

Product Data Sheet

November 2007

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY



H4420V

Wet-on-Wet Surfacer P565-357 & P565-358

<i>Product</i>	<i>Description</i>
P565-357	Wet-on-Wet Surfacer - Grey
P565-358	Wet-on-Wet Surfacer - White
P210-8430/-844	2K HS Hardeners
P210-842	HS Express Hardener
P170-5670	HS Tinter for Spectral Greys
P850-1692/-1693/-1694	2K Low VOC Thinners
P859-1492/-1493/-1494	2K Thinners
P100-2020	Flexible Additive for Plastics

Product Description

P565-357 and P565-358 are fast drying 2-pack acrylic surfacers, which may be used under 2K Topcoats (P471), **Aquabase™** basecoat (P965-) and **Aquabase Plus** basecoat (P989).

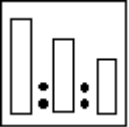





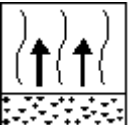

P565-357 and P565-358 are formulated to give excellent appearance and adhesion over a wide range of substrates.

As Wet-on-wet surfacers, they provide a fast process, particularly for new panel work.

The range of Spectral Grey primers can be achieved using P565-357/8 which ensures that high quality colour matches can be achieved quickly and easily while optimising topcoat usage.

Innovating Repair Solutions

Process

	P565-357/358 P210-842/8430/844 2K Thinners (See products)	3 parts 1 part 1 part	Do <u>NOT</u> add Accelerators
	14-17 secs DIN4 18-21 secs BSB4 Pot-life : 2 hours at 20°C, Clean gun immediately after use.		
	Fluid Tip Gravity Fed : 1.4-1.6 mm Suction Fed : 1.6-1.8 mm Pressure : 3.0 – 3.7 bar (45 – 55 psi)		
	Fluid Tip Gravity Fed : 1.4-1.6 mm Suction Fed : 1.6-1.8 mm Inlet Pressure : Refer to spraygun manufacturers instructions, normally 2 bar/30 psi (inlet)		
	Fluid Tip Gravity Fed : 1.4-1.6 mm Suction Fed : 1.6-1.8 mm Pressure : 0.7 Bar (10 psi) max at air cap		
	Apply 1 full single coat or 1 double coat to give a film thickness of 25-35 microns (1.0-1.4 thou)		
	Flash off : 15-20 minutes at 20°C before topcoating at a film thickness of 25-35 microns (1.0-1.4 thou)		
	Normally P565-357/358 Wet-on-Wet Surfacers do not require flatting and can be directly topcoated. If some dirt inclusion occurs, light wet flatting/denibbing can be carried out after 20-30 minutes using P800 or finer flatting paper. If a faster process time is required the surfacer can be baked at a metal temperature of 60°C for 10 minutes prior to denibbing.		
TOPCOAT	P565-357/358 can be directly topcoated with 2K Topcoats (P471), Aquabase™ basecoat (P965) and Aquabase Plus basecoat (P989).		

General Process Notes

SUBSTRATES AND PREPARATION

P565-357/358 should only be applied over :-

Original finishes in sound condition after sanding.
Good preparation is vital in order to obtain the best result from these products.

The following grades of flattening paper are recommended :-

Wet flattening	P400 or finer
Dry machine sanding	P320 or finer

Etch primed or 2K Epoxy primed aluminium and steel.

New panels in good quality Electrocoat, after thorough cleaning and Spirit wiping. For maximum durability it is recommended that the Electrocoat is lightly sanded using Scotch-Brite™, leaving it as in tact as possible, prior to application of the wet-on-wet primer.

PAINTING PLASTICS

P565-357/358 may be applied over prepared painted or primed plastic.
If P565-357/358 is applied over a flexible plastic, e.g. PP/EPBM, PBT (Pocan), PUR it must be mixed as follows :-

P565 -357/8	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 drying properties.
For more detailed information on the painting of plastic substrates, refer to the Painting Plastics PDS.

SPECTRAL GREYS

In order to maintain a VOC, it is essential that the recommended tinter level is not exceeded. Addition of higher levels of Tinter, P170-5670 should be avoided as this may lead to deterioration of drying properties and recoat problems.

The mixture should then be activated and thinned in the normal way before spraying.

For each of the Spectral Grey primer variants specified, the following mixing ratios apply :

	SG01	SG02	SG03	SG04	SG05	SG06	SG07
P565-358	100	95	80	50	0	0	0
P565-357	0	5	20	50	100	98.5	92
P170-5670	0	0	0	0	0	1.5	8

Note: Mixing ratios are expressed as weight percentages.



General Process Notes

CHOICE OF HARDENER AND THINNER

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

Hardener	Temperature Range	Recommended Thinner
P210-842	<25°C	P850-1692/-1693/-1492/1493
P210-8430	22°C - 28°C	P850-1692/-1693/-1694/-1492/-1493/-1494
P210-844	25 - 30°C	P850-1693/-1694/-1493/-1494

VOC INFORMATION

The EU limit value for these products (product category: IIB.c) in ready to use form is max. 540g/litre of VOC. The VOC content of these products in ready to use form is max. 540g/litre. Depending on the chosen mode of use the actual ready for use VOC of these products may be lower than that specified on 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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