

Product Data Sheet

December 2007 (February 2015 update)

INTERNATIONAL MASTER
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T3700V

High-Build Epoxy Primer P580-2920

Product	Description
P580-2920	High Build Epoxy Primer
P275-3022	Hardener for Epoxy Primer
P275-3032	High Build Epoxy Hardener for PluralMix
P850-1480	Thinner for HP C.F. Epoxy Primer
P850-1479	Thinner for HP C.F. Epoxy Primer - Slow

Product Description

P580-2920 is a high performance epoxy primer specifically designed for high-build applications over structural substrates such as chassis. It is dedicated for use with Plural Mix, with airless or air-assisted airless spray equipment. P580-2920 is a high solids product with excellent adhesion properties and corrosion resistance over most common commercial transport substrates. When ready-for-use, the VOC content is less than 540 g/l.

For an outstanding, lasting finish, P580-2920 should be re-coated with either Turbo Plus, HS Turbo Plus or EHS Turbo Plus topcoats.

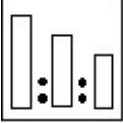



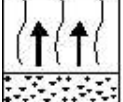






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Process		
	Conventional Mix Airless / Air-Assisted Airless Spray	Plural Mix
	Mixing Ratio (by volume)	
	Conventional	Airless/Airmix
	P580-2920 4 parts P275-3022 1 part P850-14xx 1 part	P580-2920 4 parts P275-3022 1 part P850-14xx 0,5 part
	Pot Life at 20°C : 3-4 hours Clean gun immediately after use	Pot Life at 20°C : n/a ONLY USE WITH PLURAL-MIX EQUIPMENT
	Airless: 0.33-0.37 mm (11-15 thou) tip Approx. 140 bar (2000 psi) fluid pressure Air Assisted Airless: 0.33-0.37 mm (11-15 thou) tip Approx. 70 bar (1000 psi) fluid pressure Approx. 1.4-1.8 bar (20-25 psi) air cap pressure	
	Application: 1-2 coats to give 75 - 150 microns dry film thickness.	
	Flash Off: 10-15 minutes between coats, depending on film thickness and drying conditions. Flash Off: 15-30 minutes before stoving.	
	Air Dry (20°C) : Dust free: 10-15 min. Tack free: 60 min. Hard dry: 16 hours Low Bake Hard dry at : 60°C Metal Temperature 40 minutes 50°C Metal Temperature 80 minutes 40°C Metal Temperature 120 minutes	Air Dry (20°C) : Dust free: 10-15 min. Tack free: 60 min. Hard dry: 12-16 hours Low Bake Hard dry at : 60°C Metal Temperature 30 minutes 50°C Metal Temperature 60 minutes 40°C Metal Temperature 90 minutes
The above figures are a guide only, and will vary with film thickness and drying conditions.		
	Wet Flatting: P600 or finer. When hard dry	
	Machine sanding: P240 or finer. When hard dry	
	Recoat time: Can be recoated wet-on-wet after 30 minutes flash-off For best appearance allow to fully dry before recoating	

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Process

SUBSTRATES AND PREPARATION

Substrate	Preparation	Notes
Steel	Blast cleaning is the preferred surface treatment for maximum durability and optimum paint usage. Blast clean to SA2.5 minimum standard Alternatively flat thoroughly using P80-P180 dry sanding machines discs or P120-P220 wet and dry paper, then clean with P850-1378.	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	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	Take care not to break through the gel coat when flatting GRP
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	

P580-2920 is 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, it is important that P580-2920 is fully baked or left to dry overnight. See appropriate PDS for further details. Do not recoat with 1-pack synthetic topcoats.

NOTE: P580-2920 **cannot** be re-coated with EHS P383 or other 1 pack synthetic topcoats.

APPLICATION EQUIPMENT INFORMATION

It is important to mix paint and hardener at the correct ratio. Plural-mix equipment should be regularly calibrated to ensure accurate paint / hardener mixing.

P275-3032 Hardener must **ONLY** be used with plural-mix application equipment.

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.

COVERAGE (on ready-for-use paint)

At 4:1: Approx. 9.6 m² per litre at a dry film thickness of 50 microns on smooth steel.



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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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