



Technical Data Sheet

May 2022

U3800_TV

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

Universal 2K Primer – Light Grey P565-38xx

Product	Description
P565-3800	Universal 2K Primer – Light Grey
P565-3880	Universal 2K Primer – Dark Grey
P210-7504	MS Hardener - Medium
P210-7502	MS Hardener - Slow
P852-6334	MS Thinner - Medium
P852-6332	MS Thinner - Slow
SPP4000	Potlife Extender

Product Description

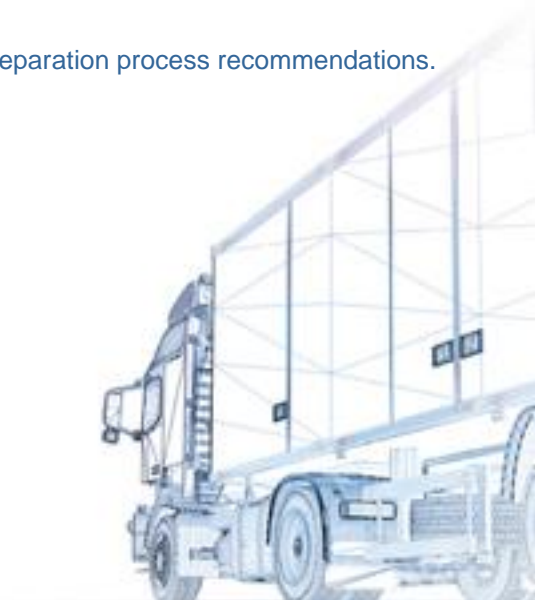
Universal 2K Primer P565-38xx, is based on the latest technical developments in primer technology, and should be used where optimisation of the repair and building processes are key requirements.

Universal 2K Primer is designed for use under **TURBO VISION® Topcoats** (P650) or Aquabase Plus basecoat (P989), provides a truly productive process.

This product can be applied direct to metal or over a Etch-Wash primer 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
OE Finishes and
Aged Paintwork

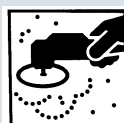
Sanding:

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

Sanded with P320-400



Cleaning:



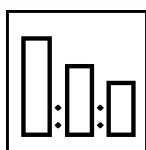
The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

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

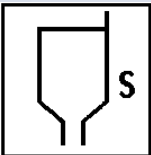

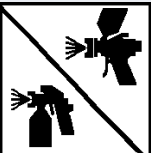

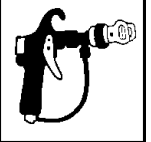

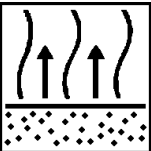



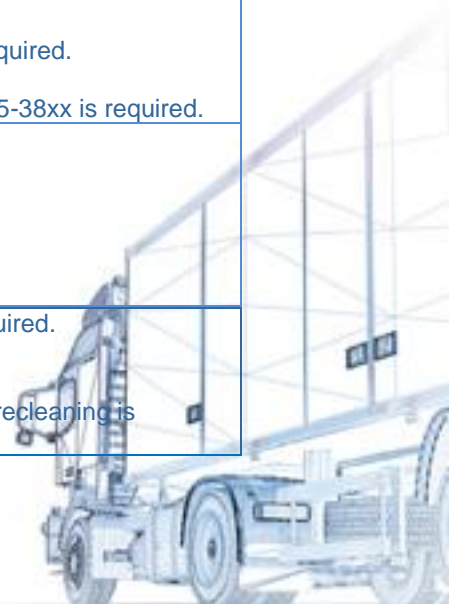
Activation ratio by volume

P565-38xx	3.5 parts
P210-750x	1 part
P852-633x or SPP4000	1-1.5 parts



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Process	
	Conventional, Pressure Pot or Air Assisted Airless Application
	Spray Viscosity at 20°C: 28-32 seconds DIN4
	Potlife @20°C: 2 hours Sprayable time @20°C: 1 Hour
	1.6-1.8 mm Gravity or suction feed at 2.0-2.5 bars
	OR
	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
	OR
	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
	Number of Coats Apply 2 full coats This gives a film thickness of minimum 65 microns Or: 1 light coat followed immediately by 1 full coat to give 45µm Dry Film thickness (aluminium only). 100-125 µm wet is required. If sprayed over a wash/etch primer, 25-35 µm Dry Film thickness of P565-38xx is required.
	10-15 minutes minimum Minimum 30 minutes at 20°C before topcoating or until fully matt.
	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 24 hours before topcoating, then light de-nibbing and precleaning is recommended. Sand with P400 dry or finer if left for more than 5 days.



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TOPCOAT

P565-38xx can be directly topcoated with **TURBO VISION® Topcoats** (P650) or Aquabase Plus basecoat (P989).

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
P210-7504	Below 18°C	P852-6332 or P852-6334
P210-7502	Below 25°C	P852-6334 or SPP4000
P210-7502	Above 25°C	P852-6332 or SPP4000

Health and Safety

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

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