

Product Data Sheet

November 2007



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H1120V

Stone-chip Sealer P565-779

<i>Product</i>	<i>Description</i>
P565-779	Stone-chip Sealer
P210-832/-796/-798/-828/-847	2K MS Hardeners
P210-842/-8430/-844/-845	2K HS Hardeners
P850-1490/-1491/-1492/-1493/-1494/-1495	2K Thinners
P850-1692/-1693/-1694	2K Low VOC Thinners

Product Description

P565-779 is a mildly flexibilised transparent sealer, which has been developed for use under **Nexa Autocolor** 2K topcoat systems. It is intended for use primarily on areas vulnerable to damage to enhance the stone-chip resistance.

SUBSTRATES AND PREPARATION

P565-779 should only be applied over :

A **Nexa Autocolor** 2-pack undercoat or a properly prepared OE finish.





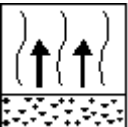


P565-779 should be applied wet-on-wet directly after the application of the 2-pack undercoat, after the recommended flash-off time.

For bare steel and aluminium it is necessary to use a **Nexa Autocolor** 2-pack Etch Primer or 2K Epoxy Primer under the 2-pack undercoat. For electrocoated panels the 2-pack undercoat can be used directly over the substrate, after careful preparation.

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PROCESS	
	<p>P565-779 2 parts</p> <p>P210-*** 2K Hardeners 1 part (See products list)</p> <p>P850-**** 2K Thinners 0.15 – 0.3 part (See products list)</p>
	<p>16-18 secs DIN4 (20-23 secs BSB4)</p> <p>Pot-life : 2 hours at 20°C</p>
	<p>Fluid tip :</p> <p>Gravity Fed : 1.3-1.6 mm</p> <p>Suction Fed : 1.6-1.8 mm</p> <p>Inlet Pressure : As recommended by spraygun manufacturer (normally 2 bar or 30 psi).</p>
	<p>2 single coats to give a minimum film thickness of 50-60 microns (2.0-2.5 thou)</p>
	<p>Flash-off 5-10 minutes at 20°C between coats</p> <p>NOTE : No flash off needed before baking</p>
	<p>Air dry at 20°C :</p> <p>16 hours</p> <p>12 hours with P210-832/-842</p> <p>Bake at a metal temperature of 60°C :</p> <p>30 minutes</p> <p>20 minutes with P210-832/-842</p>
	<p>Finish with the following grades :</p> <p>P600 : Solid colours</p> <p>P800 or finer : Basecoats</p>
TOPCOAT	<p>P565-779 can be directly topcoated after flattening with Nexa Autocolor 2K topcoat systems.</p>

GENERAL PROCESS NOTES

TYPICAL USE

Apply 2-pack Undercoat as usual. After recommended flash-off time, spray P565-779 to vulnerable areas. Fade out sealer towards middle of panel.

Fade-out thinners not required. Allow to dry as above.

Flat the 2-pack undercoat in the usual way and wet flat the sealer area.

VOC INFORMATION

The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/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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