

Product Data Sheet

January 2011

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY



H0510V

Polyester Spraying filler P565-2901

<i>Product</i>	<i>Description</i>
P565-2901	Polyester Spraying Filler
SHA307	Activator for Polyester Spraying Filler
P850-1224	Thinner for Polyester Spraying Filler

Product Description

P565-2901 is a light grey, heavily bodied 2-pack filler developed for use under any **Nexa Autocolor** 2-pack undercoat, for the deep filling of irregular metal surfaces. P565-2901 is particularly versatile, it can be thinned to improve flow and reduce flattening or may be applied by brush over small areas.

Substrates/Preparation

P565-2901 should only be applied over:

Well-scuffed and degreased bare steel and aluminium.

For optimum durability a 2K Epoxy Primer may be used first.

Well flattened GRP, works primer and old finishes in sound condition.

NOTE: If the original finish is thermoplastic acrylic then strip to bare metal.

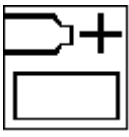
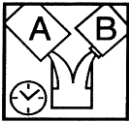


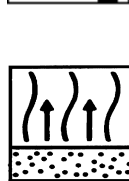



Good preparation is vital in order to obtain the best results from this product.

The following grades of flattening paper are recommended: -

P80-P120

NOTE: DO NOT USE P565-2901 OVER ZINC, GALV OR ETCH PRIMER.

Process

 	<table border="0"> <thead> <tr> <th></th> <th style="text-align: center;">Volume</th> <th style="text-align: center;">Weight</th> </tr> </thead> <tbody> <tr> <td>P565-2901</td> <td style="text-align: center;">100.0 parts</td> <td style="text-align: center;">100.0 parts</td> </tr> <tr> <td>SHA307</td> <td style="text-align: center;">2.5 parts*</td> <td style="text-align: center;">2.0 parts</td> </tr> <tr> <td>P850-1224</td> <td style="text-align: center;">2.0 parts</td> <td style="text-align: center;">2.0 parts</td> </tr> </tbody> </table> <p>*Add 25ml SHA307 to 1 litre P565-2901</p> <p>Viscosity DIN 4 @ 20°C 45 seconds</p> <p>Pot Life @ 20°C 20 minutes</p>		Volume	Weight	P565-2901	100.0 parts	100.0 parts	SHA307	2.5 parts*	2.0 parts	P850-1224	2.0 parts	2.0 parts
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	<p>Gravity fed gun is recommended</p> <p><u>Fluid tip</u> Gravity fed: 2.0 -2.5 mm</p> <p><u>Pressure at Gun</u> : 2.0-2.7 bar (30-40 psi)</p>												
 	<p>3 – 4 coats</p> <p>Each pass of the gun adds 75-100 microns (3-4 thou.)</p> <p>Maximum recommended thickness: 600 microns</p> <p>To improve flow and reduce flattening, add 5% P850-1224 to the final coat.</p> <p>Can also be applied by brush, particularly in small areas.</p> <p>Flash off:</p> <table border="0"> <tr> <td>Between coats</td> <td style="text-align: center;">5 – 10 minutes</td> </tr> <tr> <td>Before Bake</td> <td style="text-align: center;">5 – 10 minutes</td> </tr> </table>	Between coats	5 – 10 minutes	Before Bake	5 – 10 minutes								
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 	<p>Air-dry at 20°C (200 microns) : 2 - 3 hours</p> <p>Through hardening will be severely impaired if applied at temperatures below 15°C</p> <p>Bake at a metal temperature of: 30 mins @ 50°C</p> <table border="0"> <tr> <td>Infrared Drying</td> <td style="text-align: center;">Medium Wave</td> <td style="text-align: center;">15 minutes</td> </tr> <tr> <td></td> <td style="text-align: center;">Short Wave</td> <td style="text-align: center;">10 minutes</td> </tr> </table>	Infrared Drying	Medium Wave	15 minutes		Short Wave	10 minutes						
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	<p>P565-2901 is extremely easy to sand beginning with dry sanding with P150 – P180, finishing off by dry sanding with P240-P280</p> <p><u>This product should not be wet flatted</u></p>												
<p>RECOAT</p>	<p>Following sanding, P565-2901 must be directly recoated with any Nexa Autocolor 2-pack undercoat prior to topcoating.</p>												
<p>NB: P565-2901 must not be sandwiched between 2 coats of lacquer drying paints.</p> <p>EQUIPMENT CLEANING: Equipment should be cleaned immediately after use with cleaning solvent or a strong thinner, e.g. P851-61</p>													

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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. 250g/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: www.nexaautocolor.com

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