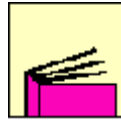


FOR PROFESSIONAL USE ONLY



# U0320

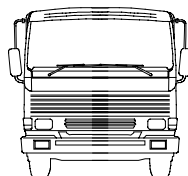
Date of issue: September 2002

## HS Wet-on-wet Undercoat P565-897 - Medium Solids system

Products	
P565-897	HS Wet-on-wet undercoat - off white
P210-820	Turbo Plus™ Extra slow MS hardener
P210-821	Turbo Plus Slow MS hardener
P210-822	Turbo Plus Medium MS hardener
P850-1390	Turbo Plus Extra slow thinner
P850-1391	Turbo Plus Slow thinner
P850-1392	Turbo Plus Medium thinner
P850-1393	Turbo Plus Fast thinner

### PRODUCT DESCRIPTION

P565-897 has been designed for application by Compliant 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 Plus basics or ready mix for use as a tintable undercoat.



**THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY AFTER REFERENCE TO THE MANUFACTURER'S MATERIAL SAFETY DATA SHEET**

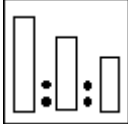

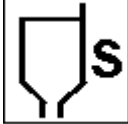



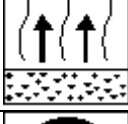


# HS Wet-on-wet undercoat

## P565-897 - Medium Solids system



U0320

### PROCESS

PROCESS	
	<b>MS Turbo Plus use Compliant and Conventional Application</b>
	<p>P565-897 (tinted or untinted)      3 parts            P210-820/-821/-822                      1 part            Turbo Plus thinner                          1 part</p>
	<p><b>Pot Life at 20°C :</b>    approximately 2 hours             Clean gun immediately after use.</p>
	<p>15-17 secs DIN4            (19-22 secs BSB4)    at 20°C</p>
	<p>1.4-1.8 mm            3.3-4.0 bar (50-60 psi)</p>
 <b>COMPLIANT</b>	<p>1.0-1.4 mm            Air cap pressure: See manufacturers recommendations</p>
	<p>1 or 2 single coats depending on build required</p>
	<p>10-15 minutes between coats, depending on film thickness and drying conditions.            Flash off 30 minutes before topcoating</p>
	<p><b>Air dry (20°C)</b>            Recoat :      40 minutes for wet-on-wet use            When using P565-897 over Etch primers (e.g. P565-625/-767) it is essential that the topcoat or basecoat is applied within the specified recoat time or if left longer be recoated after 6 hours, otherwise film lifting may occur.  <b>Stoving at metal temperature of :</b>            50°C              60 minutes            60°C              30 minutes</p>
	<p>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.</p> <p>If baked P565-897 can be flatted after the above stoving times :            Wet or Dry paper :      P600 or finer            Dry machine sanding :    P320 or finer</p>

# HS Wet-on-wet undercoat

## P565-897 - Medium Solids system



U0320

### 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. See appropriate PDS for further details.

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

#### APPLICATION EQUIPMENT INFORMATION

##### Compliant

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

Air cap pressure : See manufacturers recommendations

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.

# HS Wet-on-wet undercoat

## P565-897 - Medium Solids system



U0320

### GENERAL PROCESS NOTES

#### FLATTING

Normally, P565-897 can be left for 2 days without flattening prior to recoating. However, if left longer than 3 days P565-897 must be scuffed before topcoating.

#### 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 10% Turbo Plus to the unactivated P565-897. Then activate and thin according to the P565-897 process recommendations.

**This information is given in good faith but without warranty.**

For further information please contact:  
Customer Service and Sales Group  
PPG Industries (UK) Ltd  
Needham Road  
Stowmarket  
Suffolk, IP14 2AD

**Tel: 01449 771771**  
**Fax: 01449 773472**

**Nexa Autocolor** and Turbo Plus are trademarks of PPG Industries. © 2002 PPG Industries, all rights reserved.  
Copyright in the above product numbers that are original is asserted by PPG Industries.

**Scotchbrite** is a trademark of 3M UK Plc.