



Technical Data Sheet

May 2022

U3800V_TV

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

Universal 2K Primer – Light Grey P565-38xx	
Product	Description
P565-3800	Universal 2K Primer – Light Grey
P565-3880	Universal 2K Primer – Dark Grey
P210-7642	EHS Hardener - Slow
P210-7606	EHS Plural-Mix Hardener
P852-6440	EHS Thinner - Extra Slow
P852-6442	EHS Thinner - Slow
SPP4000	Potlife Extender

Product Description

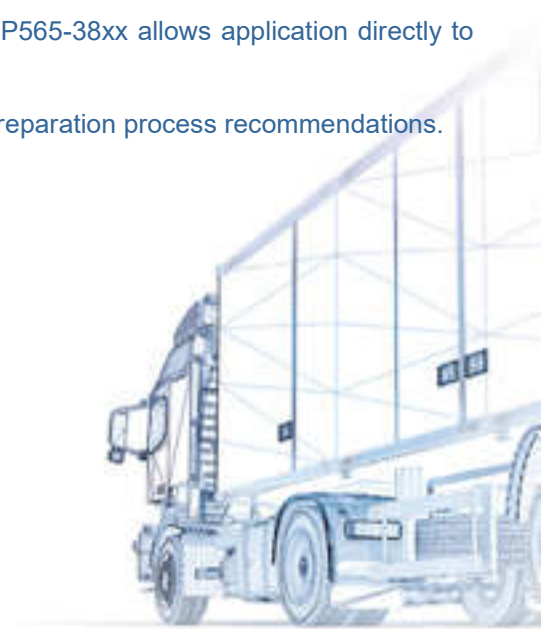
Universal 2K Primer P565-38xx, is based on the latest technical developments in primer technology, and should be used where optimisation of the repair and building processes are key requirements.

Universal 2K Primer is designed for use under **TURBO VISION® Topcoats** (P650) 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.

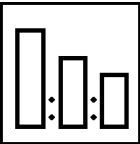


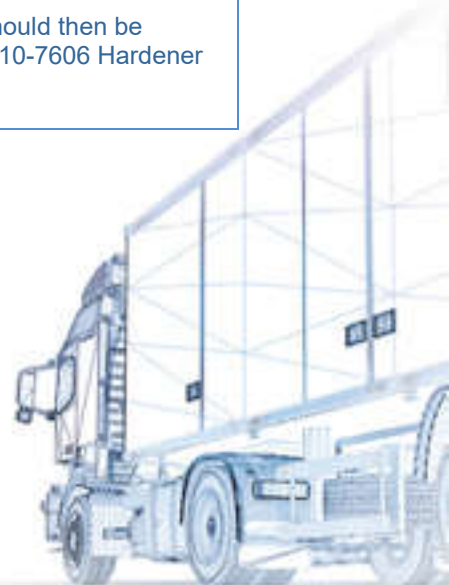
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Substrates and Preparation

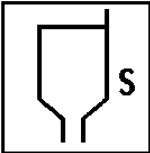

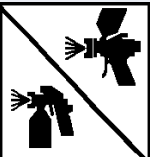





Prepare the Substrate as follows:		Cleaning:
Substrates:	Sanding:	
Steel	Sanded with P80-150	<p>The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.</p> <p>Substrates need to be thoroughly wiped using the appropriate degreaser (P850-1367 Degreaser & P850-1378 Spirit Wipe or P980-9010 low V.O.C cleaner)</p>
Shot Blasted Steel Aluminium (*)	SA 2,5 (Rz not above 35µm) Sanded with P360-P400 or shot Blasted (Rz not above 35µm)	
Anodized Aluminium Galvanised Steel	Without any mechanical treatment Scuffed with Scotch Brite® Red pads	
Stainless Steel GRP	Sanded with P80-P150 Sanded with P320-400	
OE Finishes and Aged Paintwork	Sanded with P320-400	
(*) 3003 – 1050 alloys have been evaluated		

Process

	Conventional or Pressure Pot or Air Assisted Airless Application													
	Standard Process	Plural-Mix Process												
	Activation ratio by volume	Activation ratio by volume												
	<table border="0"> <tr> <td>P565-38xx</td> <td>4 parts</td> </tr> <tr> <td>P210-7642</td> <td>1 part</td> </tr> <tr> <td>P852-644x or SPP4000</td> <td>0.75-1.25 parts</td> </tr> </table>	P565-38xx	4 parts	P210-7642	1 part	P852-644x or SPP4000	0.75-1.25 parts	<table border="0"> <tr> <td>P565-38xx</td> <td>3 parts</td> </tr> <tr> <td>P210-7606</td> <td>1 part</td> </tr> <tr> <td>P852-644x or SPP4000</td> <td>0.3 – 0.7 parts</td> </tr> </table> <p>For 2K Plural-mix equipment it is recommended to pre-thin the primer 3 : 0.5 with Thinner. The pre-thinned paint should then be activated 3.5 : 1 with P210-7606 Hardener</p>	P565-38xx	3 parts	P210-7606	1 part	P852-644x or SPP4000	0.3 – 0.7 parts
P565-38xx	4 parts													
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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 Sprayable 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 dry. Or: 1 light coat followed immediately by 1 full coat to give 45µm Dry Film thickness (aluminium only). 100-125 µm wet film thickness 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 Turbo Vision topcoats after 30 minutes, or up to 3 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 3 days.



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TOPCOAT	P565-38xx can be directly topcoated with TURBO VISION® Topcoats (P650) or Aquabase Plus basecoat (P989).
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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
P210-7642	Below 18°C	P852-6442
P210-7642	Below 25°C	P852-6440 or SPP4000
P210-7642	Above 25°C	P852-6440 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 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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