

## **Product Data Sheet**

November 2007

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY



**H4730V** 

# HS Primer Filler P565-510 & P565-511

| Product                                 | Description                    |
|---|--------------------------------|
| 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.

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



### **Process**



Finish with the following grades:-

P600 or finer: Solid colour P800 or finer: Basecoats



Finish with the following grades :-

P360 or finer: Solid colours (Direct Gloss).

P400 or finer: Basecoats

P565-510/511 can be directly topcoated with **Nexa Autocolor** 2K topcoat systems.

**TOPCOAT** 

Once flatted, if P565-510/511 is left for more than 2 days it should be re-flatted prior to application of further undercoat or topcoat.

## **General Process Notes**

#### **PAINTING PLASTICS**

P565-510/511 may be applied over primed plastic.

If P565-510/511 is applied over a flexible plastic, e.g. PP/EPDM, PBT (Pocan) or PUR it must be mixed as follows:-

P565-510/511 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 flatting and drying properties.

For more detailed information on the painting of plastic substrates, refer to the

Painting Plastics PDS.

#### SPECTRAL GREYS

For each of the Spectral Grey primer variants specified the following mixing ratio applies:

|           | SG01 | SG02 | SG03 | SG04 | SG05 | SG06 | SG07 |
|-----------|------|------|------|------|------|------|------|
| P565-511  | 100  | 95   | 80   | 50   | 0    | 0    | 0    |
| P565-510  | 0    | 5    | 20   | 50   | 100  | 99   | 92   |
| P170-5670 | 0    | 0    | 0    | 0    | 0    | 1    | 8    |

#### N.B. Mixing ratios are expressed as weight percentages.

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



#### **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:

Customer Service Sales Group PPG Industries (UK) Ltd Needham Road Stowmarket Suffolk IP14 2AD

Tel: 01449 771771 Fax: 01449 773472

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