

Product Data Sheet

March 2018

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY



U0830V_TV

HS Wet-on-wet Undercoat P565-897 – EHS System


<i>Product</i>	<i>Description</i>
<i>P565-897</i>	<i>HS Wet-on-wet Undercoat – off White</i>
<i>P210-7644</i>	<i>EHS Hardener - Standard</i>
<i>P852-6442</i>	<i>EHS Thinner - Slow</i>
<i>P852-6444</i>	<i>EHS Thinner - Medium</i>
<i>P852-6446</i>	<i>EHS Thinner - Fast</i>

Product Description

P565-897 is a fast-drying isocyanate hardened acrylic 2-pack product with excellent adhesion to a variety of substrates and very good holdout properties beneath 2-pack topcoats. When used in conjunction with TURBO VISION® 2-pack Premium High Flow EHS Topcoat hardeners and thinners, the ready-for-use VOC content of this product is lower than 540 g/l.



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Standard and Fast Process

	<p>P565-897 (tinted or untinted) 6 parts P210-7644 1 part Thinner 2,5 parts</p>
	<p>Pot Life at 20°C : approximately 60 minutes</p> <p>Activate between coats</p> <p>Clean gun immediately after use</p>
	<p>15-17 secs DIN4 (19-22 secs BSB4) at 20°C</p>
	<p>1.0-1.4 mm Use compliant spray equipment</p>
	<p>1 or 2 single coats depending on build required</p>
	<p>10-15 minutes between coats, depending on film thickness and drying conditions. Flash off 30 minutes before topcoating</p>
	<p>Air dry (20°C) Recoat : 30 minutes for wet-on-wet use When using P565-987 over etch primers (e.g. P565-625/-767) it is essential that the topcoat or basecoat is applied in the specified recoat time or if left longer should be recoated after 6 hours, otherwise film lifting may occur. Stoving at metal temperature of : 50°C 60 minutes 60°C 30 minutes</p>
	<p>Normally P565-897 does not require flatting and should be directly topcoated. If, however, some dirt inclusion occurs, light flatting/denibbing can be carried out when hard dry using P600 or finer flatting paper.</p> <p>If baked, P565-897 can be flatted after the above stoving times :</p> <p>Wet or Dry paper : P600 or finer Dry machine sanding : P320 or finer</p>

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SUBSTRATES AND PREPARATION

Thoroughly cleaned, and where appropriate flatted, works primers and OE finishes; old 2-pack finishes; CT etch primers; 1-pack and 2-pack undercoats; and GRP.

NOTES:

1. Do **NOT** apply P565-897 over areas of bare steel, (i.e. rub throughs etc.) when used in refurbishment work.
2. Do **NOT** apply over old or fresh synthetic alkyd topcoats.
3. This product is recommended for whole panels only and should not be used for spot or partial repairs.
4. Careful preparation of substrates will ensure a top quality finish.


For more detailed information, see "Preparation and Pre-treatment" PDS Q0100.

RECOAT:

P565-897 may be recoated with any **Nexa Autocolor** Commercial Transport 2-pack topcoat. Care must be taken to ensure that the correct recoat times are observed, particularly with metallic basecoats, in order to prevent lifting. See appropriate PDS for further details.

Normally P565-897 can be left for up to 2 days without flattening prior to recoating. However, if left for longer than 2 days P565-897 must be scuffed before overcoating.

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APPLICATION EQUIPMENT INFORMATION

HVLP

The most suitable HVLP gun for the application of Commercial Transport products is a pressure feed system.

Air cap pressure : 0.675 bar (10 psi) maximum
 Paint pressure : 0.3-1.0 bar (5-15 psi) maximum

If long fluid lines are used, the paint pressure will need to be increased.

DRYING

The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, temperatures below 20°C and excessive film thickness will extend the drying times.

SELECTION OF HARDENER AND THINNER

The exact choice of hardener and thinner combination will depend on the gun set up used, air movement, temperature application conditions, size of job and personal preference.

FLATTING

Normally, P565-897 can be left for 2 days without flattening prior to recoating. However, if left longer than 2 days P565-897 must be scuffed before topcoating.

PAINTING PLASTIC

P565-897 may be applied over prepared painted plastic. Prepare by thorough cleaning and scuffing. It may also be applied over primed plastic (see Plastic Plastics Painting System data sheet Y0100 for details). If P565-897 is applied over a flexible plastic, it must be mixed as detailed below :

	Flexible plastic	Very flexible plastic
P565-897	5 parts	2 parts
Flexible Additive for Plastics (P100-2020)	1 part	1 part

AFTER adding P100-2020, activate and thin in the normal way.

The addition of P100-2020 will extend the drying times.

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VOC INFORMATION

The EU limit value for this product (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 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


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