

# Product Data Sheet

March 2023

INTERNATIONAL MASTER  
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# U1130V\_TV

## HS High-Build, Primer Surfacer P565-1027 /1028 - Grey / White

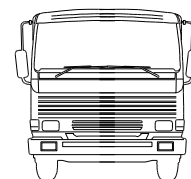
Product	Description
P565-1027/8	HS High Build, Primer Surfacer – Grey / White
P210-7644	EHS Hardener - Standard
P210-7642	EHS Hardener - Slow
P210-7606	EHS Plural-Mix Hardener
P852-6442	EHS Thinner - Slow
P852-6444	EHS Thinner - Medium
P852-6446	EHS Thinner - Fast
P852-6448	EHS Thinner - Extra Fast
P100-2020	Flexible Additive for Plastics

### Product Description

P565-1027 and P565-1028 HS High-build, Primer are high performance 2-Pack undercoats for use under Nexa Autocolor 2-Pack topcoats.

When used with TURBO VISION® 2-pack Premium High Flow EHS ancillaries, P565-1027/1028 has a ready-for-use VOC of less than 540g/l.

P565-1027 P565-1028 HS High-build, Primer have been specifically designed for application over large areas. They can be used in wet-on-wet and high-build modes and when dry have excellent flattening characteristics.



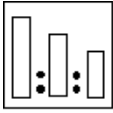




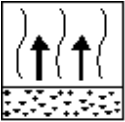



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## Standard and Fast Process

EHS Mode (Below 540g/L VOC)					
	<p><b>Standard Build Mode</b> P565-1027/1028      8 parts</p> <p>P210-764x      1 part</p> <p>P852-644x      1.5 parts</p> <p><b>High Build Mode</b> P565-1027/1028      8 parts</p> <p>P210-764x      1 part</p> <p><b>See separate note on page 4 for use with EHS Plural Mix Hardener P210-7606</b></p>				
	<p>Pot life at 20°C: 1 hour</p> <p><b>Clean gun immediately after use</b></p>				
	<p><b>Standard Build</b> 23-29s. DIN4 (35-45s. BSB4)</p>				
	<p><b>Gravity or Suction feed:</b> 1.6-1.8 mm Air cap pressure: 3.7-4.0 bar (55-60 psi)</p> <p><b>Pressure feed:</b> 1.0-1.4 mm</p>				
	<p><b>Gravity or Suction feed:</b> 1.6-1.8 mm Air cap pressure: 0.675 bar (10psi) max.</p> <p><b>Pressure feed:</b> 0.85-1.4 mm HVLP/compliant</p>				
	<p>10-15 minutes between coats, depending on dry film thickness and drying conditions</p> <p>Flash off 15-30 minutes before stoving</p>				
	<table style="width: 100%; border: none;"> <tr> <td style="width: 50%; vertical-align: top;"> <p><b>Air Dry (20°C) :</b></p> <p>Dust free:      10-15 min.</p> <p>Tack free:      30-60 min.</p> <p>Hard dry:      4 hours</p> </td> <td style="width: 50%; vertical-align: top;"> <p><b>Low Bake (60°C metal temperature):</b></p> <p>Hard dry: 30 min.</p> </td> </tr> </table> <p><b>Can be recoated wet-on-wet after a minimum of 30 min air dry</b> <b>If recoating with Turbo Plus metallic basecoat, allow at least two hours drying time otherwise lifting of the paint film may occur.</b></p>	<p><b>Air Dry (20°C) :</b></p> <p>Dust free:      10-15 min.</p> <p>Tack free:      30-60 min.</p> <p>Hard dry:      4 hours</p>	<p><b>Low Bake (60°C metal temperature):</b></p> <p>Hard dry: 30 min.</p>		
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	<p><b>Wet Flattening:</b></p> <table style="width: 100%; border: none;"> <tr> <td style="width: 50%;">P600 or finer</td> <td>Solid Colours</td> </tr> <tr> <td>P860 or finer</td> <td>Basecoats.</td> </tr> </table>	P600 or finer	Solid Colours	P860 or finer	Basecoats.
P600 or finer	Solid Colours				
P860 or finer	Basecoats.				
	<p><b>Machine sanding:</b></p> <table style="width: 100%; border: none;"> <tr> <td style="width: 50%;">P240 or finer</td> <td>Solid Colours.</td> </tr> <tr> <td>P360 or finer</td> <td>Basecoats</td> </tr> </table>	P240 or finer	Solid Colours.	P360 or finer	Basecoats
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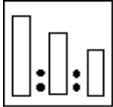



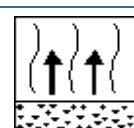





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**Express Mode (Below 540g/L VOC)**

 <p>Standard build mode</p>	<p>P565-1027/1028                      8 parts                  P210-7644                              1 part                  P852-6448                              1.5 parts</p>
	<p>Pot life at 20°C: 15 mins.   <b>Clean gun immediately after use</b></p>
	<p><b>Standard Build</b>                  23-29s. DIN4                  (35-45s. BSB4)</p>
	<p><b>Gravity or Suction feed:</b>                  1.6-1.8 mm                  Air cap pressure: 3.7-4.0 bar (55-60 psi)   <b>Do not use in pressure feed system</b></p>
 <p>HVLP</p>	<p><b>Gravity or Suction feed:</b>                  1.6-1.8 mm                  Air cap pressure: 0.675 bar (10psi) max.   <b>Do not use in pressure feed system</b></p>
	<p>5 minutes between coats, depending on dry film thickness and drying conditions                   Flash off 5-10 minutes before stoving</p>
	<p><b>Force Dry / Low Bake</b>                   30°C -: 20 min.                  40°C -: 10 min.                   Flattable as soon as cooled.</p>
	<p><b>Wet Flattting:</b>                  P600 or finer                      Solid Colours                  P860 or finer                      Basecoats.</p>
	<p><b>Machine sanding:</b>                  P240 or finer                      Solid Colours.                  P360 or finer                      Basecoats</p>

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## General Process Notes

**NOTE:**

**Not recommended for use directly to metal.  
For metal substrates use Etch Primer and refer to relevant TDS**

**SUBSTRATES:**

Etch Primer  
Sound Factory finishes  
Sound works primer  
Sound old finishes (2-pack)  
Sound electrocoat  
GRP  
"Glasonite"

**PREPARATION:**

For Etch Primer, apply directly after the required flash-off time (See etch primer TDS)  
  
For other listed substrates, flat thoroughly using P240- P320 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378

**RECOAT**

Drying times will depend on film thickness and drying conditions. In common with other primers, longer drying times before recoat will improve final appearance.  
  
Topcoat with TURBO VISION® 2-pack Premium High Flow EHS Topcoat or EHS Turbo Plus or CT Aquabase  
Also may be recoated with any other Nexa Autocolor Commercial Transport 2-pack topcoat  
  
When using CT Aquabase (P962-Line), it is important that P565-1027/1028 is hard dry prior to application of the Aquabase basecoat .

**PREPARATION**

For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS Q0100.

**PLURAL-MIX USE**

P565-1027 / 1028 can be used with P210-7606 EHS Plural-mix Hardener

P565-1027 / 1028	6 parts
P210-7606	1 part
P852-644x	0-1 part

For 2K Plural-Mix Equipment, it is recommended to use unthinned at 6:1

If thinning is required it is recommended to pre-thin the primer 6:1 with Thinner  
The thinned paint should then be activated 7:1 with P210-7606 Hardener

**COVERAGE**

At a film thickness of 80 microns – 4.1 m<sup>2</sup>/litre

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**SPECTRAL GREYS**

These primers may be blended as below to give a range of Spectral Greys.

	SG01	SG03	SG05	SG06	SG07
P565-1027 - Grey	-	100g	99.5g	97.5g	88.5g
P565-1028 - White	100g	-	-	-	-
P170-5670 - Black Paste	-	-	0.5g	2.5g	11.5g

**PAINTING PLASTICS**

P565-1027/1028 can be used over the appropriate plastics primer, when painting plastic parts, to give build.

When used over very flexible plastics these primers should be mixed:

- 8 parts P565-1027/1028
- 2 parts P100-2020 Flexible Additive for Plastics
- 1.5 parts P210-7644 or P210-7642 Hardener
- 2.5 parts Thinner

Note: The use of the flexible Additive will extend drying times

**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.

**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](http://www.ppg.com/Autocolor_MSDS)

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