

Product Data Sheet

November 2011



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H4700V

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

<i>Product</i>	<i>Description</i>
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

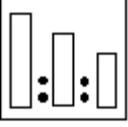
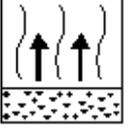
Product Description

P565-4471, P565-4475 and P565-4477 **Eco+ Primer Surfacer**s 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.

High Build & Primer Surfacer Process

	High Build	Primer Surfacer
	P565-4471/4475/4477 3 parts P210-4470 1 part P850-1692/3/4/5 0.5 parts	P565-4471/4475/4477 3 parts P210-4470 1 part P850-1692/3/4/5 1 part
	NOTE: DO NOT add Accelerators	
	Viscosity: 25 - 30 secs DIN4 @ 20°C Pot-life: 20 - 30 min at 20°C Clean gun immediately after use	Viscosity: 18 - 20 secs DIN4 @ 20°C Pot-life: 30 - 45 min at 20°C Clean gun immediately after use
	<u>Fluid Tip</u> Gravity Fed: 1.6 - 1.8 mm Inlet Pressure: Refer to spraygun manufacturers recommendation (normally 2 bar / 30 psi).	<u>Fluid Tip</u> Gravity Fed: 1.6 - 1.8 mm Inlet Pressure: Refer to spraygun manufacturers recommendation (normally 2 bar / 30 psi).
	2 coats (max 3) to give a film thickness of 150 - 200 microns	2 - 3 coats to give a film 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	



High Build & Primer Surfacer Process

	High Build	Primer Surfacer
	<p>Air-dry at 20°C: 4 - 6 hours 150 - 200 microns</p> <p>Baking at a metal temperature of 60°C: 40 minutes</p>	<p>Air-dry at 20°C: 3 - 4 hours 75 - 125 microns</p> <p>Baking at a metal temperature of 60°C: 30 minutes</p>
	<p>Short wave: 8-12 minutes</p> <p>Medium Wave: 12 minutes</p> <p>Keep film builds below 150 microns</p> <p>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.</p>	
	<p>Finish with the following grades: -</p> <p>P360 or finer: Single layer solid colours (Direct Gloss)</p> <p>P400 or finer: Basecoats.</p>	
	<p>Finish with the following grades: -</p> <p>P600 or finer: Single layer solid colours (Direct Gloss).</p> <p>P800 or finer: Basecoats.</p>	
TOPCOAT	<p>P565-447X primer fillers can be directly topcoated with Nexa Autocolor 2K topcoat systems.</p> <p>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.</p>	



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	80
	P565-4475	20
SG5	P565-4475	100
SG6	P565-4475	25
	P565-4477	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



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 Health 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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