

Product Data Sheet

October 2019

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY



U1130V_TV

HS High-Build, Primer Surfacer P565-1027 /1028 - Grey / White

Product	Description
P565-1027/8	HS High build, Primer Surfacer – Grey / White
P210-7644	EHS Hardener - Standard
P210-7642	EHS Hardener - Slow
P210-987	Plural mix hardener
P852-6442	EHS Thinner - Slow
P852-6444	EHS Thinner - Medium
P852-6446	EHS Thinner - Fast
P852-6448	EHS Thinner - Extra Fast
P100-2020	Flexible Additive for Plastics

Product Description

P565-1027 and P565-1028 HS High-build, Primer are high performance 2-Pack undercoats for use under Nexa Autocolor 2-Pack topcoats.

When used with TURBO VISION® 2-pack Premium High Flow EHS ancillaries, P565-1027/1028 has a ready-for-use VOC of less than 540g/l.

P565-1027 P565-1028 HS High-build, Primer have been specifically designed for application over large areas. They can be used in wet-on-wet and high-build modes and when dry have excellent flattening characteristics.



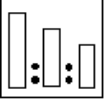




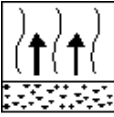



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Standard and Fast Process

EHS Mode (Below 540g/L VOC)											
 <p>Standard build mode including wet-on-wet and non-sand</p> <p>High Build mode</p>	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%; padding: 5px;">P565-1027/1028</td> <td style="padding: 5px;">8 parts</td> </tr> <tr> <td style="padding: 5px;">P210-764x</td> <td style="padding: 5px;">1 part</td> </tr> <tr> <td style="padding: 5px;">P852-644x</td> <td style="padding: 5px;">1.5 parts</td> </tr> <tr> <td style="padding: 5px;">P565-1027/1028</td> <td style="padding: 5px;">8 parts</td> </tr> <tr> <td style="padding: 5px;">P210-764x</td> <td style="padding: 5px;">1 part</td> </tr> </table>	P565-1027/1028	8 parts	P210-764x	1 part	P852-644x	1.5 parts	P565-1027/1028	8 parts	P210-764x	1 part
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P565-1027/1028	8 parts										
P210-764x	1 part										
	<p>Pot life at 20°C: 1 hour</p> <p>Clean gun immediately after use</p>										
	<p>Standard Build 23-29s. DIN4 (35-45s. BSB4)</p>										
	<p>Gravity or Suction feed: 1.6-1.8 mm Air cap pressure: 3.7-4.0 bar (55-60 psi)</p> <p>Pressure feed: 1.0-1.4 mm</p>										
	<p>Gravity or Suction feed: 1.6-1.8 mm Air cap pressure: 0.675 bar (10psi) max.</p> <p>Pressure feed: 0.85-1.4 mm HVLP/compliant</p>										
	<p>10-15 minutes between coats, depending on dry film thickness and drying conditions</p> <p>Flash off 15-30 minutes before stoving</p>										
	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%; vertical-align: top;"> <p>Air Dry (20°C) :</p> <p>Dust free: 10-15 min. Tack free: 30-60 min. Hard dry: 4 hours</p> </td> <td style="width: 50%; vertical-align: top;"> <p>Low Bake (60°C metal temperature):</p> <p>Hard dry: 30 min.</p> </td> </tr> </table> <p>Can be recoated wet-on-wet after a minimum of 30 min air dry If recoating with Turbo Plus metallic basecoat, allow at least two hours drying time otherwise lifting of the paint film may occur.</p>	<p>Air Dry (20°C) :</p> <p>Dust free: 10-15 min. Tack free: 30-60 min. Hard dry: 4 hours</p>	<p>Low Bake (60°C metal temperature):</p> <p>Hard dry: 30 min.</p>								
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	<p>Wet Flattening:</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">P600 or finer</td> <td style="padding-left: 20px;">Solid Colours</td> </tr> <tr> <td>P860 or finer</td> <td>Basecoats.</td> </tr> </table>	P600 or finer	Solid Colours	P860 or finer	Basecoats.						
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	<p>Machine sanding:</p> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;">P240 or finer</td> <td style="padding-left: 20px;">Solid Colours.</td> </tr> <tr> <td>P360 or finer</td> <td>Basecoats</td> </tr> </table>	P240 or finer	Solid Colours.	P360 or finer	Basecoats						
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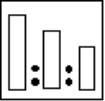
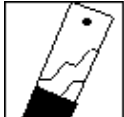







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Express Mode (Below 540g/L VOC)

 <p>Standard build mode</p>	<table border="0"> <tr> <td>P565-1027/1028</td> <td>8 parts</td> </tr> <tr> <td>P210-7644</td> <td>1 part</td> </tr> <tr> <td>P852-6448</td> <td>1.5 parts</td> </tr> </table>	P565-1027/1028	8 parts	P210-7644	1 part	P852-6448	1.5 parts
P565-1027/1028	8 parts						
P210-7644	1 part						
P852-6448	1.5 parts						
	<p>Pot life at 20°C: 15 mins.</p> <p>Clean gun immediately after use</p>						
	<p>Standard Build 23-29s. DIN4 (35-45s. BSB4)</p>						
	<p><u>Gravity or Suction feed:</u> 1.6-1.8 mm Air cap pressure: 3.7-4.0 bar (55-60 psi)</p> <p>Do not use in pressure feed system</p>						
	<p><u>Gravity or Suction feed:</u> 1.6-1.8 mm Air cap pressure: 0.675 bar (10psi) max.</p> <p>Do not use in pressure feed system</p>						
	<p>5 minutes between coats, depending on dry film thickness and drying conditions</p> <p>Flash off 5-10 minutes before stoving</p>						
	<p>Force Dry / Low Bake</p> <p>30°C -: 20 min. 40°C -: 10 min.</p> <p>Flattable as soon as cooled.</p>						
	<p>Wet Flattening: P600 or finer Solid Colours P860 or finer Basecoats.</p>						
	<p>Machine sanding: P240 or finer Solid Colours. P360 or finer Basecoats</p>						

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General Process Notes

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NOTE:	Not recommended for use directly to metal. Use Etch Primer and refer to relevant PDS				
SUBSTRATES:	Steel Stainless Steel Aluminium Galvanised steel Zintec Sound Factory finishes Sound works primer Sound old finishes (2-pack) Sound electrocoat GRP "Glasonite"				
PREPARATION:	Abrade using P180-240 dry sanding machine discs or P180-400 wet and dry paper, then clean with P850-1378 Then pre-prime with Etch Primer P565-767 or P565-7600. Flat thoroughly using P240- P320 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378				
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. Topcoat with TURBO VISION® 2-pack Premium High Flow EHS Topcoat or EHS Turbo Plus or CT Aquabase Also may be recoated with any other Nexa Autocolor Commercial Transport 2-pack topcoat When using CT Aquabase (P962-Line), it is important that P565-1027/1028 is hard dry prior to application of the Aquabase basecoat .				
TINTING	P565-1027 /1028 can be tinted. EHS Turbo Plus Tinters can be added up to a maximum of 5% to P565-1027/1028, which should then be activated and thinned according to the P565-1027/1028 process recommendations. For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS Q0100.				
PLURAL MIXING	P565-1027 / 1028 can be mixed with P210-987 plural mix hardener <table style="margin-left: auto; margin-right: auto;"> <tr> <td>P565-1027 / 1028</td> <td>5 parts</td> </tr> <tr> <td>P210-987</td> <td>1 part</td> </tr> </table> This will then perform as the EHS Hardener mode above	P565-1027 / 1028	5 parts	P210-987	1 part
P565-1027 / 1028	5 parts				
P210-987	1 part				
COVERAGE	At a film thickness of 80 microns – 4.1 m ² /litre				

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 Scotchbrite is a trademark of 3M UK Plc.



SPECTRAL GREYS

These primers may be blended as below to give a range of Spectral Greys.

	SG01	SG03	SG05	SG06	SG07
P565-1027 - Grey	-	100g	99.5g	97.5g	88.5g
P565-1028 - White	100g	-	-	-	-
P170-5670 - Black Paste	-	-	0.5g	2.5g	11.5g

PAINTING PLASTICS

P565-1027/1028 can be used over the appropriate plastics primer, when painting plastic parts, to give build. When used over very flexible plastics these primers should be mixed:

8 parts P565-1027/1028
 2 parts P100-2020 Flexible Additive for Plastics
 1.5 parts P210-7644 or P210-7642 Hardener
 2.5 parts Thinner

Note: The use of the flexible Additive will extend drying times

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

For further information please contact:

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