

Product Data Sheet

August 2006 (July 2019 update)

INTERNATIONAL MASTER
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T0100

QD Weldable Primer P565-769

<i>Product</i>	<i>Description</i>
P565-769	QD Weldable primer - dark grey

Product Description

QD Weldable Primer is a very fast drying weldable primer, which provides temporary protection to blast cleaned components during fabrication of commercial vehicles. It allows two metal surfaces to be primed and then welded with minimum burn-back



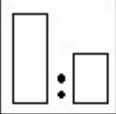









Product Data Sheet

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Process

	Conventional Spray	HVLP	Airless (Cold only)
	Thinning not normally required (add 5-10% P850-1335/-1404 if necessary)	Thinning not normally required	Thinning not normally required
			
	Ready for use	Ready for use	Ready for use
	1.8-2.2 mm 3.3-5.3 bar (50-80 psi)		
		1.0-1.5 mm Air cap pressure : 0.675 bar (10 psi)maximum	
			0.22-0.28 mm (9-11 thou) 40-60° angle Paint pressure : 110-120 bar (1600-1800)
	1 to 2 single coats or 1 double coat for temporary protection 15-25 microns (1 thou approx.)	1 to 2 single coats or 1 double coat for temporary protection 15-25 microns (1 thou approx.)	1 single coat for temporary protection 15-25 microns (1 thou approx.)
	No flash off required between coats		
	Air dry (20°C) Dust free : 4 minutes Handleable : 10 minutes Recoat : 20 minutes Hard dry : 1 hour Weldable : When hard dry	Air dry (20°C) Dust free : 4 minutes Handleable : 10 minutes Recoat : 20 minutes Hard dry : 1 hour Weldable : When hard dry	Air dry (20°C) Dust free : 4 minutes Handleable : 10 minutes Recoat : 20 minutes Hard dry : 1 hour Weldable : When hard dry
	Flattening is not recommended unless it is necessary to remove dirt or runs and should be denibbed lightly when hard dry (minimum overnight dry)		

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General Process Notes

SUBSTRATES AND PREPARATION

Blast cleaned steel/well abraded clean steel.

Hot and cold rolled steel should be free from loose scale and rust and thoroughly degreased by hand solvent cleaning P850-1367. Blast cleaning to a maximum of 25 microns blast profile is the preferred surface treatment for maximum durability and optimum paint usage. Alternatively flat thoroughly using P80-P180 dry sanding machine discs or P120-P220 wet and dry paper, then clean with P850-1378.

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

RECOAT

Do NOT recoat directly with topcoats.

P565-769 may be recoated with **Nexa Autocolor** Commercial Transport 1 pack and 2-pack primers/undercoats when fully cured. Components should be cleaned thoroughly with Prep-Pak 2 (P850-1378) prior to painting.

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.

Air Assisted Airless

P565-769 is NOT recommended for air assisted airless (air mix) application.

DRYING

The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, temperatures below 20°C and excessive film thickness will extend the drying times.

THINNER ADDITION

P565-769 comes ready for use and thinning is not normally required. P850-1335 or P850-1404 may be added up to a level of 5-10% to retard the drying time and improve application in hot conditions.

WELDING

P565-769 can be welded at low film weights when hard dry. It conforms to the UK Health and Safety Executive Guidance Note EH40 "Occupational Exposure Limits". When sprayed for welding purposes the dry film thickness of P565-769 should NOT exceed 25 microns (1 thou). At this film thickness P565-769 can only be used as a temporary protection as a holding primer. Further coats of primer should be applied to achieve the maximum durability.

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HOLDING PRIMER

When used as a holding primer P565-769 will protect vehicles or components for up to 3 months under cover. A dry film thickness of 25 microns above the blast-cleaned peaks is recommended for this purpose.

COVERAGE

Approximately 5-8 m² per litre of ready for use paint at a dry film thickness of 15-25 microns (approx. 1 thou).

OTHER POINTS TO NOTE WHEN USED AS HOLDING PRIMER

1. Do NOT apply when relative humidity exceeds 85%.
2. Apply a minimum of 25 microns (1 thou) dry if components are stored outside undercover.
3. Avoid excessive film thicknesses above 30 microns (1.2 thou).
4. NOT recommended for use over large areas.
5. Do NOT spray in areas where welding is likely to take place.

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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