

Product Data Sheet

August 2006

INTERNATIONAL MASTER
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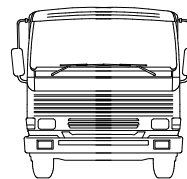
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Primecoat P565-625

<i>Product</i>	<i>Description</i>
<i>P565-625</i>	<i>Primecoat - greyish green</i>
<i>P275-124</i>	<i>Standard Activator</i>
<i>P275-232</i>	<i>Slow Activator</i>
<i>P275-292</i>	<i>Extra Slow Activator</i>
<i>P851-396</i>	<i>Fast thinner</i>
<i>P850-1391</i>	<i>Turbo Plus™ Slow thinner</i>

Product Description

Primecoat, etch primer undercoat, combines the benefits of acid etch for adhesion with good filling properties. Mainly for use over bare metal its build and neutral colour can cut out the need for an undercoat on new work. A standard activator is available for general-purpose use and slow and extra slow activators are available for use over larger surface areas and/or in hot conditions.



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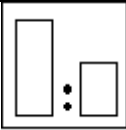





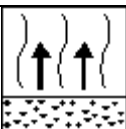


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Standard and Fast Process

HVLP and Conventional Application

	P565-625 1 part P275-124/-232 /-292 1 part
	Allow activated paint to stand for 20 minutes before use. Pot Life at 20°C : 2 days
	17-18 DIN4 (21-23 secs BSB4) at 20°C Adjust viscosity with small additions of P851-396 / P850-1391. Do NOT add further activator
	1.4-1.8 mm 3.3 -4.3 bar (50-65 psi)
	0.85-1.0 mm Air cap pressure : 0.675 bar (10 psi) maximum
	1 or 2 full coats 12-25 microns (0.5-1.0 thou)
	1- 2 minutes minimum between coats. 5 minutes minimum before stoving. Leave slightly longer with Slow or Extra Slow Activator.
	Air Dry (20°C) : Recoat : 1 hour Stoving at metal temperature of : 50°C 20 minutes
	Flattening is not normally required and is not recommended

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General Process Notes

SUBSTRATES AND PREPARATION

Any contamination from the fitting of rubbers on windows etc. must be thoroughly removed by using P850-1367 prior to the application of P565-625.

SUBSTRATES	PREPARATION	NOTES
Steel	Blast cleaning is the preferred surface treatment for maximum durability and optimum paint usage. Alternatively flat thoroughly using P80-P180 dry sanding machine discs or P120-P220 wet and dry paper, then clean with P850-1378	Surface must be free from oil/grease, millscale and rust.
Stainless Steel	Degrease with P850-1367 and scuff using P180-240 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378.	
Sound Factory Finishes Sound Works Primer Sound old finishes (2-pack) Sound electrocoat	Flat thoroughly using P240-P320 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378	Old synthetic finishes must be well cured and non-bleeding
Aluminium	Degrease with P850-1367 and abrade the surface using P180-P320 dry sanding machine discs, P400-P600 wet and dry paper	
Weathered galvanised steel Zintec	Clean with P273-901; degrease with P850-1367 and sand using P180-P320 dry sanding machine discs.	Surface must be free from oxidation residues
Hot dipped galvanised steel	Thoroughly degrease with P850-1367, scuff with Scotchbrite™ Fine or P400 wet and dry paper, then clean with P850-1378.	
GRP "Glasonite"	Clean with P273-901. Flat thoroughly using P240-P280 dry sanding machine discs or P320-P400 wet and dry paper, then clean with P850-1378.	Take care not to break through the gel coat when flattening GRP.

P565-625 is **NOT** recommended for use over thermoplastic substrates.

For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS.

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General Process Notes

RECOAT

May be recoated with **Nexa Autocolor** Commercial Transport 1-pack and 2-pack primers/undercoats or directly topcoated with **Nexa Autocolor** Commercial Transport 1-pack and 2-pack topcoats. See appropriate PDS for further details.

For best results P565-625 should be recoated within 24 hours.

APPLICATION EQUIPMENT INFORMATION

HVLP

The most suitable HVLP gun for the application of Commercial Transport products is a pressure feed system.

Air cap pressure : 0.675 bar (10 psi) maximum

Paint pressure : 0.3-1.0 bar (5-15 psi)

If long fluid lines are used, the paint pressure will need to be increased.

Brushing

Primecoat can be applied by brush over small areas where spray application is not possible.

Airless/Air Assisted Airless

Not recommended for airless or air assisted airless (air mix) application.

DRYING

Do not force dry or low bake synthetic colour coats which have been applied directly over Primecoat. If low bake is required use Repaint Undercoat (P595-line) as an intermediate sealing coat.

The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, temperatures below 20°C and excessive film thickness will extend the drying times.

SELECTION OF ACTIVATOR AND THINNER

This will depend on the temperature, air movement and size of job. For high temperatures and larger areas use P275-232

Slow Activator.

CORROSION PROTECTION

For optimum corrosion resistance apply a minimum of 25 microns (1 thou).

RECTIFICATION

Care must be taken when spot priming fresh synthetic topcoats. Alternative primers for spot repairs are Fastbuild™ (P540-line)

or Repaint Undercoat (P595-line).

COVERAGE

Approximately 9m² per litre of ready for use paint at a dry film thickness of 12 microns (0.5 thou).

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VOC INFORMATION

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 780g/litre of VOC.

The VOC content of this product in ready to use form is max. 780g/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.

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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