

Product Data Sheet

November 2011



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H4700V

Eco+ Primer Surfacer P565-4471, P565-4475 & P565-4477

Product	Description
P565-4471	Eco+ Primer Surfacer – Light Grey SG01
P565-4475	Eco+ Primer Surfacer – Grey SG 05
P565-4477	Eco+ Primer Surfacer – Dark Grey SG 07
P210-4470	2K HS Hardener
P850-1692/1693/1694/1695	2K Low VOC Thinners
P100-2020	Flexible Additive for Plastics

Product Description

P565-4471, P565-4475 and P565-4477 **Eco+ Primer Surfacers** incorporate a raw material produced from high quality PET flakes from recycled plastic bottles. **Eco+ Primer Surfacers** are designed for use under **Nexa Autocolor** topcoat systems.

They are easy to apply with excellent flow to minimise sanding and give excellent final appearance and durability.

A range of Spectral Grey primers can be achieved using P565-4471/4475/4477, which ensure that coverage can be achieved quickly and easily while optimising topcoat usage.

SUBSTRATES AND PREPARATION

The P565-447X primer fillers should only be applied over:

Etch primed bare steel.

(Bare steel should be well sanded & degreased. Use **Nexa Autocolor** 2-pack Etch Primer or 2-pack Epoxy Primer for maximum durability)

Aluminium must be Etch or Epoxy primed.

Well sanded 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 sanding paper are recommended for final substrate preparation: -

When using as a Sandable Product

Wet flatting P280-P320 (GRP P400)

Dry machine sanding P180-P220

CHOICE OF THINNER

The choice of thinner should be made according to application temperature, hardener choice, air movement and size of job. The recommendations below are for guidance only: -

P850-16xx Thinner	Ideal temperature range:
	-
P850-1692	Below 22°C
P850-1693	18 - 25°C
P850-1694	25 - 35°C
P850-1695	Above35°C

PAINTING PLASTICS

P565-447X may be applied over primed plastic.

If P565-447X is applied over a flexible plastic, e.g. PP/EPDM, PBT (Pocan) or PUR it must be mixed as follows: -

P565-447X 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 plastics, refer to the Painting Plastics PDS.



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High Build & Primer Surfacer Process Primer Surfacer High Build P565-4471/4475/4477 3 parts P565-4471/4475/4477 3 parts P210-4470 1 part P210-4470 1 part P850-1692/3/4/5 0.5 parts P850-1692/3/4/5 1 part **NOTE: DO NOT add Accelerators** Viscosity: 25 - 30 secs DIN4 @ 20°C Viscosity: 18 - 20 secs DIN4 @ 20°C Pot-life: 20 - 30 min at 20°C Pot-life: 30 - 45 min at 20°C Clean gun immediately after use Clean gun immediately after use **Fluid Tip Fluid Tip** 1.6 - 1.8 mm Gravity Fed: 1.6 - 1.8 mm Gravity Fed: COMPLIANT Inlet Pressure: Refer to spraygun Inlet Pressure: Refer to spraygun manufacturers manufacturers recommendation recommendation (normally 2 bar / 30 psi). (normally 2 bar / 30 psi). 2 - 3 coats to give a film 2 coats (max 3) to give a film thickness of 150 - 200 microns thickness of 75 - 125 microns Between coats: Approx. 5 minutes depending on spraying conditions Before Force Drying: Approx. 0 - 5 minutes depending on film thickness applied



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High Build & Primer Surfacer Process

High Build	Primer Surfacer			
Air-dry at 20°C: 4 - 6 hours 150 - 200 microns Baking at a metal temperature of 60°C: 40 minutes	Air-dry at 20°C: 3 - 4 hours 75 - 125 microns Baking at a metal temperature of 60°C: 30 minutes			



Short wave: 8-12 minutes

Medium Wave: 12 minutes

Keep film builds below 150 microns

Infrared drying times given require the short wave infrared lamp to be positioned 70-100 cm away from the panel. Allow P565-447x primer fillers to flash off for 5 minutes before drying with the infrared lamp. Drying times will depend on the type of infrared lamp used.



Finish with the following grades: -

P360 or finer: Single layer solid colours (Direct Gloss)

P400 or finer: Basecoats.



Finish with the following grades: -

P600 or finer: Single layer solid colours (Direct Gloss).

P800 or finer: Basecoats.

TOPCOAT

P565-447X primer fillers can be directly topcoated with **Nexa Autocolor** 2K topcoat systems.

If P565-447X primer fillers are left for more than 2 days after sanding, they should be sanded again prior to application of further undercoat or topcoat.



Spectral Grey

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

Spectral Grey Shade	Product number	Mix % (by wt.)
SG1	P565-4471	100
SG3	P565-4471 P565-4475	80 20
SG5	P565-4475	100
SG6	P565-4475 P565-4477	25 75
SG7	P565-4477	100

Weight Activation

WEIGHT ACTIVATION FIGURES: FOR USE IN HIGH BUILD MODE AT MIXING RATIO 3:1:0.5

Weights are in grams & cumulative. Do not tare the balance between additions

Target Paint Volume (L)	0.25 L	0.33 L	0.50 L	0.66 L	0.75 L	1.00 L
P565-447X	263	348	527	695	790	1053
Hardener P210-4470	323	426	646	852	968	1291
Thinner P850-16XX	346	456	691	912	1037	1382

WEIGHT ACTIVATION FIGURES: FOR USE AS PRIMER SURFACER AT MIXING RATIO 3:1:1

Weights are in grams & cumulative. Do not tare the balance between additions

Target Paint Volume (L)	0.25 L	0.33 L	0.50 L	0.66 L	0.75 L	1.00 L
P565-447X	237	313	474	626	711	948
Hardener P210-4470	290	383	581	767	871	1162
Thinner P850-16XX	331	438	663	875	994	1326



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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 these products 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 Heath and Safety information please refer to the material Safety Data Sheet, also available at: **www.nexaautocolor.com**

For further information please contact:

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