

Product Data Sheet

December 2007

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY



G1180V

2K Epoxy Primer Surfacer P565-5215

<i>Product</i>	<i>Description</i>
P565-5215	2K Epoxy Primer Surfacer
P275-5220	Hardener for 2K Epoxy Primer Surfacer
P850-1490/1491/1492/1493/1494/1495	2K Thinners
P850-1692/1693/1694	2K Low VOC Thinners

Product Description

P565-5215 is a Sandable, 2K Epoxy Primer Surfacer. Easy to use and to sand, this primer has excellent adhesion over a wide range of substrates. Developed for use with **2K HS+** Topcoat(P471), **Aquabase™** Basecoat(P965) and **Aquabase Plus** Basecoat (P989).

Substrates/Preparation

P565-5215 can be applied over:-

Well scuffed and degreased bare steel.

Properly prepared Galvanised steel, Zintec and Aluminium.

Well-flatted GRP, polyester fillers, works primers and old finishes in good condition.

Innovating Repair Solutions



PROCESS

	<table border="0"> <thead> <tr> <th></th> <th style="text-align: center;">Parts by volume</th> <th style="text-align: center;">By Weight</th> </tr> </thead> <tbody> <tr> <td>P565-5215</td> <td style="text-align: center;">3</td> <td style="text-align: center;">100g</td> </tr> <tr> <td>P275-5220</td> <td style="text-align: center;">1</td> <td style="text-align: center;">20g</td> </tr> <tr> <td>P850-14xx / 16xx</td> <td style="text-align: center;">0.6 - 0.9</td> <td style="text-align: center;">12 - 18g</td> </tr> </tbody> </table>		Parts by volume	By Weight	P565-5215	3	100g	P275-5220	1	20g	P850-14xx / 16xx	0.6 - 0.9	12 - 18g
	Parts by volume	By Weight											
P565-5215	3	100g											
P275-5220	1	20g											
P850-14xx / 16xx	0.6 - 0.9	12 - 18g											
	<p>Important: Mix primer and hardener until homogeneous, before the addition of thinner. After adding thinner, mix again. An induction period of 10 minutes after mixing is necessary, before use.</p>												
	<p>Paint should be at room temperature prior to mixing. Stir thoroughly to incorporate.</p> <p>The pot life is 3 hours at 20°C.</p> <p>Note: Material does not gel. Care should be taken not to use this product beyond 3 hours after mixing.</p>												
	<p>20-30 seconds DIN 4 at 20°C</p>												
	<p>Fluid Tip 1.3-1.6 mm Maximum Air Cap pressure 0.7 bar (10 psi)</p> <p>For best results use gravity feed spraygun only.</p>												
	<p>Fluid Tip 1.3-1.6 mm Pressure : 0.7 bar/10 psi max (@ air cap)</p> <p>For best results use gravity feed spraygun only.</p>												
	<p>2 single coats maximum (60-80 microns)</p>												
	<p>Allow 10 minutes between coats</p> <p>Or until the primer is matt.</p>												
	<p>Bake at metal temperature of 60°C for 30 minutes. Allow 10 minutes before baking, or until the primer is matt. Allow panel to cool thoroughly before attempting to sand. NOTE: Air drying for 16 hours at 20°C.</p>												

PROCESS



Allow to go matt before I.R.
10 - 15 minutes with medium wave IR, depending on film thickness

Lamp to panel distance should be 1m for High Power & Short Wave lamps.
Max. panel temperature should not exceed 80°C.
Time is for guidance only.
Drying is dependent on lamp power and efficiency.
Allow panel to cool thoroughly before attempting to sand.



Machine flattening :

P320-P360 with 2K HS+ Solid Colours
P360-P400 with Aquabase Plus and Aquabase™ Basecoats.

RECOAT

After drying fully and flattening, the primer can be recoated with 2K HS+ (P471),
Aquabase Plus and Aquabase™ Basecoat (P965)

It can also be recoated with a Wet-on-Wet Surfacer or itself.

NOTE

For optimum performance the dry film thickness should not exceed 80 microns.

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 the 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:

Customer Service Sales Group
PPG Industries (UK) Ltd
Needham Road
Stowmarket
Suffolk IP14 2AD
Tel: 01449 771771
Fax: 01449 773472

Nexa Autocolor, **ZK**, Aquabase, Aquadry and Ecofast are trademarks of PPG Industries.
Copyright © 2007 PPG Industries, all rights reserved.
Copyright in the above product numbers that are original is asserted by PPG Industries.

