

# Product Data Sheet

December 2018

INTERNATIONAL MASTER  
FOR PROFESSIONAL USE ONLY

## U0320\_TV

### HS Wet-on-wet Undercoat P565-897 – Medium Solids System

<i>Product</i>	<i>Description</i>
<i>P565-897</i>	<i>HS Wet-on-wet Undercoat – off White</i>
<i>P210-7504</i>	<i>MS Hardener - Standard</i>
<i>P210-7502</i>	<i>MS Hardener - Slow</i>
<i>P852-6336</i>	<i>MS Thinner - Fast</i>
<i>P852-6334</i>	<i>MS Thinner - Medium</i>
<i>P852-6332</i>	<i>MS Thinner - Slow</i>
<i>P100-2020</i>	<i>Flexible Additive for Plastics</i>

#### Product Description

P565-897 has been designed for application by HVLP and conventional spray. It is a fast-drying Isocyanate hardened acrylic 2-pack product with excellent adhesion to a variety of substrates and very good holdout properties beneath 2-pack topcoats. It can be tinted with Turbo Vision Toners or use as white readymix color for use as undercoat.



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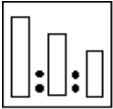





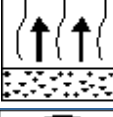


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## Process

	MS Turbo Plus use HVLP and Conventional Application
	P565-897 (tinted or untinted)    4 parts P210-750x    1 part P852-633x    2 part
	<b>Pot Life at 20°C :</b> approximately 2 hours  Clean gun immediately after use.
	15-17 secs DIN4 (19-22 secs BSB4)    at 20°C
	1.4-1.8 mm 3.3-4.0 bar (50-60 psi)
	1.0-1.4 mm Air cap pressure : 0.675 bar (10 psi maximum)
	1 or 2 single coats depending on build required
	10-15 minutes between coats, depending on film thickness and drying conditions. Flash off 40 minutes before topcoating
	<b>Air dry (20°C)</b> Recoat :    minimum after 40 minutes for wet-on-wet use maximum after 48 hours overnight drying without sanding. If left longer than 2 days, P565-897 must be sanded    and degreased prior topcoating  <b>Stoving at metal temperature of :</b> 50°C    60 minutes 60°C    30 minutes
	Normally P565-897 does not required flatting and should be directly topcoated. If, however, some dirt inclusion occurs, light flatting/denibbing can be carried out when hard dry using P600 or finer flatting paper.  If baked P565-897 can be flattened after the above stoving times : Wet or Dry paper :    P600 or finer Dry machine sanding :    P320 or finer

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## General Process Notes

### SUBSTRATES AND PREPARATION

Thoroughly cleaned, and where appropriate flatted, works primers and OE finishes; old 2-pack finishes; CT etch primers; 1-pack and 2-pack undercoats; and GRP.

#### NOTES:

1. Do **NOT** apply P565-897 over areas of bare steel, (i.e. rub throughs etc.) when used in refurbishment work.
2. Do **NOT** apply over old or fresh synthetic alkyd topcoats.
3. This product is recommended for whole panels only and should not be used for spot or partial repairs.
4. The Turbo Plus MS process is preferable for large area application.
5. Careful preparation of substrates will ensure a top quality finish.

For more detailed information, see "Preparation and Pre-treatment" PDS.

### RECOAT

P565-897 may be recoated with any **Nexa Autocolor** Commercial Transport 2-pack topcoat. Care must be taken to ensure that the correct recoat times are observed, particularly with metallic basecoats, in order to prevent lifting.

Normally P565-897 can be left for up to 2 days without flattening prior to recoating. However, if be left for longer than 1 day, P565-897 must be scuffed before overcoating.

### APPLICATION EQUIPMENT INFORMATION

#### HVLP

The most suitable HVLP gun for the application of Commercial Transport products is a pressure feed system.

Air cap pressure : 0.675 bar (10 psi) maximum

Paint pressure : 0.3-1.0 bar (5-15 psi) maximum

If long fluid lines are used, the paint pressure will need to be increased.

### DRYING

The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, temperatures below 20°C and excessive film thickness will extend the drying times.

### SELECTION OF HARDENER AND THINNER

The exact choice of hardener and thinner combination will depend on the gun set up used, air movement, temperature application conditions, size of job and personal preference.

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**PAINTING PLASTICS**

P565-897 may be applied over prepared painted plastic. Prepare by thorough cleaning and scuffing. It may also be applied over primed plastic (see Plastic Plastics Painting System data sheet Y0100 for details). If P565-897 is applied over a flexible plastic, it must be mixed as detailed below :

	Flexible plastic	Very flexible plastic
P565-897	5 parts	2 parts
Flexible Additive for Plastics (P100-2020)	1 part	1 part

**AFTER** adding P100-2020, activate and thin in the normal way.

The addition of P100-2020 will extend the drying times.

**TINTING**

P565-897 can be tinted. Add up to a maximum of 5% Turbo Vision Toners to the unactivated P565-897. Then activate and thin according to the P565-897 process recommendations.

**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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