Technical Data Sheet U3800V

May 2022

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

Universal 2K Primer

Product	Description
P565-38xx	Universal 2K Primer – Light Grey
P565-3880	Universal 2K Primer – Dark Grey
P210-987	EHS Plural Mix Hardener
P210-982	EHS Turbo Plus Hardener - Medium
P210-9652	EHS Turbo Plus Medium Hardener
P852-1792	EHS Thinner - Medium
P852-1790	EHS Thinner - Slow
SPP4000	Potlife Extender

Product Description

Universal 2K Primer P565-38xx, is based on the latest technical developments in primer technology, and should be used where optimisation of the repair and building processes are key requirements.
Universal 2K Primer is designed for use under **2K EHS Turbo Plus topcoat (P498)** or Aquabase Plus basecoat (P989) provides a truly productive process.
This product can be applied direct to metal or over a Wash-Etch primer and can be topcoated up to five days later without the need for primer sanding.

The strong adhesion and anti-corrosion properties of Universal 2K Primer, P565-38xx allows application directly to bare metal as long as high build mode is respected.

Substrates must be properly prepared and cleaned according to substrate preparation process recommendations.

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Substrates and Preparation

Prepare the Substrate as follows:

Substrates:	Sanding:
Steel	Sanded with P80-150
Shot Blasted Steel	SA 2,5 (Rz not above 35µm)
Aluminium (*)	Sanded with P360-P400 or shot Blasted (Rz not above 35µm)
Anodized Aluminium	Without any mechanical treatment
Galvanised Steel	Scuffed with Scotch Brite® Red pads
Stainless Steel	Sanded with P80-P150
GRP	Sanded with P320-400
OE Finishes and Aged painted surfaces	Sanded with P320-400

(*) 3003 – 1050 alloys have been evaluated

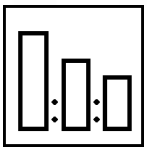
Cleaning:

The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.

Substrates need to be thoroughly wiped using the appropriate degreaser (P850-1367 Degreaser & P850-1378 Spirit Wipe or P980-9010 low V.O.C cleaner)

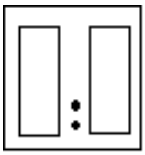
Process

Conventional or Pressure Pot or Air Assisted Airless Application



Activation ratio by volume

P565-38xx	3,5 parts
P210-982 or -9652	1 part
P852-179x or SPP4000	1-1,5 parts



Pluralmix option 1, ratio by Volume:

Prethin first as: *

P565-38xx	10 parts
P852-179x or SPP4000	1 part

Then activate prethinned primer as:

Prethinned Primer:	2,75 parts
P210-987	1 part

Pluralmix option 2, ratio by Volume:

Prethin first as: *

P565-38xx	3,5 parts
P852-179x or SPP4000	1 part

Then activate prethinned primer as:

Prethinned Primer:	4,5 parts
P210-982 or P210-9652	1 part

***The Primer can remain prethinned in the original pail for maximum one month**

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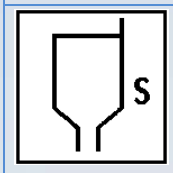
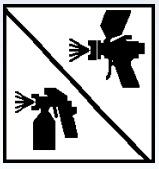
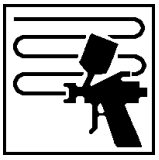
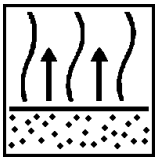
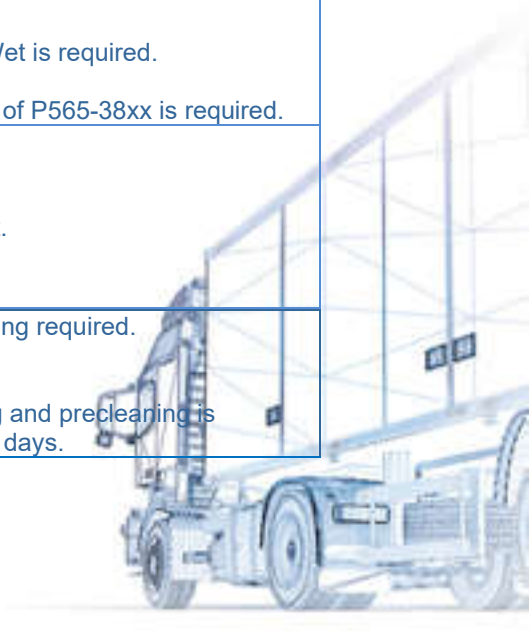
Process

	Conventional, Pressure Pot or Air Assisted Airless Application
	Spray Viscosity at 20°C: 28-32 seconds DIN4
	Potlife @20°C: 2 hours Spraybable time @20°C: 1 Hour
	1,6-1,8 mm Gravity or suction feed at 2.0-2.5 bars OR 1.1-1.2 mm Pressure Pot Air Cap Pressure: 0.68 bar Paint Pressure : 0.3-1.0 bar Fluid flow rate: 280-320 cc/min OR Tip Size: 11 to 13 Thou (0,23 to 0,28 mm) for Air Assisted Airless Paint Pressure: 100-120 bars Air Atomization: 2,5-3,5 bars
	**Number of Coats** Apply 2 full coats This gives a film thickness of minimum 65 microns Or: 1 light coat followed immediately by 1 full coat to give 45µm Dry Film thickness (aluminium only). 100-125 µm Wet is required. If sprayed over a wash/etch primer, 25-35 µm Dry Film thickness of P565-38xx is required.
	10-15 minutes minimum Minimum 30 minutes at 20°C before topcoating or until fully matt.
	Ready for topcoat after 30 minutes, or up to 5 days with no sanding required. For any other need force dry before sanding. If left more than 8 hours, then preclean before topcoating If left more than 24 hours before topcoating, then light de-nibbing and precleaning is recommended. Sand with P400 dry or finer if left for more than 5 days.



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General Process Notes

CHOICE OF HARDENER AND THINNER
The exact choice of hardener and thinner combination will depend on the gun set-up used, air movement, size of repair, temperature and application conditions. However, below is a general guide :

Hardener	Temperature Range	Recommended Thinner
P210-982 or -9652	Below 18°C	P852-1792
P210-982 or -9652	Below 25°C	P852-1790 or SPP4000
P210-982 or -9652	Above 25°C	P852-1790 or SPP4000

Health and Safety

The EU limit value for these products (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 these products 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 Heath and Safety information please refer to the material Safety Data Sheet, also available at: **http://www.ppg.com/Autocolor_MSDS**

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