

Product Data Sheet

November 2007



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H4730V

HS Primer Filler P565-510 & P565-511

<i>Product</i>	<i>Description</i>
P565-510	HS Primer Filler - Grey
P565-511	HS Primer Filler - White
P210-8430/-844/-845	HS Hardeners
P210-842	HS Express Hardener
P850-1490/-1491/-1492/-1493/-1494/-1495	2K Thinners
P850-1692/-1693/-1694	2K Low VOC Thinners
P170-5670	HS Tinter for Spectral Greys
P100-2020	Flexible Additive for Plastics

Product Description

P565-510 and P565-511 are 2-pack acrylic, high build primer fillers, developed for use under Nexa Autocolor 2K topcoat systems.

They are easy to apply and sand and give excellent final appearance and durability. They can be used in either build or surfacer modes.

A range of Spectral Grey primers can be achieved using P565-510/511 and ensure that high quality colour matches can be achieved quickly and easily while optimising topcoat usage.

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Substrates/Preparation:

P565-510/1 should only be applied over :-

Well scuffed and degreased bare steel. Use **Nexa Autocolor** 2-pack Etch Primer or 2K Epoxy Primer for maximum durability. Aluminium **must** be Etch or 2K Epoxy primed.

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

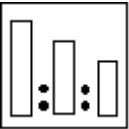




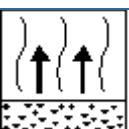


Good preparation is vital in order to obtain the best results from these products. The following grades of flating paper are recommended for substrate preparation :-

Wet or dry paper	P280-P320 (GRP P400)
Dry machine sanding	P180-P220

NOTE : Not recommended for spot repairs over thermoplastic acrylic, old lacquer finishes or sensitive substrates. Over these substrates, apply to complete panels only.



Process

	PRIMER SURFACER (100-150 microns)	PRIMER FILLER (150-200 microns)
	P565-510/511 5 parts P210-842/-8430/-844/-845 1 part P850-2K Thinner 1 part	P565-510/511 5 parts P210-842/-8430/-844/-845 1 part P850-2K Thinner 0.5 part
	19-26 secs DIN4 (24-35 secs BSB4) Sprayable for 1 hour Clean gun immediately after use.	30-35 secs DIN4 (41-48 secs BSB4) Sprayable for 30 minutes Clean gun immediately after use
	Gravity fed gun is recommended Fluid tip: Gravity fed : 1.6-1.9 mm Pressure : 2.5-3.5 bar (40-50 psi)	Gravity fed gun is recommended Fluid tip: Gravity fed : 1.7-2.0 mm Pressure : 2.5-3.5 bar 40-50 psi).
	Fluid tip : Gravity fed : 1.6-1.9 mm Pressure : 0.7 bar (10 psi max air cap)	Fluid tip : Gravity fed : 1.7-2.0 mm Pressure : 0.7 bar (10 psi max at air cap)
	2-3 coats to give a film thickness of 100-150 microns (4-6 thou) NB: Film build depends on fluid tip size. For best results see above.	3-4 coats to give a film thickness of 150-200 microns (6-8 thou) NB: Film build depends on fluid tip size. For best results see above.
	Approx. 5 minutes between coats	Approx. 5-7 minutes between coats
	Air-dry at 20°C : 2 hours 75-100 microns (3-4 thou) 3 hours 150 microns (6 thou) Stoving at a metal temp. of 60°C : 20 minutes	Air-dry at 20°C : 3-4 hours 200 microns (8 thou) Stoving at a metal temp. of 60°C : 20 minutes
	Allow 5 minute flash before IR drying Lamp to Panel: 70-100 cm Short wave : 8-12 minutes	Allow 5 minute flash before IR drying Lamp to Panel: 70-100 cm Short wave : 8-12 minutes

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, temperature and application conditions. However, below is a general guide.

Hardener	Temperature Range	Recommended Thinner
P210-842	< 25°C	P850-1491/-1492/-1692/-1693
P210-8430	20 - 25°C	P850-1492/-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.

Infrared drying times given require the short wave infrared lamp to be positioned 70-100 cm away from the panel. Allow P565-510/511 to flash off for 5 minutes before drying with the infrared lamp. Drying times will depend on the type of infrared 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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