

# Product Data Sheet

April 2010

INTERNATIONAL MASTER  
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# S0100V

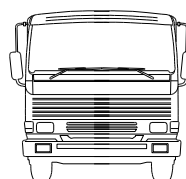
CF Etch Primer P565-767	
Product	Description
P565-767	CF Etch Primer
P275-533	Medium Activator
P850-1393	Turbo Plus™ Fast Thinner
P851-396	Fast Thinner

## Product Description

A Chromate-free 2-pack high build etch primer which is fast drying, has good corrosion resisting properties and excellent adhesion to a wide variety of substrates.

## TYPE OF PRODUCT

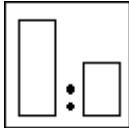
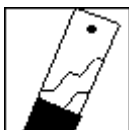



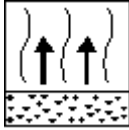

Acid catalysed etching primer.



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**PROCESS**

	CONVENTIONAL	HVLP
	P565-767 1 part P275-533 1 part	P565-767 1 part P275-533 1 part
		
	18-20 DIN4 (23-27 secs BSB4)  Adjust viscosity with small additions of fast thinner P851-396 or Turbo Plus Fast Thinner P850-1393. Do NOT add further activator.	18-20 DIN4 (23-27 secs BSB4)  Adjust viscosity with small additions of fast thinner P851-396 or Turbo Plus Fast Thinner P850-1393. Do NOT add further activator.
	Fluid tip: 0.55-0.070 in (1.4-1.8mm)  Pressure at cap: 3.3-4.3 bar (50-65 psi)	Fluid tip: 1.0-1.4mm (0.39-1.055in) Air cap consumption: 15-17 CFM  Pressure at cap: 0.675 bar (10 psi) maximum
	2 single coats to give a film thickness of 25 microns (1 thou)	2 single coats to give a film thickness of 25 microns (1 thou)
	10 minutes minimum between coats.	10 minutes minimum between coats.
	Air dry 30 mins - 1 hour at 20C before overcoating.  Flash-off for 10 minutes minimum, stove 20 mins at 50C metal temperature.	Air dry 30 mins - 1 hour at 20C before overcoating.  Flash-off for 10 minutes minimum, stove 20 mins at 50C metal temperature.

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## GENERAL PROCESS NOTES

### SUBSTRATES AND PREPARATION

The substrates to be painted must be dry, clean, free of corrosion, grease and mould release agents. Substrates need to be thoroughly degreased by hand using **Nexa Autocolor** solvent.

SUBSTRATES	PREPARATION	NOTES
Steel Zintec Weathered Galvanised-Steel Sound Works Primers Sound old finishes	Blast clean steel Flat thoroughly using P280-P320 wet or dry paper or P180-P220 machine sanding, then spirit wipe.	Rust and mill-scale must be removed from steel Old synthetic finishes must be thoroughly hardened Not recommended over Thermoplastic
GRP	Clean with Bodykleen P273-901, flat thoroughly and clean with Prep-Pak 1 P850-1367	
Aluminium	Aluminium substrates must be very thoroughly flatted using P280-P320 wet or dry paper of P180-P220 machine sanding, then spirit wipe.	Old synthetic finishes must be well cured and non-bleeding
Hot dipped galvanised steel	Treat with Mordant Solution (A273-1041) prior to priming	

### RECOAT

May be recoated with any of the **Nexa Autocolor** Commercial Transport 2-pack undercoats or directly with Turbo Plus and Turbo Plus HS Topcoats, with the exception of Epoxy Primers.

P565-767 is **NOT** recommended for use beneath synthetic topcoat lines such as HI-Gloss 383.

### COVERAGE

About 9m<sup>2</sup> per litre of activated paint at a dry film thickness of 12.5 microns (0.5 thou).

### FLATTING

May be flatted by hand when hard dry (minimum 2 hours at 20oC) with P600-P800 wet and dry paper.

### POT LIFE

Only freshly mixed material will give best protection against corrosion. To obtain maximum adhesion mixed material should be used within 24 hours.

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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](http://www.ppg.com/Autocolor_MSDS)

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