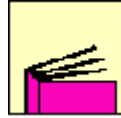


FOR PROFESSIONAL USE ONLY



U0230

Date of issue : September 2002

Transparent Sealer P565-755 - Medium Solids system

Products	
P565-755	Transparent sealer
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
P100-2020	Flexible additive for plastics

PRODUCT DESCRIPTION

A versatile transparent wet-on-wet sealer with excellent adhesion properties. Substrates need only be cleaned and scuffed, thereby saving considerable preparation time. It is especially useful for resprays where the masking of door shuts is not as critical as with conventional non-sand primers because any overspray is transparent.

The product is also useful for sealing off polyester filled areas and can act as a coloured sealer or groundcoat when tinted with Turbo Plus. Use over complete panels only.



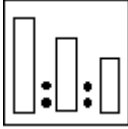




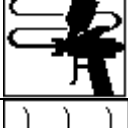
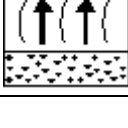
THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY AFTER REFERENCE TO THE MANUFACTURER'S MATERIAL SAFETY DATA SHEET

Transparent Sealer P565-755 Medium Solids System



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PROCESS

Compliant and Conventional Application		
USAGE	Adhesion Promoter Sealer Turbo Plus Standard System	Coloured Sealer Turbo Plus Standard System
Tinting prior to activating		Tint with Turbo Plus (P488-) Maximum Ratio 1:1
	P565-755 3 parts P210-820/-821/-822 1 part P850-1390/-1391/-1392/-1393 2 parts	P565-755 Mix 3 parts P210-820/-821/-822 1 part P850-1390/-1391/-1392/-1393 2 parts
	Pot Life at 20°C : 4-5 hours Clean gun immediately after use.	Pot Life at 20°C : 4-5 hours Clean gun immediately after use.
	14-16 secs DIN4 (17-20 secs BSB4) at 20°C	14-16 secs DIN4 (17-20 secs BSB4) at 20°C
	1.4-1.8 mm 3.3-4.0 bar (50-60 psi)	1.4-1.8 mm 3.3-4.0 bar (50-60 psi)
	1.0-1.4 mm Air cap pressure : See manufacturers recommendations	1.0-1.4 mm Air cap pressure : See manufacturers recommendations)
	1 double or 2 single coats 25-35 microns (1-1.5 thou)	1 double or 2 single coats 25-35 microns (1-1.5 thou)
	10-15 minutes between coats 15-30 minutes before topcoating	10-15 minutes between coats 15-30 minutes before topcoating
RECOAT	Follow after flash-off time with Turbo Plus P488- line.	Follow after flash-off time with Turbo Plus P488- line.

Transparent Sealer P565-755



GENERAL PROCESS NOTES

SUBSTRATE AND PREPARATION

P565-755 AS WET-ON-WET ADHESION PROMOTER AND SURFACER

Substrates need to be well flatted when using P565-755 as a tinted sealer or groundcoat.

SUBSTRATES	PREPARATION	NOTES
Bare Metal	Etch prime steel and aluminium before applying P565-755.	Small rub throughs i.e. areas flatted through to bare steel, can be directly overcoated with P565-755.
Existing 2-pack paintwork	Wash down with P273-901. Scuff with Scotchbrite™ Fine or fine grade paper. For severe contamination wet flat with Bodykleen P273-901 added to the water using P400-P600 paper. Clean thoroughly with P850-1378.	
Bare GRP/ "Glasonite"	Clean with P273-901. Flat thoroughly using P240-P280 dry sanding machine discs or P320-P400 wet and dry paper, then clean with P850-1378.	Take care not to break through the gel coat when flating GRP.
Fillers	Flat thoroughly with P280-P320 dry sanding machine discs then clean with P850-1378.	

NOTE : P565-755 is NOT recommended for use over old synthetic finishes.

For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS.

Transparent Sealer P565-755 Medium Solids System



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GENERAL PROCESS NOTES

RECOAT

P565-755 may be recoated with Turbo Plus, see appropriate PDS for further details.

P565-755 is **NOT** recommended for use beneath synthetic topcoat lines such as EHS Hi-Gloss 383™.

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.

FLATTING

Normally, P565-755 can be left for 3 days without flattening prior to recoating. However, if left longer than 3 days P565-755 must be scuffed before recoating.

RECTIFICATION

If dirt pick-up or damage occurs, and rectification is required, P565-755 may be lightly flattened when hard (approximately 2 hours air-dry at 20°C).

Transparent Sealer P565-755 Medium Solids System



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GENERAL PROCESS NOTES

PAINTING PLASTIC

P565-755 may be applied over prepared painted plastic. Prepare by careful cleaning and scuffing with Scotchbrite Fine when using P565-755 as an adhesion promoter. Flat thoroughly using P400-P600 wet or P280-P320 dry, when using tinted P565-755 as a coloured sealer.

P565-755 may be applied over prime plastic (see Plastics Painting System data sheet Y0100 for details). If P565-755 is applied over a flexible plastic, it must be mixed as detailed below :

Flexible plastic	Very flexible plastic	
P565-755	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

Where a coloured sealer is required, P565-755 can be tinted with Turbo Plus (P488-) topcoat up to a ratio of 1 part P565-755 : 1 part Turbo Plus (P488-) topcoat. Then activate and thin according to the P565-755 process.

This information is given in good faith but without warranty.

For further information please contact:
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