

Product Data Sheet

August 2006

INTERNATIONAL MASTER
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U1130V

HS High-Build, Primer Surfacer P565-1027 /1028 - Grey / White

<i>Product</i>	<i>Description</i>
P565-1027/8	HS High build, Primer Surfacer – Grey / White
P210-982	EHS Turbo Plus Hardener
P210-821	Turbo Plus Hardener – Slow
P210-822	Turbo Plus Hardener – Medium
P852-1792	EHS Turbo Plus Additive Thinner – Medium
P852-1794	EHS Turbo Plus Repair Thinner

Product Description

P565-1027 and P565-1028 HS High-build, Primer are high performance 2-Pack undercoats for use under Nexa Autocolor 2-Pack topcoats. When used with EHS Turbo Plus ancillaries, P565-1027/1028 has a ready-for-use VOC of less than 540g/l.

P565-1027 P565-1028 HS High-build, Primer have been specifically designed for application over large areas. They can be used in wet-on-wet and high-build modes and when dry have excellent flattening characteristics.



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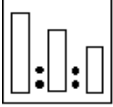

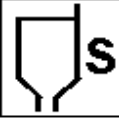


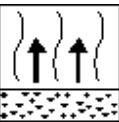



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Standard and Fast Process

	EHS Mode (Below 540g/L VOC)	MS Mode (Below 540g/L VOC)
 <p>Standard build mode including wet-on-wet and non-sand</p> <p>High Build mode</p>	<p>P565-1027/1028 7 parts P210-982 1 parts P852-1792/4 1 part</p> <p>P565-1027/1028 7 parts P210-982 1 parts</p>	<p>P565-1027/1028 4 parts P210-821/-822 1 part</p>
	<p>Pot life at 20°C: 1 hour</p> <p>Clean gun immediately after use</p>	<p>Pot life at 20°C: 1-2 hours</p> <p>Clean gun immediately after use</p>
	<p>Standard Build 23-29s. DIN4 (35-45s. BSB4)</p>	
	<p>Gravity or Suction feed: 1.6-1.8 mm Air cap pressure: 3.7-4.0 bar (55-60 psi)</p> <p>Pressure feed: 1.0-1.4 mm</p>	
	<p>Gravity or Suction feed: 1.6-1.8 mm Air cap pressure: 0.675 bar (10psi) max.</p> <p>Pressure feed: 0.85-1.4 mm HVLP/compliant</p>	
	<p>10-15 minutes between coats, depending on dry film thickness and drying conditions</p> <p>Flash off 15-30 minutes before stoving</p>	
	<p>Air Dry (20°C) : Dust free: 10-15 min. Tack free: 30-60 min. Hard dry: 4 hours</p>	<p>Low Bake (60°C metal temperature): Hard dry: 30 min.</p>
<p>Can be recoated wet-on-wet after a minimum of 30 min air dry If recoating with Turbo Plus metallic basecoat, allow at least two hours drying time otherwise lifting of the paint film may occur.</p>		
	<p>Wet Flattening: P600 or finer Solid Colours P860 or finer Basecoats.</p>	
	<p>Machine sanding: P240 or finer Solid Colours. P360 or finer Basecoats</p>	

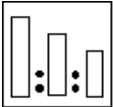








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	Express Mode (Below 540g/L VOC)
 Standard build mode	P565-1027/1028 7 parts P210-982 1 parts P852-1792/4 1 part
	Pot life at 20°C: 15 mins. Clean gun immediately after use
	Standard Build 23-29s. DIN4 (35-45s. BSB4)
	Gravity or Suction feed: 1.6-1.8 mm Air cap pressure: 3.7-4.0 bar (55-60 psi) Do not use in pressure feed system
	Gravity or Suction feed: 1.6-1.8 mm Air cap pressure: 0.675 bar (10psi) max. Do not use in pressure feed system
	5 minutes between coats, depending on dry film thickness and drying conditions Flash off 5-10 minutes before stoving
	Force Dry / Low Bake 30°C -: 20 min. 40°C -: 10 min. Flattable as soon as cooled.
	Wet Flattening: P600 or finer Solid Colours P860 or finer Basecoats.
	Machine sanding: P240 or finer Solid Colours. P360 or finer Basecoats



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General Process Notes

NOTE:

**Not recommended for use directly to metal.
Use Etch Primer and refer to relevant PDS**

SUBSTRATES:

Steel
Stainless Steel
Aluminium
Galvanised steel
Zintec

Sound Factory finishes
Sound works primer
Sound old finishes (2-pack)
Sound electrocoat
GRP
"Glasonite"

PREPARATION:

Abrade using P180-240 dry sanding machine discs or P180-400 wet and dry paper, then clean with P850-1378
Then pre-prime with Etch Primer P565-625 Primecoat or P565-767 CFE Primer

Flat thoroughly using P240- P320 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378

RECOAT

Drying times will depend on film thickness and drying conditions. In common with other primers, longer drying times before recoat will improve final appearance.

Topcoat with EHS Turbo Plus or CT Aquabase
Also may be recoated with any other Nexa Autocolor Commercial Transport 2-pack topcoat

When using CT Aquabase (P962-Line), it is important that P565-1027/1028 is hard dry prior to application of the Aquabase basecoat .

TINTING

P565-1027 /1028 can be tinted. EHS Turbo Plus Tinters can be added up to a maximum of 5% to P565-1027/1028, which should then be activated and thinned according to the P565-1027/1028 process recommendations.

For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS Q0100.



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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.

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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