix option 1, ratio by Volume:

##### Prethin first as: \*

P565-38xx	10 parts
P852-179x or SPP4000	1 part

##### Then activate prethinned primer as:

Prethinned Primer:	2,75 parts
P210-987	1 part

#### Pluralmix option 2, ratio by Volume:

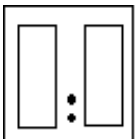
##### Prethin first as: \*

P565-38xx	3,5 parts
P852-179x or SPP4000	1 part

##### Then activate prethinned primer as:

Prethinned Primer:	4,5 parts
P210-982 or P210-9652	1 part

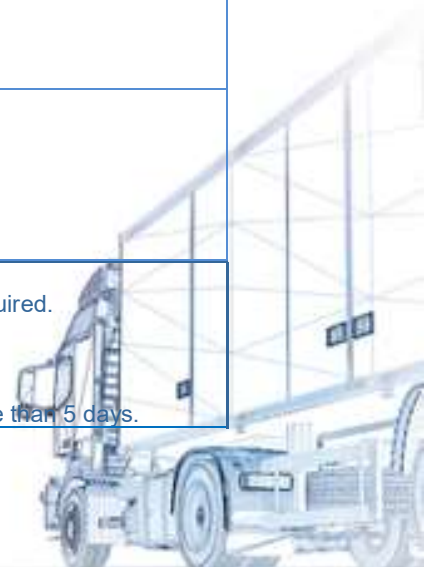
\*The Primer can remain prethinned in the original pail for maximum one month



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## Process

Conventional, Pressure Pot or Air Assisted Airless Application	
	<p>Spray Viscosity at 20°C: 28-32 seconds DIN4</p>
	<p>Potlife @20°C: 2 hours Sprayable time @20°C: 1 Hour</p>
	<p>1,6-1,8 mm Gravity or suction feed at 2.0-2.5 bars</p> <p>OR</p> <p>1.1-1.2 mm Pressure Pot Air Cap Pressure: 0.68 bar Paint Pressure : 0.3-1.0 bar Fluid flow rate: 280-320 cc/min</p> <p>OR</p>
	<p>Tip Size: 11 to 13 Thou (0,23 to 0,28 mm) for Air Assisted Airless Paint Pressure: 100-120 bars Air Atomization: 2,5-3,5 bars</p>
	<p><b>Number of Coats</b></p> <p>Apply 2 full coats This gives a film thickness of minimum 65 microns</p> <p>Or: 1 light coat followed immediately by 1 full coat to give 45µm Dry Film thickness (aluminium only)</p>
	<p>10-15 minutes minimum</p> <p>Minimum 30 minutes at 20°C before topcoating or until fully matt.</p>
	<p>Ready for topcoat after 30 minutes, or up to 5 days with no sanding required. For any other need force dry before sanding. If left more than 8 hours, then preclean before topcoating If left more than 3 days before topcoating, then light de-nibbing and precleaning is recommended. Sand with P400 dry or finer if left for more than 5 days.</p>



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## General Process Notes

### CHOICE OF HARDENER AND THINNER

The exact choice of hardener and thinner combination will depend on the gun set-up used, air movement, size of repair, temperature and application conditions. However, below is a general guide :

Hardener	Temperature Range	Recommended Thinner
P210-982 or -9652	Below 18°C	P852-1792
P210-982 or -9652	Below 25°C	P852-1790 or SPP4000
P210-982 or -9652	Above 25°C	P852-1790 or SPP4000

## Health and Safety

The EU limit value for these products (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 these products 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: [http://www.ppg.com/Autocolor\\_MSDS](http://www.ppg.com/Autocolor_MSDS)

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