

Product Data Sheet

November 2007



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H1220V

High Build Filler / Surfacer P565-693 - High Solids System

<i>Product</i>	<i>Description</i>
P565-693	High Build Filler / Surfacer
P210-8430/844/845	2K HS Hardeners
P850-1491/1492/1493/1494	2K Thinners
P850-1692/1693/1694	2K Low VOC Thinners
P100-2020	Flexible Additive for Plastics

Product Description

P565-693 is a 2-pack acrylic, flattable primer, which has been developed for use under Nexa Autocolor **2K topcoat systems**.

P565-693 can be used in primer filler and primer surfacer modes to give excellent topcoat appearance & durability.

Substrates and Preparation

P565-693 should only be applied over :-

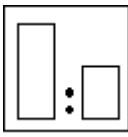



Well scuffed and degreased bare steel. Aluminium should be etch primed.
Use an **Nexa Autocolor** 2-pack Etch Primer for maximum durability on large areas.

Well flatted GRP, polyester fillers, works primer and old finishes in sound conditions.

Good preparation is vital in order to obtain the best results from this product.
The following grades of flating paper are recommended:-


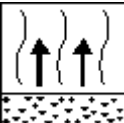




Wet or dry paper P280-P320 (GRP P400)
Dry machine sanding P220-P280

NOTE: Not recommended for spot repairs over thermoplastic acrylic and old lacquer finishes. Complete panels only.

HS PROCESS		
USAGE	PRIMER SURFACER (80-100 microns)	PRIMER FILLER (100-150 microns)
	P565-693 6 parts P210-8430/-844/-845 1 part P850-2K Thinners 1 parts (see Products)	P565-693 6 parts P210-8430/-844/-845 1 part P850-2K Thinners 0.5 parts (see Products)
	17-19 secs DIN4 (21-24 secs BSB4) Pot-life : Approx. 2 hours at 20°C	30-35 secs DIN4 (41-48 secs BSB4) Pot-life : Approx. 1 hour at 20°C
	Gravity fed gun is recommended Fluid tip :: Gravity gun : 1.4-1.8 mm Pressure : 2.7-3.3 bar (40-50 psi)	Gravity fed gun is recommended Fluid tip : Gravity gun : 1.8-2.0 mm Pressure : 2.7-3.3 bar (40-50 psi)
	Fluid tip : Gravity fed : 1.6-1.8 mm Pressure : 0.7 bar (10 psi) max at air cap	Fluid tip : Gravity gun : 1.8-2.0 mm Pressure : 0.7 bar (10 psi) max at air cap



HS PROCESS

USAGE	PRIMER SURFACER (80-100 microns)	PRIMER FILLER (100-150 microns)
	2-3 coats to give a film thickness of 80-100 microns (3-4 thou)	3-4 coats to give a film thickness of 150-200 microns (6-8 thou)
	Approx. 5 minutes between coats	Approx. 5-10 minutes between coats Approx. 20 minutes before low bake
	Air-dry at 20°C : 2 - 3 hours Bake at a metal temperature of 60°C : 20-30 minutes	Air-dry at 20°C : 4 hours Bake at a metal temperature of 60°C : 40 minutes
	Flash off 5 minutes Short wave : 5-10 minutes	Not recommended
	Finish with the following grades :- P600 or finer : Solid colours (Direct Gloss). P800 or finer : Basecoats	
	P320 or finer : Solid colours (Direct Gloss). P360 or finer : Basecoats	
TOPCOAT	P565-693 can be directly topcoated with Nexa Autocolor 2K topcoat systems. Once flatted if P565-693 is left for more than 2 days it should be flatted prior to application of further undercoat or topcoat.	

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GENERAL PROCESS NOTES

PAINTING PLASTICS

P565-693 may be applied over primed plastic.

If P565-693 is applied over a flexible plastic, e.g. PP/EPDM, PBT (Pocan), or PUR it must be mixed as follows :-

P565-693 5 parts
 P100-2020 (Flexible additive for plastics) 1 part
Then activate and thin in the normal manner.

Addition of P100-2020 may lead to deterioration of the flattening and drying properties.

For more detailed information on the painting of plastic substrates, refer to the Painting Plastics PDS.

CHOICE OF HARDENER AND THINNER

The exact choice of hardener and thinner combination will depend on the gun set-up used, air movement, temperature and application conditions. However, below is a general guide.:

Hardener	Temperature Range	Recommended Thinner
P210-8430	Up to 25°C	P850-1491/-1492/-1692/-1693
P210-844	25 - 30°C	P850-1493/-1693/-1694
P210-845	30°C +	P850-1493/-1494/-1694

DRYING

All drying times given in this process summary will depend on the film thickness applied and temperature.

Infra-red drying times given require the short wave infra-red lamp to be positioned 70-100 cm away from the panel. Allow P565-693 to flash off for 5 minutes before drying with the infra-red lamp. Drying times will depend on the type of infra-red lamp used.

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

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.

Note:

Combinations of this product with P100-2020 will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: 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.

For further information please contact:

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