

Product Data Sheet

November 2016

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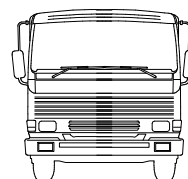
HP Chromate Free Epoxy Primer P580-3501/-3502/-3503/-3504

| <i>Product</i> | <i>Description</i> |
|----------------|---|
| P580-3501 | HP Chromate Free Epoxy Primer - White |
| P580-3502 | HP Chromate Free Epoxy Primer - Grey |
| P580-3503 | HP Chromate Free Epoxy Primer - Beige |
| P580-3504 | HP Chromate Free Epoxy Primer - Black |
| P275-3022 | Hardener for Epoxy Primer |
| P275-3025 | Plural Mix Hardener |
| P275-3027 | Plural Mix Hardener |
| P850-1480 | Thinner for HP C.F. Epoxy Primer |
| P850-1479 | Thinner for HP C.F. Epoxy Primer - Slow |

Product Description

P580-3501/-3502/-3503/-3504 are high performance amine cured epoxy primers. They are high solids and fast curing products with excellent adhesion properties and corrosion resistance over most common commercial transport substrates. In ready-for-use mode, the VOC content of this product is lower than 540 g/l.

P580-3501/-3502/-3503/-3504 are ideal under the Turbo Plus, HS Turbo Plus or EHS Turbo Plus topcoat range.



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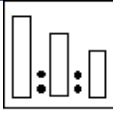






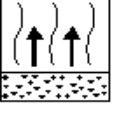



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Product Data Sheet



Process

| | HVLP and Conventional Application | Air Assisted Airless Spray | Airless Spray | |
|--|---|--|---|--|
|  | P580-350X 4 parts P275-3022 1 part Stir thoroughly before adding :- P850-thinners* 1.5 part *see list of thinners above | P580-350X 4 parts P275-3022 1 part Stir thoroughly before adding : P850-thinners 1 part | Plural or standard mix: P580-350X 4 parts P275-3022 1 part | Pluralmix only : P580-350X 2 parts P275-3027 1 part Or P580-350X 3 parts P275-3025 1 part |
|  | Pot life at 20°C: 4-6 hours Clean gun immediately after use Pot life at 20°C: 4-6 hours Clean gun immediately after use | | | Pot life at 20°C: N/A Clean gun immediately after use |
|  | 18 – 22 Seconds DIN4 (24 – 30 Seconds BSB4) | 30 – 35 s DIN4 (35 – 40 sec BSB4) | 71-85s DIN4 (110-130s BSB4) | 22 – 24 s DIN4 (26 – 32 seconds BSB4) With P275-3027 30 – 35 s DIN4 (35 – 40 seconds BSB4) With P275-3025 |
|  | Gravity or Suction feed: 1.4-1.8 mm Air cap pressure: 3.7-4.0 bar (55-60 psi) Pressure feed: 1.0-1.4 mm | | | |
|  | Gravity or Suction feed: 1.4-1.8 mm Air cap pressure: 0.675 bar (10psi) max. Pressure feed: 0.85-1.4 mm HVLP | | | |
|  | | Airless: 0.33-0.37 mm (13-15 thou) tip Approx. 140 bar (2000 psi) fluid pressure Air Assisted Airless: 0.33-0.37 mm (13-15 thou) tip Approx. 70 bar (1000 psi) fluid pressure Approx. 1.4-1.8 bar (20-25 psi) air cap pressure | | |
|  | 2 single coats to give 50-75 microns (2-3 thou) dry film thickness | 1-2 coats to give 75-100 microns (3-4 thou) dry film thickness | | |
|  | 10-15 minutes between coats, depending on dry film thickness and drying conditions Flash off 15-30 minutes before stoving | | | |
|  | Air Dry (20°C) : Dust free: 10-15 min. Tack free: 60 min. Hard dry: 16 hours | | Low Bake (60°C metal temperature): Hard dry: 60 min. | |
| Can be recoated wet-on-wet after a minimum of 1 hour air dry. After 7 days maximum but after 24 hours a thorough clean of the surface is recommended. | | | | |
|  | Wet Flattig: P600 or finer. | | | |
|  | Machine sanding: P240 or finer. | | | |

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Process

| Substrate | Preparation | Notes |
|--|---|--|
| Steel | Blast cleaning is the preferred surface treatment for maximum durability and optimum paint usage. Alternatively flat thoroughly using P80-P180 dry sanding machines discs or P120-P220 wet and dry paper, then clean with P850-1378 | Surface must be free from oil/grease, millscale and rust |
| Stainless Steel | Degrease with P850-1367 and scuff using P180-240 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378 | |
| Aluminium | Flat thoroughly using P240 dry sanding machine discs or Scotchbrite, then clean with P850-1378 | Not recommended over jointed aluminium sections. Please, seek advice from your local Nexa Autocolor representative |
| Sound Factory finishes Sound works primer Sound old finishes (2-pack) Sound electrocoat | Flat thoroughly using P240-P320 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378 | Old synthetic finishes must be well cured and non-bleeding |
| Weathered galvanised steel / Zintec | Clean with P273-901, degrease with P850-1367 and sand using Scotchbrite Fine or P180-P320 dry sanding machine discs | Surface must be free from oxidation residues |
| Hot dipped galvanised steel | Thoroughly degrease with P850-1367, scuff with Scotchbrite Fine or P400 wet and dry paper, then clean with P850-1378 | |
| 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 flattening GRP |

P580-350X series primers are NOT recommended for use over etch primers or thermoplastic substrates.

For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS Q0100.



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General Process Notes

RECOAT

Drying times will depend on film thickness and drying conditions. In common with other primers, longer drying times before recoat will improve final appearance. May be recoated with **Nexa Autocolor** Commercial Transport 2-pack primers/undercoats or directly topcoated with **Nexa Autocolor** Commercial Transport 2-pack topcoats. If topcoated with CT Aquabase P962-Line, it is important that P580-3501/-3502/-3503/-3504 are fully baked or left to dry overnight. See appropriate PDS for further details.

APPLICATION EQUIPMENT INFORMATION

HVLP

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

Air cap pressure : 0.675 bar (10 psi) maximum
Paint pressure : 0.3-1.0 bar (5-15 psi)
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 and excessive film thickness will extend the drying times. Overnight temperatures above 15°C are essential for the primer to fully cure.

COVERAGE (on ready-for-use paint)

At 4:1:1.5 : Approx. 7 m² per litre at a dry film thickness of 50 microns

At 4:1 : Approx. 9 m² per litre at a dry film thickness of 50 microns
Or 4,5 m² per litre at a dry film thickness of 100 microns

PLURAL MIX USE

Hardeners P275-3022 or P275-3027 can be used with these primers, when needed for plural mixing.
The mixing ratio is 4 parts primer to 1 part P275-3022
or 3 parts primer to 1 part P275-3025
or 2 parts primer to 1 part P275-3027.

P275-3022 is the slower hardener.
P275-3025 is the medium hardener
P275-3027 is the faster hardener.

Note: P275-3027 should ONLY be used in a plural mix situation, as it gives a short pot life.

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SPECTRAL GREYS

For each of the Spectral Grey primer variants specified the following mixing ratio applies:

| | Product number | Mix % (by wt.) | Mix Parts | Mix by Target Weight | | |
|-----|----------------|----------------|-----------|----------------------|--------|------|
| | | | | 100g | 250g | 500g |
| SG1 | P580-3501 | 100 | | 100g | 250g | 500g |
| | | | | | | |
| SG3 | P580-3501 | 90 | 9 | 90g | 225g | 450g |
| | P580-3502 | 10 | 1 | 10g | 25g | 50g |
| | | | | | | |
| SG5 | P580-3502 | 100 | | 100g | 250g | 500g |
| | | | | | | |
| | | | | | | |
| SG6 | P580-3502 | 70 | 7 | 70g | 175g | 350g |
| | P580-3504 | 30 | 3 | 30g | 75g | 150g |
| | | | | | | |
| SG7 | P580-3502 | 17 | 1.7 | 17g | 42.5g | 85g |
| | P580-3504 | 83 | 8.3 | 83g | 207.5g | 415g |

VOC INFORMATION

The EU limit value for this product (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 this product 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

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