

Product Data Sheet

November 2022



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

U0370V_TV

HS Wet on Wet Undercoat P565-370X

Product	Description
P565-3701	HS Wet on Wet Undercoat White SG01
P565-3705	HS Wet on Wet Undercoat Grey SG05
P565-3707	HS Wet on Wet Undercoat Grey SG07
P210-7644	EHS Hardener - Standard
P210-7642	EHS Hardener - Slow
P210-7606	EHS Plural-Mix Hardener
P852-6442	EHS Thinner - Slow
P852-6444	EHS Thinner - Medium
P852-6446	EHS Thinner - Fast

Product Description

HS Wet on Wet Undercoat , P565-370x, 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.

HS Wet on Wet Undercoat is designed for use under **Aquabase Plus** basecoat (P989), **2K EHS Turbo Plus** topcoat (P498) and **TURBO VISION® 2-pack Premium High Flow EHS Topcoat** (P650) provides a truly productive process that removes the need for sanding.

This product can be applied direct to Electrocoat and can be topcoated up to five days later without the need for primer sanding.

Excellent application combined with the excellent levelling properties provide a high quality finish, equivalent to that provided by a traditional sanded primer, and delivers a non-sanding route to optimise the whole repair process.

Especially valuable for new panel work, HS Wet on Wet Undercoat allows booth utilisation to be optimised by providing the opportunity for priming new panels in advance in small batches, ready for topcoating at the same time as the vehicle.

The strong adhesion and anti-corrosion properties of HS Wet on Wet Undercoat allows small rub-through areas of bare metal to be primed without the need for an Etch Primer, again saving a step in the repair process.

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Process

	<p>Standard Process Activation ratio by volume</p> <p>P565-370x 4 parts P210-764x 1 part P852-644x 2 parts</p>	<p>Plural-Mix Process Activation ratio by volume</p> <p>P565-370x 3 parts P210-7606 1 part P852-644x 1.2 parts</p> <p>For 2K Plural Mix Equipment it is recommended that P565-370X is pre-thinned 3 : 1.2 with Thinner. The pre-thinned paint should then be activated 4.2 : 1 with P210-7606 Hardener</p>
	<p>Activated viscosity: 17 - 20 seconds DIN4</p> <p>Pot-life: 60 min at 20°C. Clean gun immediately after use</p>	
	<p>Fluid Tip Gravity Fed : 1.3-1.4 mm Pressure : 3.0 – 3.7 bar (45 – 55 psi)</p>	
	<p>Fluid Tip Gravity Fed : 1.3-1.4 mm Pressure : 2 – 2,25 bar (30-35 psi)</p>	
	<p>Fluid Tip Gravity Fed : 1.3-1.4 mm</p> <p>Inlet Pressure : Refer to spraygun manufacturers instructions, (Normally 2 bar/30 psi at gun inlet)</p>	
	<p>Apply 1 full single coat or 1 light + 1 full This gives a film thickness of approximately 25-35 microns (1.0 - 1.4 thou.)</p> <p>Apply to achieve an even finish. Do not apply heavy coats.</p>	
	<p>No flash off between coats is necessary where a single visit application is used. 10-15 minutes flash-off is necessary when applied in 2 coats.</p> <p>Minimum 25 minutes at 20°C before topcoating at a film thickness of 25-35 microns (1.0 - 1.4 thou.)</p>	
	<p>Ready for topcoat after 25 minutes, or up to 5 days with no sanding required. If some dirt inclusion occurs, light dry flattening / de-nibbing can be carried out after first coat of Aquabase Plus, using P800 or finer with foam pad.</p> <p>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.</p>	
<p>TOPCOAT</p>	<p>P565-370X can be directly topcoated with Aquabase Plus basecoat (P989) or 2K EHS Turbo Plus topcoat (P498) or TURBO VISION® 2-pack Premium High Flow EHS Topcoat (P650)</p>	

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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
P210-7644	Below 18°C	P852-6446
P210-7644	Below 25°C	P852-6444
P210-7644	Above 25°C	P852-6442
	Above 25°C	
P210-7642	(or very large surface)	P852-6442

HS WET ON WET UNDERCOAT CAN BE USED IN PRIMER FILLER MODE USING THE FOLLOWING RECOMMENDATIONS

Mix and use the gun set up as recommended in the main Process note.
 Apply 1 light + 2 full coats
 This gives a film thickness of approximately 60-70 microns

Bake for 30 minutes at 60°C metal temperature.
 IR medium wave 5 min flash-off, followed by a 10 min cure time.
 IR/GAS 50 cm 110°C.

After cooling dry sand with P400 or finer

SUBSTRATES AND PREPARATION

HS Wet on Wet Undercoat should only be applied over:

- Well cleaned un-sanded Electrocoat.
- Bare steel areas up to 10cm diameter without the need for an Etch Primer
- Galvanised Steel for rub throughs up to 10cm maximum diameter
- Zintec for rub throughs up to 10cm maximum diameter
- Aluminium and alloys for rub throughs up to 10cm maximum diameter
- Aged painted and original surfaces sanded with P320 or finer
- GRP, Fibreglass sanded P120/ P240/P320
- Polyester Filler P120/ P240/P320

Note: A 2-pack Etch Primer should be applied prior to the application of HS Wet on Wet Undercoat for areas of bare metal above 10cm diameter, area's particularly vulnerable to corrosion or for OEM warranty standard corrosion performance.

PAINTING PLASTICS

HS Wet on Wet Undercoat can be applied directly over well prepared and cleaned ABS, NORYL, PC/PBT, LEXAN, PUR and SMC, as well as sanded and pre-primed bumpers.

Large bare plastic sections or rub through areas on bumpers, e.g. PP, TPO, PP/EPDM should be primed first with a light coat of P572-2001 Plastic Primer, and flashed off 10 minutes before the application of HS Wet on Wet Undercoat

DEGREASING

Substrates must be cleaned thoroughly with a suitable Nexa Autocolor cleaner.
 The substrate cleaner must be wiped off the panel surface immediately using a clean dry cloth.

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Mixing Spectral Grey Range

% by wt.	SG1	SG3	SG5	SG6	SG7
-3701	100	75	--	--	--
-3705	--	25	100	48	--
-3707	--	--	--	52	100

Note: The mixed Spectral Grey shade must be activated and thinned as normal.

COVERAGE

Approximately 8,5 to 12 m² per litre of ready for use paint at a dry film thickness of 25-35µm dry film thickness.

INFORMATION

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:

www.nexaautocolor.com

For further information please contact:

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