

Product Data Sheet

November 2007



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H1330V

High Build Surfacer/Filler P565-761 - High Solids System

<i>Product</i>	<i>Description</i>
P565-761	High Build Surfacer/Filler
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

P565-761 is a 2-pack acrylic, flattable primer, developed for use under 2K HS Plus topcoat (P471), **Aquabase™** basecoat (P965) and **Aquabase Plus** basecoat (P989) to give an excellent final appearance.

P565-761 can be used in primer surfacer and high build primer filler modes.

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Substrates and Preparation

P565-761 should only be applied over: -

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

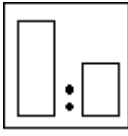
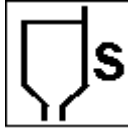


Well-flatted GRP, polyester fillers, works primer and old finishes in sound condition.

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.
Apply to complete panels only.

HS PROCESS		
USAGE	PRIMER SURFACER (80-150 microns)	PRIMER FILLER (150- 200 microns)
	P565-761 6 parts P210-8430/-844/-845 1 part P850-2K Thinners 1 parts (See Products)	P565-761 6 parts P210-8430/-844/-845 1 part P850-2K Thinners 0.5 part (See Products)
	17-21 secs DIN4 (21-27 secs BSB4) Pot-life : 2-3 hours at 20°C Clean gun immediately after use	30-35 secs DIN4 (41-48 secs BSB4) Pot-life : 1-2 hours at 20°C Clean Gun immediately after use
	Gravity fed gun is recommended Fluid tip: Gravity fed : 1.6-1.8 mm Pressure : 2.7-3.3 bar (40-50 psi)	Gravity fed gun is recommended Fluid tip : Gravity Fed : 1.8-2.2 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 fed : 1.8-2.2 mm Pressure : 10.7 bar (10 psi) max at air cap

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HS PROCESS		
USAGE	PRIMER SURFACER (80-150 microns)	PRIMER FILLER (150- 200 microns)
	2-3 coats to give a film thickness of 80-150 microns (3-6 thou)	3-4 coats to give a film thickness of 150-200 microns (6-8 thou)
	Approx. 5 minutes between coats No flash-off required before baking.	Approx. 5-10 minutes between coats Approx. 20 minutes before low bake
	Air-dry at 20°C : 4 hours Bake at a metal temperature of 60°C 30 minutes	Air-dry at 20°C : 6 hours Bake at a metal temperature of 60°C : 40 minutes
	Flash off 5 minutes. Short wave : 10-15 minutes	Not recommended
	<u>Finish with the following grades: -</u> <u>Wet Flat</u> P600 or finer: Solid colours / single layer metallic colours P800 or finer: Basecoats	
	<u>Dry Sanding</u> P320 or finer: Solid colours / single layer metallic colours P400 or finer: Basecoats	
TOPCOAT	P565-761 can be directly topcoated with 2K HS Plus topcoat (P471), Aquabase™ basecoat (P965) and Aquabase Plus basecoats (P989). Once flatted, if P565-761 is left for more than 2 days it should be flatted again prior to application of further undercoat or topcoat.	

GENERAL PROCESS NOTES

PAINTING PLASTICS

P565-761 may be applied over primed plastic.

If P565-761 is applied over a flexible plastic, e.g. PP/EPDM, PBT (Pocan) or PUR it must be mixed as follows: -

P565-761	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, please 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	<25°C	P850-1491/-1492/-1692/-1693
P210-844	25 - 30°C	P850-1492/-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 P565-761 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.



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.

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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