

Product Data Sheet

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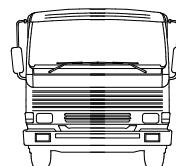
Transparent Sealer P565-755 – EHS System

Product	Description
P565-755	Transparent Sealer
P210-982	EHS Turbo Plus Hardener - Medium
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
P852-1790	EHS Turbo Plus additive Thinner – Slow
P852-1792	EHS Turbo Plus additive Thinner
P852-1794	EHS Turbo Plus additive Thinner - Fast
P100-1020	Flexible Additive

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 EHS Turbo Plus. Use over complete panels only.

When used in conjunction with EHS Turbo Plus hardener, the ready-for-use VOC content of this product is lower than 540 g/l.



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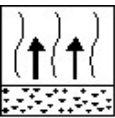
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Standard and Fast Process

HVLP and Conventional Application		
USAGE	Adhesion Promoter Sealer	Coloured Sealer/Undercoat
Tinting prior to activating		Tint with EHS Turbo Plus (P498-) Maximum Ratio 10 parts P565-755 :1 Part P498
	P565-755 5 parts P210-982 1 part P850-13XX-17XX 3 parts	P565-755 5 parts P210-982 1 part P850-13XX-17XX 3 parts
	Pot life at 20°C: 4 hours Clean gun immediately after use	Pot life at 20°C: 4 hours Clean gun immediately after use
	19-20 secs. DIN4 at 20°C	19-20 secs. DIN4 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 Use compliant spray equipment	1.0-1.4 mm Use compliant spray equipment
	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 EHS Turbo Plus P498-line	Follow after flash-off time with EHS Turbo Plus P498-line

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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 Q0100.

SUBSTRATES 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:	SUBSTRATES:	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	Existing 2-pack paintwork	
Bare GRP/”Glasonite”	Clean with P273-901 BodyKleen. Flat thoroughly using P240-P320 dry sanding machine discs or P400-P600 wet and dry paper, then clean with P850-1378.	Take care not to break through the gel coat when flatted GRP.
Fillers	Flat thoroughly with P280-P320 dry sanding machine discs then clean with P850-1378.	

RECOAT:

P565-755 may be recoated with EHS 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

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.

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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 2 days without flattening prior to recoating. However, if left longer than 2 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).

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 primed 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 EHS Turbo Plus (P498-) topcoat up to a ratio of 10 parts P565-755 : 1 part EHS Turbo Plus (P498-) topcoat. Then activate and thin according to the P565-755 process.

OTHER POINTS TO NOTE

1. Do **NOT** use P275-455 EHS Turbo Plus Rapide with P565-755.



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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.

Note:

Combinations of this product with P100-2020, will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre.

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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