

Product Data Sheet

October 2019

INTERNATIONAL MASTER
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T8700V

HP Chromate Free Epoxy Primers P580-4501/-4505/-4510

Product	Description
P580-4501	HP Chromate Free Epoxy Primer - White
P580-4505	HP Chromate Free Epoxy Primer - Grey
P580-4510	HP Chromate Free Epoxy Primer - Beige
P275-3042	Hardener for Epoxy Primer
P275-2013	Fast hardener for Epoxy Primer
P850-1480	Thinner for HP C.F. Epoxy Primer
P850-1479	Thinner for HP C.F. Epoxy Primer - Slow

Product Description

P580-4501/-4505 / 4510 are high performance amine cured epoxy primers. They are high solids and fast curing products with excellent adhesion properties and corrosion resistance over most common commercial transport substrates. In ready-for-use mode, the VOC content of this product is lower than 540 g/l. P580-4501/-4505 / 4510 are ideal under the Turbo Plus, HS Turbo Plus or EHS Turbo Plus topcoat range.



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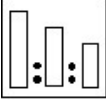
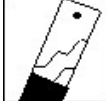





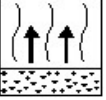



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Process

	HVLP and Conventional Application	Airless / Air-Assisted Airless Spray
	P580-45xx 4 parts P275-3042 1 part Stir thoroughly before adding :- P850-1480/1479 0.5 -1.5 parts	P580-45xx 4 parts P275-3042 1 part
	Pot life at 20°C: 3-4 hours Clean gun immediately after use	Pot life at 20°C: 3-4 hours Clean gun immediately after use
	25 – 35 Seconds DIN4	60-70 seconds DIN4
	<u>Gravity or Suction feed:</u> 1.6 -1.8 mm <u>Air cap pressure:</u> 3.7-4.0 bar (55-60 psi) <u>Pressure feed:</u> 1.0-1.4 mm	
	<u>Gravity or Suction feed:</u> 1.8 mm <u>Air cap pressure:</u> 0.675 bar (10psi) max. <u>Pressure feed:</u> 0.85-1.4 mm HVLP	
		<u>Airless:</u> 0.33-0.37 mm (13-15 thou) tip Approx. 140 bar (2000 psi) fluid pressure <u>Air Assisted Airless:</u> 0.28-0.37 mm (11-15 thou) tip Approx. 70 bar (1000 psi) fluid pressure Approx. 2.0 bar (20-25 psi) air cap pressure
	2 single coats to give 50-80 microns (2-3 thou) dry film thickness	1-2 coats to give 75-100 microns (3-4 thou) dry film thickness
	10-15 minutes between coats, depending on dry film thickness and drying conditions Flash off 10-15 minutes before stoving	
	Air Dry (20°C) : Dust free: 10-15 min. Tack free: 60 min. Hard dry: 8 - 10 hours Can be recoated wet-on-wet after 60 minutes air dry minimum, Can be recoated without sanding for up to 1 month maximum, but after 24 hours a thorough clean of the surface is recommended.	Low Bake (60°C metal temperature): Hard dry: 45 - 60 min.
	Wet Flattig: P600 or finer.	
	Machine sanding: P320 or finer.	

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Process

Substrate	Preparation	Notes
Steel	Blast cleaning is the preferred surface treatment for maximum durability and optimum paint usage. Alternatively flat thoroughly using P80-P180 dry sanding machines discs or P120-P220 wet and dry paper, then clean with P850-1378. Overcoat within 8 hours with primer.	Surface must be free from oil/grease, millscale and rust
Stainless Steel	Degrease with P850-1367 and scuff using P180-240 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378	
Aluminium	Flat thoroughly using P240 dry sanding machine discs or Scotchbrite, then clean with P850-1378. Overcoat with primer within 4 hours of sanding.	Not recommended over jointed aluminium sections. Please, seek advice from your local Nexa Autocolor representative
Sound Factory finishes Sound works primer Sound old finishes (2-pack) Sound electrocoat	Flat thoroughly using P240-P320 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378	Old synthetic finishes must be well cured and non-bleeding
Weathered galvanised steel / Zintec	Clean with P273-901, degrease with P850-1367 and sand using Scotchbrite Fine or P180-P320 dry sanding machine discs	Surface must be free from oxidation residues
Hot dipped galvanised steel	Thoroughly degrease with P850-1367, scuff with Scotchbrite Fine or P400 wet and dry paper, then clean with P850-1378	
GRP "Glasonite"	Clean with P273-901. Flat thoroughly using P240-P280 dry sanding machine discs or P320-P400 wet and dry paper, then clean with P850-1378	Take care not to break through the gel coat when flattening GRP

P580-45xx series primers are **NOT** recommended for use over etch primers or thermoplastic substrates.

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

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General Process Notes

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. May be recoated with **Nexa Autocolor** Commercial Transport 2-pack primers/undercoats or directly topcoated with **Nexa Autocolor** Commercial Transport 2-pack topcoats. If topcoated with CT Aquabase P962-Line, Nexa Aquabase or Aquabase Plus it is important that P580-4505/-4510 are fully baked or left to dry overnight. See appropriate PDS for further details.

APPLICATION EQUIPMENT INFORMATION

HVLP

The most suitable HVLP gun for the application of Commercial Transport products is the pressure feed system.

Air cap pressure : 0.675 bar (10 psi) maximum

Paint pressure : 0.3-1.0 bar (5-15 psi)

If long fluid lines are used, the paint pressure will need to be increased.

DRYING

The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation and excessive film thickness will extend the drying times. Overnight temperatures above 15°C are essential for the primer to fully cure.

USE OF P275-2013 FAST HARDENER

This hardener can be used when applying primer at temperatures below 18°C to speed up drying times.

COVERAGE (on ready-for-use paint)

At 4:1:1 : Approx. 4.2 – 5.1 m² per litre at a dry film thickness of 100 microns

At 4:1 : Approx. 6.5 m² per litre at a dry film thickness of 100 microns

TECHNICAL DATA

Solid Content by Weight 72% as supplied

Solid Content by volume 52% as supplied

Density 1.5 Kg/litre



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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

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