



Technical Data Sheet

January 2024

U3900V

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

2K PU Primer – P565-390X	
Product	Description
P565-3902	2K PU Primer - Light Grey
P565-3907	2K PU Primer - Dark Grey
P565-3910	2K PU Primer - Beige
P210-7644	EHS Hardener - Medium
P210-7642	EHS Hardener - Slow
P210-7606	EHS Hardener - Pluralmix
P852-6440	EHS Thinner – Extra Slow
P852-6442	EHS Thinner - Slow
P852-6444	EHS Thinner - Medium
P852-6454	EHS Thinner – Plural Mix
P850-1392	Medium Thinner

Product Description

P565-390X 2K PU Primer is a high performance primer designed to give excellent corrosion protection over aluminium, and is especially recommended for surfaces of jointed aluminium panels. It has a high build and can be applied in one coat over aluminium (2 coats required on steel). It can be recoated after 40 minutes and will give an excellent smooth finish and gloss from the topcoat. The VOC content of this product is below 450 g/l. It perfectly compliments the Turbo Vision topcoat range, giving an excellent high quality finish.



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Substrates and Preparation

Prepare the Substrate as follows:

Substrates:

Steel

Blast Cleaned Steel
Aluminium

Anodised Aluminium
Chemically Pretreated
Aluminium

Galvanised Steel
Stainless Steel
GRP
OE Finishes and
Aged Paintwork

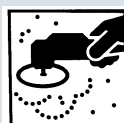
Sanding:

Abraded with P80-150

SA 2.5 (Rz not above 35µm)
Abraded with P240-320
or blast cleaned (Rz < 35µm)
Not Recommended
Consult PPG Technical Team
and see separate note

Abraded with Red Scotch Brite®
Abraded with P80-P150
Abraded with P240-360

Abraded with P320-400



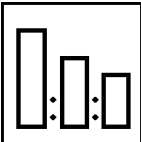
Cleaning:



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

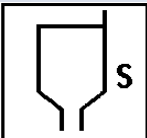

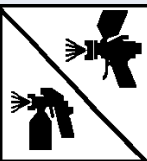


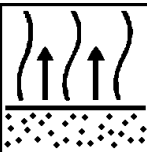

Substrates need to be thoroughly wiped using
the appropriate degreaser (P850-1367
Degreaser & P850-1378 Spirit Wipe)

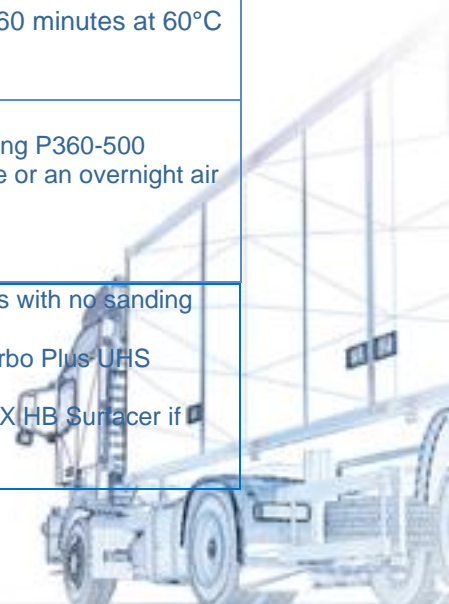
Process

	Conventional / Pressure Feed Application	Air Assisted Airless Application
	Activation ratio by volume	Activation ratio by volume
	P565-390X 4 parts	P565-390X 4 parts
	P210-7642 / -7644 1 part	P210-7642 / -7644 1 part
	P852-644X 1.7 - 2 parts	P852-644X 0.8 - 1.2 parts
	For Plural Mix Equipment:	For Plural Mix Equipment:
	P565-390X 3 parts	P565-390X 3 parts
	P210-7606 1 part	P210-7606 1 part
	P852-6454 / P850-1392 1 part	P852-6454 P850-1392 0.5 part
	For 2K Plural-mix equipment it is recommended to pre-thin the primer 3 : 1 with Thinner. The pre-thinned paint should then be activated 4 : 1 with P210-7606 Hardener Note: ONLY P852-6454 or P850-1392 Thinner should be used if pre-thinning the primer.	For 2K Plural-mix equipment it is recommended to pre-thin the primer 3 : 0.5 with Thinner. The pre-thinned paint should then be activated 3.5 : 1 with P210-7606 Hardener Note: ONLY P852-6454 or P850-1392 Thinner should be used if pre-thinning the primer.



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Process		
	Conventional and Pressure Feed Application	Air Assisted Airless Application
 	<p>Spray Viscosity at 20°C: 17-19 seconds DIN4</p> <p>Potlife at 20°C: 1.5 hours</p>	<p>Spray Viscosity at 20°C: 23-27 seconds DIN4</p> <p>Potlife at 20°C: 1 hour</p>
 	<p>Gravity Feed: 1.3-1.4 mm tip Suction Feed: 1.6-1.8mm tip Air Pressure : 2.0-2.5 bars</p> <p>Pressure Feed: 1.0-1.2 mm tip Paint Pressure : 0.3-1.0 bars Fluid flow rate: 280-320 cc/min Air Pressure : 2.0-2.5 bars</p>	<p>Tip Size: 9-11 thou (0.23 to 0.28 mm) Paint Pressure: 70-120 bars Air Atomization: 2.0-3.5 bars</p>
	<p>Number of Coats</p> <p>For aluminium and non-metallic substrates, apply 1 full coat to give a Dry Film Thickness of 25-35 microns</p> <p>For steel substrates, apply 2 full coats to give a Dry Film Thickness of 50-80 microns. Higher film thicknesses are required on blast cleaned substrates.</p>	
	<p>10-15 minutes minimum between coats</p> <p>If baking is required, flash-off 10 minutes minimum before baking 45-60 minutes at 60°C metal temperature.</p>	
	<p>For best results recoat wet-on wet Can be de-nibbed or lightly sanded if required, after 2-4 hours air dry using P360-500 abrasive. If full sanding is required, best results are obtained after a bake or an overnight air dry.</p>	
<p>RECOAT</p>	<p>Can be recoated with topcoat after 40-60 minutes air dry, or up to 3 days with no sanding required (if not baked). Can be topcoated directly with Turbo Vision® Topcoats (P650-Line), Turbo Plus UHS (P498-Line), Aquabase Plus Basecoat, or 2K P422-Line Basecoat. Can also be recoated with P565-37XX Wet on Wet Primer, or P565-102X HB Suracer if required.</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 :

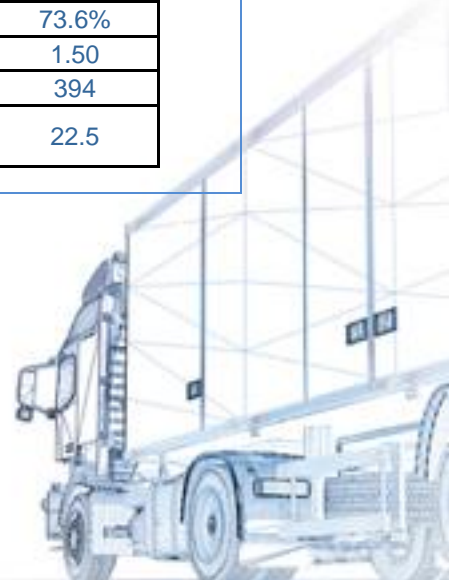
Hardener	Thinner	Temperature Range
P210-7644	P852-6444	Below 18°C
P210-7644	P852-6442	18-25°C
P210-7642	P852-6442	Above 25°C
P210-7642	P852-6440	Above 30°C
P210-7606	P852-6454	20-30°C

APPLICATION OVER CHEMICALLY PRE-TREATED ALUMINIUM

Nexa Autocolor P565-390X 2K PU Primer will work on some aluminium pre-treatments. Conditions of use are important. Please contact Nexa Autocolor Technical Support for more information.

Ready for use Data

Activation ratio by volume	4:1:1.7	4:1:1	3:1:1	3:1:0.5
P565-390X 2K PU Primer	4	4	3	3
P210-764X	1	1		
P210-7606 Plural Mix			1	1
P852-64XX	1.7	1	1	0.5
Volume solids %	49%	54.5%	50.7%	56.3%
Solids by weight %	68.6%	73.1%	69.0%	73.6%
Density	1.42	1.49	1.44	1.50
VOC (g/L)	446	400	444	394
Coverage m ² /L at 25 microns DFT	19.6	21.8	20.3	22.5



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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

For further information please contact:

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