

Product Data Sheet

July 2017



INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY

H5681V

Speed Surfacer P565-5801, P565-5805 & P565-5807

<i>Product</i>	<i>Description</i>
P565-5801	Speed Surfacer – White SG 01
P565-5805	Speed Surfacer – Grey SG05
P565-5807	Speed Surfacer – Dark Grey SG07
P210-8815	2K HS Hardener - Fast
P852-1678	Accelerator Thinner for Speed Surfacer
P852-1690	Accelerator Thinner (For high temperature application)
P850-1694	Slow Thinner for IR

Product Description

Speed Surfacer combines process speed and ease of application with excellent sanding properties. Speed Surfacer is a primer that is incredibly fast and easy to apply, with excellent sanding properties. It has a quick and user-friendly one visit application (with little or no flash off), and air dries in less than an hour; improving bodyshop efficiency without compromising on the quality of the final finish.

Speed Surfacer is available in three spectral grey shades (and can be mixed to provide further shades) in order to be able to provide the optimum spectral grey for every color. This further improves productivity and profitability by reducing basecoat consumption.

SUBSTRATES AND PREPARATION

The P565-580X surfacers should only be applied over :

Well sanded and degreased bare steel. Use *Nexa Autocolor* 2-pack Etch Primer or 2-pack Epoxy Primer for maximum durability. Aluminium **must** be Etch or Epoxy primed.

Well sanded GRP, polyester fillers works primer and old finishes in sound condition.

Good preparation is vital in order to obtain the best results from these products.
The following grades of sanding paper are recommended for substrate preparation: -

Wet or dry paper	P280 - P320 (GRP P400)
Dry machine sanding	P180 - P240

NOTE: Not recommended for spot repairs over thermoplastic acrylic, old lacquer finishes or sensitive substrates. Over these substrates, apply to complete panels only.

Process		
	<p>Air-dry at 20°C: 1 hour</p>	<p>Air-dry below 20°C: 1 hour</p>
	<p>Baking at a metal temperature of 60°C: 20 – 25 minutes depending on film thickness</p>	
	<p>High Wave: 12 minutes P850-1694 to be used for IR drying process. Allow P565-580X surfacers to flash off for 5 minutes before drying with the infrared lamp. Drying times will depend on the type of infrared lamp used. Max 120 microns, when using force dry process.</p>	
	<p>Finish with the following grades: - P360 or finer: Single layer solid colours (Direct Gloss) P400 or finer: Basecoats</p>	
	<p>Finish with the following grades: - P600 or finer: Single layer solid colours (Direct Gloss) P800 or finer: Basecoats</p>	
TOPCOAT	<p>P565-580X surfacers can be topcoated with <i>Nexa Autocolor 2K</i> topcoat systems. If P565-580X surfacers are left for more than 2 days after sanding, they should be sanded again prior to application of further undercoat or topcoat.</p>	

Process

SPECTRAL GREYS

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

	Product number	Mix % (by wt.)	Mix by Target Weight		
			100g	250g	500g
SG01	P565-5801	100	100g	250g	500g
SG03	P565-5801	58	58g	145g	290g
	P565-5805	42	42g	105g	210g
SG05	P565-5805	100	100g	250g	500g
SG06	P565-5805	48	48g	145g	240g
	P565-5807	52	52g	105g	260g
SG07	P565-5807	100	100g	250g	500g

CHOICE OF HARDENER AND THINNER

The choice of thinner should be made according to application temperature, air movement and size of job. The recommendations below are for guidance only :-

Hardener:

P210-8815
P210-8815

Thinner:

P852-1678
P852-1690

Ideal temperature range:

Below 25°C
Over 30°C



Process

Weight Activations for use with HS hardeners (P210-8815) Ratio 7 : 1 : 2

Please note the weights are cumulative. Do not tare or zero scale between additions

RFU Sprayable Volume	P565-5801 Grams	P210-8815 Grams	P852-1678/90 P850-1694 Grams
1.0L	1019	1125	1297
RFU Sprayable Volume	P565-5805 Grams	P210-8815 Grams	P852-1678/90 P850-1694 Grams
1.0L	921	1027	1198
RFU Sprayable Volume	P565-5807 Grams	P210-8815 Grams	P852-1678/90 P850-1694 Grams
1.0L	929	1035	1207

Flexible Additive Weight Activations for use with HS hardeners (P210-8815)

Please note the weights are cumulative. Do not tare or zero scale between additions

RFU Sprayable Volume	P565-5801	P100-2020	P210-8815	P852-1678/90 P850-1694 Grams
1.0L	820	950	1059	1239
RFU Sprayable Volume	P565-5805	P100-2020	P210-8815	P852-1678/90 P850-1694 Grams
1.0L	741	871	980	1159
RFU Sprayable Volume	P565-5807	P100-2020	P210-8815	P852-1678/90 P850-1694 Grams
1.0L	748	877	986	1166

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.

Nexa Autocolor[®], ZK[®], Aquabase[®], Aquadry[®] and Ecofast[®] are registered marks of PPG Industries Ohio, Inc.
Copyright © 2015 PPG Industries Ohio, Inc. All rights reserved.
Copyright in the above product numbers that are original is asserted by PPG Industries Ohio, Inc..



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: www.nexaautocolor.com

For further information please contact:

Customer Service Sales Group
PPG Industries (UK) Ltd
Needham Road
Stowmarket
Suffolk IP14 2AD

Tel: 01449 771771

Fax: 01449 773472

Nexa Autocolor[®], ZK[®], Aquabase[®], Aquadry[®] and Ecofast[®]
are registered marks of PPG Industries Ohio, Inc.
Copyright © 2015 PPG Industries Ohio, Inc. All rights reserved.
Copyright in the above product numbers that are
original is asserted by PPG Industries Ohio, Inc..

Page 7 of 7

