

Product Data Sheet

Oct 2015



FOR PROFESSIONAL USE ONLY

H5932V

Self Levelling Primer P565-5601, P565-5605, P565-5607 (using P210-8815 HS Plus Hardener)

<i>Product</i>	<i>Description</i>
P565-5601	Self Levelling Primer - SG1
P565-5605	Self Levelling Primer - SG5
P565-5607	Self Levelling Primer - SG7
P210-8815	HS Plus Hardener
P850-1692/1693/1694/1695	2K Low VOC Thinners
P852-1690	2K Accelerator Thinner
P852-1670	Plastic additive for primer

Product Description

Self Levelling Primer, P565-560X, is based on the latest technical developments in primer technology, and should be used where optimisation of the repair process is a key requirement. Self Levelling Primer, designed for use under **Aquabase Plus** basecoat (P989) and **2K HS Plus** topcoat (P471), provides a truly productive process that removes the need for sanding. This product can be applied direct to Electrocoat and can be topcoated up to five days later without the need for primer sanding.







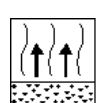

Excellent application combined with the self levelling properties provide a high quality finish, equivalent to that provided by a traditional sanded primer, and delivers a non-sanding route to optimise the whole repair process.

Especially valuable for new panel work, Self Levelling Primer allows booth utilisation to be optimised by providing the opportunity for priming new panels in advance in small batches, ready for topcoating at the same time as the vehicle.

The strong adhesion and anti-corrosion properties of Self Levelling Primer, P565-560X allows small rub through areas of bare metal to be primed without the need for an Etch Primer, again saving a step in the repair process.

The addition of P852-1670 Plastic additive for primer will allow new bare TPO, PP/EPDM panels to be painted with Self Levelling Primer.

Process

	<p>With 2K Low VOC Thinners P850-16xx</p> <p>P565-560X 4 parts P210-8815 1 part P850-16XX or P852-1690* or P852-1670 2 parts</p> <p>* (for optimum performance at 20-25°C)</p>
	<p>Activated viscosity: 16 - 18 seconds DIN4 (20 - 22 seconds BSB4)</p> <p>Pot-life: 60 min at 20°C. Clean gun immediately after use</p>
	<p>Fluid Tip</p> <p>Gravity Fed : 1.2-1.3 mm Pressure : 3.0 – 3.7 bar (45 – 55 psi)</p>
	<p>Fluid Tip</p> <p>Gravity Fed : 1.2-1.3 mm Pressure : 0.7 bar (10 psi max at cap.)</p>
	<p>Fluid Tip</p> <p>Gravity Fed : 1.2-1.3 mm</p> <p>Inlet Pressure : Refer to spraygun manufacturers instructions, (Normally 2 bar/30 psi at gun inlet)</p>
	<p>Apply 1 full single coat or 1 light + 1 full This gives a film thickness of approximately 25 - 35 microns (1.0 - 1.4 thou.)</p> <p>Apply to achieve an even finish. Do not apply heavy coats.</p>
	<p>No flash off between coats is necessary where a single visit application is used.</p> <p>15 minutes at 20°C before topcoating at a film thickness of 1.0 - 1.4 thou. (25-35 microns)</p>
	<p>Ready for topcoat after 15 minutes, or up to 5 days with no sanding required. If some dirt inclusion occurs, light dry flatting / de-nibbing can be carried out after first coat of Aquabase Plus, using P800 or finer with foam pad.</p> <p>For any other need force dry before sanding.</p> <p>If left more than 8 hours, then preclean before topcoating</p> <p>If left more than 3 days before topcoating, then light de-nibbing and precleaning is recommended,</p> <p>Sand with P400 dry or finer if left for more than 5 days.</p>
<p>TOPCOAT</p>	<p>P565-560X can be directly topcoated with Aquabase Plus basecoat (P989) or 2K HS Plus topcoat (P471).</p>

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General Process Notes

CHOICE OF HARDENER AND THINNER

The exact choice of hardener and thinner combination will depend on the gun set-up used, air movement, size of repair, temperature and application conditions. However, below is a general guide :

Hardener	Temperature Range	Recommended Thinner
P210-8815	Below 25°C	P852-1690
P210-8815	- 30°C	P850-1692/1693/1694
P210-8815	Above 30°C	P850-1694/1695
P210-8815	Applications with IR/gas	P850-1695

SELF LEVELLING PRIMER CAN BE USED IN PRIMER FILLER MODE USING THE FOLLOWING RECOMMENDATIONS

Mix and use the gun set up as recommended in the main Process note.
Apply 1 light + 2 full coats
This gives a film thickness of approximately 100-110 microns

Bake for 30 minutes at 60°C metal temperature.
IR medium wave 5 min flash-off, followed by a 10 min cure time.
IR/GAS 50 cm 110°C.
After cooling dry sand with P400 or finer

SUBSTRATES AND PREPARATION

Self Levelling Primer should only be applied over:
Well cleaned un-sanded Electrocoat.
Bare steel areas up to 10cm diameter without the need for an Etch Primer
Galvanised Steel for rub throughs up to 10cm maximum diameter
Zintec for rub throughs up to 10cm maximum diameter
Aluminium and alloys for rub throughs up to 10cm maximum diameter
Aged painted and original surfaces sanded with P320 or finer
GRP, Fibreglass sanded P120/ P240/P320
Polyester Filler P120/ P240/P320

Note: A 2-pack Etch Primer should be applied prior to the application of Self Levelling Primer for areas of bare metal above 10cm diameter, area's particularly vulnerable to corrosion or for OEM warranty standard corrosion performance.

PAINTING PLASTICS

Self Levelling Primer can be applied directly over well prepared and cleaned ABS, NORYL, PC/PBT, LEXAN, PUR and SMC, as well as sanded and pre-primed bumpers.

With the addition of P852-1670 plastic additive for primer Self Levelling Primer can be applied directly over well prepared and cleaned PP, TPO, PP/EPDM, as well as sanded and pre-primed bumpers.

Thorough preparation and cleaning are essential for the successful refinishing of plastic parts. The **Nexa Autocolor** plastic cleaning and preparation system is designed to produce the best performance from the primer and topcoat systems.

Refer to the Cleaning and Preparation of Plastic Substrates TDS (L0700V)

DEGREASING

Substrates must be cleaned thoroughly with a suitable Nexa Autocolor cleaner.
The substrate cleaner must be wiped off the panel surface immediately using a clean dry cloth.

Mixing Spectral Grey Range

% by wt.	SG1	SG3	SG5	SG6	SG7
-5601	100	75	--	--	--
-5605	--	25	100	48	--
-5607	--	--	--	52	100

Note: The mixed Spectral Grey shade must be activated and thinned as normal.

Weight Activation

WEIGHT ACTIVATION FIGURES: FOR USE WITH 16XX THINNERS AT 4 : 1 : 2 MIXING RATIO
Weights are in grams & cumulative. Do not tare the balance between additions

Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
P565-560X	160	320	480	640	800
Hardener P210-8815	190	381	571	761	951
Thinner P850-16XX,P852-1690	240	474	711	949	1186

WEIGHT ACTIVATION FIGURES: FOR USE WITH P852-1670 THINNER AT 4 : 1 : 2 MIXING RATIO
Weights are in grams & cumulative. Do not tare the balance between additions

Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
P565-560X	160	320	480	640	800
Hardener P210-8815	190	381	571	761	951
Plastic Additive P852-1670	240	481	721	961	1202



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 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 these products 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: www.nexaautocolor.com

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