

Product Data Sheet

November-2023

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY

H5685V

Eco-Dry Primer

<i>Product</i>	<i>Description</i>
P565-5811/15/17	Eco-Dry Primer
P210-8820	Hardener
P850-1700	STD Thinner
P850-1701	HT Thinner

Product Description

The new Eco-Dry Primer has been developed to reinforce NEXA AUTOCOLOR® brand's position as a market leader of quality products. The aim of Nexa Autocolor is to constantly build its reputation through the delivery of leading-edge, innovate products, outstanding colour quality and repair process efficiency.

This new Primer range has been designed by Nexa Autocolor to provide incredible benefits to the brand thanks to the launch of a new technology that provides an eco-friendly product in the Premium offer.

This new Primer is launched in three grey shades and alongside dedicated ancillaries: one hardener and two thinners allowing great performance in both low and high temperatures with a simple 3:1:0.5 simple mixing ratios.

The new Eco Primer is VOC Compliant to the European VOC regulative.

Main characteristic of this new primer is the fast-Air-drying, and the excellent sanding properties.

Easy to apply in one visit application.

Application in 1 light coat followed by 2-4 full coats without flash-off

SUBSTRATES AND PREPARATION

Bare Metal should be lightly abraded, degreased and completely rust free before application.

Air-Dry Primer, P565-5811/15/17 may be applied directly to small areas of bare steel

For larger size of bare steel use ADHW-50 Adhesion wipes.

ADHW-50 Adhesion Wipe Process:

Apply the cloth to the bare, previously well cleaned metal substrate (ADHW-50 is not a cleaning cloth!) and allow it to flash off until matt before applying the Air-Dry Primer.

For optimum adhesion and corrosion protection use Wash-etch- or Epoxy-Primers.

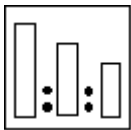
If epoxy primer is used, ensure sufficient flash-off time or allow to dry completely before applying Eco-Dry-Primer.

Plastics:

➤ P565-581X can be applied directly to common automotive plastics.

*NOTE P471- Direct Gloss, is not recommended as topcoat on plastic substrate.

Process

**PRIMER**

P565-8511/15/17 Eco-Dry Primer	3 parts
P210-8820 Hardener	1 part
P850-1700 Std. or 1701 HT.	0,5 part

NOTE: FOR ACCURATE ACTIVATION AND THINNING, WEIGHT MIXING IS RECOMMENDED
SEE PAGE 4



Activated viscosity: 17 - 18 secs DIN4 @ 20°C (Double viscosity in 45 min.)

Pot-life: 30 min at 20°C

Clean gun immediately after use

**Fluid Tip**

Gravity Fed:	1,4- 1.6 mm (not higher)
Inlet Pressure:	Refer to spraygun manufacturers recommendation (normally 2 bar / 30 psi).

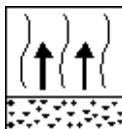
**Fluid Tip**

Gravity Fed: 1.4-1,6 mm not higher (except Iwata HVLP 1.7mm)
 Pressure: Refer to spraygun manufacturers' recommendation
 (0.7 bar / 10 psi max at air cap).



One visit Application
 1 light & 2-3 full coats (max. 4 coats if necessary)

The first coat should be applied as a light closed coat.
 Second and third is applied as full coats.



Flash off between coats after first coat, allow 10-15 sec. flash off.
 All other coats is applied in one visit.

***Note; A fourth coat is possible but for sensitive surface avoid heavy layers.**

**Air-dry at 20°C:**

2½ coats Air Dry in 30 min. 80-100 micron DFT
 3½ coats Air Dry in 35 min. 100-120 micron DFT
 4½ coats Air Dry in 40 min. 120-140 micron DFT



IR Shortwave: 1 min flash followed by 5 min @ 50% efficiency

5-10 min @ 60 °C
 10-15 min @ 50°C
 15-20 min @ 40 °C


***Note:** When using etch primer for optimum adhesion and corrosion drying time will be slight longer.

**Finish with the following grades: -**

P400 or finer: Single layer solid colours (Direct Gloss)
 P400 or finer: Basecoats

Use 1K aerosols for rub-through areas during/after filler sanding.
 For the correct final sanding and the respective 1K Primer version, take the PDS of the base- topcoat into account.

SPECTRAL GREYS

	<p>Finish with the following grades: -</p> <p>P800 or finer: Single layer solid colours (Direct Gloss)</p> <p>P800 or finer: Basecoats</p>
<p>TOPCOAT</p>	<p>P565-5811/15/17-Eco-Dry Primer can be top coated with Nexa Autocolor Aquabase Plus (P989).</p> <p><u>Plastics: P471- Direct Gloss is not recommended as topcoat on plastic substrate.</u></p>

Process

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

	G1	G3	G5	G6	G7
P565-5811	100	80	--	--	--
P565-5815	--	20	100	20	--
P565-5817	--	--	--	80	100

MIXING BY WEIGHT:

The weights are cumulative - please do NOT tare the balance between additions.

Volume of RFU primer required (Litres)	Wt. Primer Grams (3 Parts)	Wt. Hardener Grams (1 Part)	Wt. Thinner (STD) Grams (0,5 Part)	Wt. Thinner (HT) Grams (0,5 Part)
0.25 L	280,0	335,8	360,3	360,8
0.5 L	560,0	671,7	720,5	721,5
0.75 L	840,0	1007,5	1080,8	1082,3
1.0 L	1120,0	1343,3	1441,0	1443,0
1.5 L	1680,0	2015,0	2161,5	2164,5

GUIDE TO USING ECO-DRY PRIMER AS A ROLL PRIMER

MIXING RATIO

Mixing Ratios – If scales are not available, then primer may be activated by volume.

By Volume

P565-5811/15/17 3 vol

P210-8820 1 vol

Pot life at 20°C: 40 minutes.

Note: It is recommended to use the material immediately after mixing.

Clean the roller tray immediately after use.

MIXING BY WEIGHT

The weights are cumulative - please do **NOT** tare the balance between additions.

Volume of RFU paint required (Litres)	Wt. Primer Grams (3 Parts)	Wt. Hardener Grams (1 Part)
0.25 L	280,0	335,8
0.5 L	560,0	671,7
0.75 L	840,0	1007,5
1.0 L	1120,0	1343,3
1.5 L	1680,0	2015,0

APPLICATION AND FLASH OFF

1. Use of good quality high-density foam rollers is essential. The use of a suitable roller tray allows easy control of paint loading on the roller.
2. Load the roller from a suitable roller tray. Removed excess paint from the roller.
3. The first coat covers the largest area. Subsequent coats cover smaller areas.
4. Apply paint from the centre of the repair patch, rolling outwards using light pressure.
5. Use the roller with less paint loading to fade the hard edges of each coat.
6. Allow the paint to flow out on the panel; avoid over-working, which can leave an uneven surface.
7. When one coat becomes matt/dry, it is ready for the next coat.

Number of coats: Apply 3-4 coats to give a film thickness of 75 - 125 microns (3 - 5 thou.)

Flash-off at 20°C: Between coats Approx. 5 minutes

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

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.

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.

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