

Product Data Sheet

November 2007



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H4830V

Fast HS Wet-on-Wet Primer P565-3030 & P565-3031

<i>Product</i>	<i>Description</i>
P565-3030	Fast HS Wet-on-Wet Primer - Grey
P565-3031	Fast HS Wet-on-Wet Primer - White
P210-842	2K HS Hardener - Fast
P210-8430	2K HS Hardener - Medium/Fast
P210-844	2K HS Hardener - Medium
P210-845	2K HS Hardener - Slow
P170-5670	HS Tinter for Spectral Greys
P850-1491/1492/1493/1494/1495	2K Thinners
P850-1692/1693/1694	2K Low VOC Thinners
P100-2020	Flexible Additive for Plastics

Product Description

P565-3030 and P565-3031 are fast drying 2-pack acrylic primers, designed for use under **Aquabase™** basecoat (P965), **Aquabase Plus** basecoat (P989) and **2K HS Plus** topcoat (P471) to give excellent appearance and adhesion over a wide range of substrates.

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

The range of Spectral Grey primers can be achieved using P565-3030/3031 and ensure that high quality colour matches can be achieved quickly and easily while optimising topcoat usage.

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SUBSTRATES AND PREPARATION

P565-3030/3031 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 aluminium and steel.

New panels in good quality Electrocoat, after lightly sanding using **Scotch-Brite™**, leaving it as intact as possible, prior to application of the wet-on-wet primer.

Process

	<p>With 2K Thinners 14XX</p> <p>P565-3030/3031 5 parts P210-842/8430/844/845 1 part P850-14XX 1.5 parts</p> <p>NOTE: DO NOT add Accelerators</p>	<p>With 2K Low VOC Thinners 16XX</p> <p>P565-3030/3031 5 parts P210-842/8430/844/845 1 part P850-16XX 2 parts</p> <p>NOTE: DO NOT add Accelerators</p>
	<p>Activated viscosity: 17 - 19 secs DIN4 (20 - 22 secs BSB4)</p> <p>Pot-life : 45 min at 20°C. Clean gun immediately after use</p>	
	<p>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)</p>	
	<p>Fluid Tip Gravity Fed : 1.4-1.6 mm Suction Fed : 1.6-1.8 mm Pressure : 0.7 bar (10 psi max at cap.)</p>	
	<p>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 at gun inlet)</p>	
	<p>Apply 1 full single coat or 1 double coat This gives a film thickness of approximately 25-35 microns (1.0 - 1.4 thou.)</p>	
	<p>10 - 15 minutes at 20°C before topcoating at a film thickness of 1.0 - 1.4 thou. (25-35 microns)</p>	
	<p>Normally P565-3030/3031 Wet-on-wet primers do not require flattening and can be directly topcoated. If some dirt inclusion occurs, light wet flattening/denibbing can be carried out after 15-20 minutes using P1200 or finer flattening paper.</p>	
<p>TOPCOAT</p>	<p>P565-3030/3031 can be directly topcoated with Aquabase™ basecoat (P965), Aquabase Plus basecoat (P989) or 2K HS Plus topcoat (P471).</p>	

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General Process Notes

PAINTING PLASTICS

P565-3030/3031 may be applied over prepared painted or primed plastic.
If P565-3030/3031 is applied over a flexible plastic, e.g. PP/EPBM, PBT (Pocan), or PUR it must be mixed as follows :-

P565-3030/3031	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 TDS.

SPECTRAL GREYS

In order to maintain a VOC below 540 g/l, 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
P565-3031	100	95	80	50	0	0	0
P565-3030	0	5	20	50	100	97.5	87.5
P170-5670	0	0	0	0	0	2.5	12.5

N.B. 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	P850-1491/192//1692/1693
P210-8430	20 - 30°C	P850-492/1493/1494//1692/1693/1694
P210-844	25 - 30°C	P850-1493/1494//1693/1694
P210-845	30°C >	P850-1494/1495//1694

Weight Activation

WEIGHT ACTIVATION FIGURES: FOR USE WITH 14XX THINNERS AT 5/1/1.5 MIXING RATIO
Weights are in grams & cumulative. Do not tare the balance between additions

Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
P565-3030/3031	202.6	405.2	607.8	810.5	1013
Hardener P210-842/8430/844/845	229.2	458.4	687.6	916.8	1146
Thinner P850-14XX	265.6	531.2	796.8	1062.4	1328

WEIGHT ACTIVATION FIGURES: FOR USE WITH 16XX THINNERS AT 5/1/2 MIXING RATIO
Weights are in grams & cumulative. Do not tare the balance between additions

Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
P565-3030/3031	190	380	570	760	950
Hardener P210-842/8430/844/845	215	430	645	860	1075
Thinner P850-16XX	255.8	511.6	767.4	1023.2	1279

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 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 these products 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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