

# Product Data Sheet

March 2022

INTERNATIONAL MASTER  
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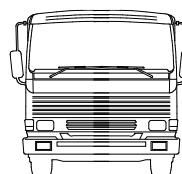
# T0750V\_TV

## HS Chromate Free Epoxy Primer - Beige P580-4023

<i>Product</i>	<i>Description</i>
P580-4023	Chromate Free Epoxy primer beige
P210-7644	EHS Hardener - Standard
P210-7642	EHS Hardener - Slow
P210-7606	EHS Plural Mix Hardener
P852-6442	EHS Thinner - Slow
P852-6444	EHS Thinner - Medium
P852-6446	EHS Thinner - Fast
P852-6448	EHS Thinner - Extra Fast

### Product Description

P580-4023 is an isocyanate cured high solids epoxy primer with excellent adhesion properties and corrosion resistance over a variety of substrates. It is ideal as a multipurpose primer and as a high build primer for use over structural steel components such as chassis.



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# Process

	Airless Spray	Conventional Spray and HVLP	Pressure Pot and HVLP
	P580-4023      10 parts P210-764x      1 part P852-644x      0.5-1 part  Please see separate note regarding use of P210-7606 Plural Mix Hardener	P580-4023      10 parts P210-764x      1 part P852-644x      1.5 parts	P580-4023      10 parts P210-764x      1 part P852-644x      1.5 parts
	<b>Pot Life at 20°C:</b> 1.5-2 hours  Clean gun immediately after use	<b>Pot Life at 20°C:</b> 1.5-2 hours  Clean gun immediately after use	<b>Pot Life at 20°C:</b> 1.5-2 hours  Clean gun immediately after use
	30-60 secs DIN4 at 20°C	33 – 37 secs DIN4 at 20°C	33 - 37 secs DIN4 at 20°C
		1.3 -1.8 mm  4.0-6.0 bar (60-90 psi)	
	0.28-0.33 mm (11-13 thou) 40-60° angle  Paint pressure: 100-200 bar (1500-3000 psi)		1.1 mm Air Pressure: 4.0-6.0 bar (60-90 psi) Paint pressure: 1 bar (15 psi)
		1.0-1.4 mm Air cap pressure: 0.675 bar (10 psi) maximum	
	2 single coats giving 60-80 microns For optimum protection of steel the primer dry film thickness should be a minimum of 50 microns. On blast cleaned steel this should be 50 microns as measured above the blast cleaned peaks. Additional coats may be necessary depending on application equipment used, spraying technique, substrate profile and chosen thinning ratio.		

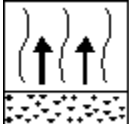




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	<p>10-20 minutes between coats, depending on film thickness and drying conditions</p> <p>Flash off 15-30 minutes before stoving.</p>
	<p><b>Air dry (20°C)</b>  Recoat : 30 minutes for wet-on-wet use  Hard dry : 12 hours overnight</p> <p><b>Stoving at metal temperature of : 60°C for 30 minutes</b></p>
	<p>Normally P580-4023 does not require flattening and should be directly recoated. It may be flattened when hard dry (12 hours at 20°C or 30 minutes at 60°C) using P320-400 dry or P500-600 wet paper. If left for more than 3 days P580-4023 must be flattened before recoating.</p>
<b>PLURAL MIX APPLICATION</b>	<p>P580-4023 can be used with Plural Mix Hardener P210-7606 for plural mix equipment. The mixing ratio is 6.5 parts Primer : 1 part P210-7606 Hardener.</p> <p>If thinning is required, it is recommended that the primer is pre-thinned 6.5:0.5 with thinner, then the pre-thinned primer activated 7:1 with P210-7606 Hardener</p>

## USE WITH POLYESTER FILLER

Apply one coat of P580-4023 with a DFT of about 30 microns. Allow to air dry for a minimum of 1-2 hours depending upon temperature and application conditions. Polyester filler can then be applied over the primer, allowed to dry and then sanded back to profile. After cleaning then P580-4023 can be reapplied over the polyester filler.

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## General Process Notes

SUBSTRATES	PREPARATION	NOTES
Steel	Blast cleaning is the preferred surface treatment for maximum durability and optimum paint usage. Alternatively sand thoroughly using P120-P220 wet and dry paper or P80-P180 dry sanding machine discs, then clean with P850-1378	Surface must be free from oil/grease, mill scale and rust.
Stainless Steel	Degrease with P850-1367 and scuff with P400 wet and dry paper or P420 dry sanding machine discs, and then cleaned with P850-1378.	
Sound Factory Finishes Sound Works Primer Sound old finishes (2-pack) Sound electrocoat	Flat thoroughly using P280-P400 wet and dry paper or P240-P320 dry sanding machine discs, then clean with P850-1378	Old synthetic finishes must be well cured and non-bleeding
Aluminium	Degrease with P850-1367 and abrade the surface using P240-P320 dry sanding machine discs, P400-P600 wet and dry paper.	
Weathered galvanised steel Zintec	Clean with P273-901; degrease with P850-1367 and sand using P240-P320 dry sanding machine discs.	Surface must be free from oxidation residues.
Hot dipped galvanised steel	Thoroughly degrease with P850-1367, scuff with Scotchbrite™ Fine or P400 wet and dry paper, then clean with P850-1378.	
<p>P580-4023 is NOT recommended for use over thermo-plastic substrates.</p> <p>For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS.</p>		



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**VOC INFORMATION**

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:  
[http://www.ppg.com/Autocolor\\_MSDS](http://www.ppg.com/Autocolor_MSDS)

**For further information please contact:**

Customer Service Sales Group  
PPG Industries (UK) Ltd  
Needham Road  
Stowmarket  
Suffolk IP14 2AD

**Tel: 01449 771771**

**Fax: 01449 773472**

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