

Product Data Sheet

January 2016

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY

H5680

Speed Surfacer P565-5801, P565-5805 & P565-5807

| <i>Product</i> | <i>Description</i> |
|----------------|---|
| P565-5801 | Speed Surfacer – White Spectral Grey 01 |
| P565-5805 | Speed Surfacer – Grey Spectral Grey 05 |
| P565-5807 | Speed Surfacer – Dark Grey Spectral Grey 07 |
| P210-842 | 2K HS Hardener - Fast |
| P852-1680 | Accelerator Thinner for Speed Surfacer |
| P852-1690 | Accelerator Thinner (For high temperature application) |
| P850-1694 | Slow Thinner for IR |

Product Description

Speed Surfacer combines process speed and ease of application with excellent sanding properties. Speed Surfacer is a primer that is incredibly fast and easy to apply, with excellent sanding properties. It has a quick and user-friendly one visit application (with little or no flash off), and air dries in less than an hour; improving bodyshop efficiency without compromising on the quality of the final finish.

P565-5801, P565-5805 and P565-5807 are 2K HS acrylic primer fillers, designed for use under 2K topcoats (P420/P421/P471), 2K Basecoats (P422), & Aquabase Plus (P989). They are easy to apply and sand and give excellent final appearance and durability.

Speed Surfacer is available in three spectral grey shades (and can be mixed to provide further shades) in order to be able to provide the optimum spectral grey for every color. This further improves productivity and profitability by reducing basecoat consumption.

SUBSTRATES AND PREPARATION

The P565-580X surfacers should only be applied over:

Well sanded and degreased bare steel. Use *Nexa Autocolor* 2-pack Etch Primer or 2-pack Epoxy Primer for maximum durability. Aluminium **must** be Etch or Epoxy primed.

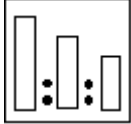
Well sanded GRP, polyester fillers works primer and old finishes in sound condition.

Good preparation is vital in order to obtain the best results from these products. The following grades of sanding paper are recommended for substrate preparation: -

| | |
|---------------------|------------------------|
| Wet or dry paper | P280 - P320 (GRP P400) |
| Dry machine sanding | P180 - P240 |

NOTE: Not recommended for spot repairs over thermoplastic acrylic, old lacquer finishes or sensitive substrates. Over these substrates, apply to complete panels only.

Process



PRIMER SURFACER

| | |
|-----------------------|---------|
| P565-5801/5805/5807 | 4 parts |
| P210-842 | 1 part |
| P852-16XX / P850-1694 | 1 part |

NOTE: FOR ACCURATE ACTIVATION AND THINNING, WEIGHT MIXING IS RECOMMENDED (SEE PAGE 6).



Activated viscosity: 25 - 30 secs DIN4 @ 20°C (4 : 1 : 1 activation)

Pot-life: 45 min at 20°C

Clean gun immediately after use



Fluid Tip

Gravity Fed: 1.6 mm
 Inlet Pressure: Refer to spraygun manufacturers recommendation (normally 2 bar / 30 psi).



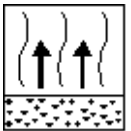
Fluid Tip

Gravity Fed: 1.6 mm
 Pressure: Refer to spraygun manufacturers' recommendation (0.7 bar / 10 psi max at air cap).







1 medium coat + 2 full coats to give a film thickness of 75 - 120 microns

NB: Film build depends on thinner addition and fluid tip size.



Between coats: 1 min after first coat. No flash off in 2-3 coat

Before Force Drying: Until Matt (depending on spraying conditions)

| Process | | |
|---|---|--|
|  | <p>Air-dry at 20°C: 1 hour</p> | <p>Air-dry below 20°C: 1 hour</p> |
| | <p>Baking at a metal temperature of 60°C: 20 – 25 minutes depending on film thickness</p> | |
|  | <p>High Wave: 12 minutes P850-1694 to be used for IR drying process. Allow P565-580X surfacers to flash off for 5 minutes before drying with the infrared lamp. Drying times will depend on the type of infrared lamp used. Max 120 microns when using force dry process.</p> | |
|  | <p>Finish with the following grades: - P360 or finer: Single layer solid colours (Direct Gloss) P400 or finer: Basecoats</p> | |
|  | <p>Finish with the following grades: - P600 or finer: Single layer solid colours (Direct Gloss) P800 or finer: Basecoats</p> | |
| TOPCOAT | <p>P565-580X surfacers can be topcoated with <i>Nexa Autocolor</i> 2K topcoats (P420/P421/P471), 2K basecoats (P422) & Aquabase Plus (P989).</p> <p>If P565-580X surfacers are left for more than 2 days after sanding, they should be sanded again prior to application of further undercoat or topcoat.</p> | |

Process

SPECTRAL GREYS

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

| | Product number | Mix % (by wt.) | Mix by Target Weight | | |
|-----|----------------|----------------|----------------------|------|------|
| | | | 100g | 250g | 500g |
| SG1 | P565-5801 | 100 | 100g | 250g | 500g |
| | | | | | |
| SG3 | P565-5801 | 58 | 58g | 145g | 290g |
| | P565-5805 | 42 | 42g | 105g | 210g |
| | | | | | |
| SG5 | P565-5805 | 100 | 100g | 250g | 500g |
| | | | | | |
| SG6 | P565-5805 | 48 | 48g | 120g | 240g |
| | P565-5807 | 52 | 52g | 130g | 260g |
| | | | | | |
| SG7 | P565-5807 | 100 | 100g | 250g | 500g |

CHOICE OF HARDENER AND THINNER

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

Hardener:

P210-842
P210-842

Thinner:

P852-1680
P852-1690

Ideal temperature range:

Below 25°C
Over 25°C

Process

Weight Activations for use with HS hardeners (P210-842) Ratio 4 : 1 : 1

Please note the weights are cumulative. Do not tare or zero scale between additions

| RFU Sprayable Volume | P565-5801 Grams | P210-842 Grams | P852-1680/90 P850-1694 Grams |
|----------------------|-----------------|----------------|------------------------------|
| 1.0L | 971 | 1134 | 1150 |
| RFU Sprayable Volume | P565-5805 Grams | P210-842 Grams | P852-1680/90 Grams |
| 1.0L | 878 | 1042 | 1184 |
| RFU Sprayable Volume | P565-5807 Grams | P210-842 Grams | P852-1680/90 Grams |
| 1.0L | 885 | 1048 | 1191 |

Flexible Additive Weight Activations for use with HS hardeners (P210-842)

Please note the weights are cumulative. Do not tare or zero scale between additions

| RFU Sprayable Volume | P565-5801 | P100-2020 | P210-842 | P852-1680/90 P850-1694 |
|----------------------|-----------|-----------|----------|------------------------|
| 1.0L | 808 | 918 | 1091 | 1234 |
| RFU Sprayable Volume | P565-5805 | P100-2020 | P210-842 | P852-1680/90 |
| 1.0L | 730 | 839 | 1013 | 1156 |
| RFU Sprayable Volume | P565-5807 | P100-2020 | P210-842 | P852-1680/90 |
| 1.0L | 736 | 846 | 1019 | 1162 |

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For Health and Safety information please refer to the material Safety Data Sheet, also available at: www.nexaautocolor.com

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