

# Product Data Sheet

March 2018

INTERNATIONAL MASTER  
FOR PROFESSIONAL USE ONLY



## U1130V\_TV

### HS High-Build, Primer Surfacer P565-1027 /1028 - Grey / White

<i>Product</i>	<i>Description</i>
P565-1027/8	HS High build, Primer Surfacer – Grey / White
P210-7644	EHS Hardener - Standard
P210-7642	EHS Hardener - Slow
P210-987	Plural mix hardener
P852-6442	EHS Thinner - Slow
P852-6444	EHS Thinner - Medium
P852-6446	EHS Thinner - Fast
P852-6448	EHS Thinner - Extra Fast
P100-2020	Flexible Additive for Plastics

#### Product Description

P565-1027 and P565-1028 HS High-build, Primer are high performance 2-Pack undercoats for use under Nexa Autocolor 2-Pack topcoats.

When used with TURBO VISION® 2-pack Premium High Flow EHS ancillaries, P565-1027/1028 has a ready-for-use VOC of less than 540g/l.

P565-1027 P565-1028 HS High-build, Primer have been specifically designed for application over large areas. They can be used in wet-on-wet and high-build modes and when dry have excellent flattening characteristics.

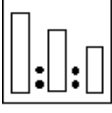
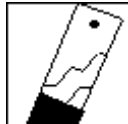



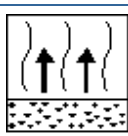





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Product Data Sheet

Standard and Fast Process													
EHS Mode (Below 540g/L VOC)													
 Standard build mode including wet-on-wet and non-sand  High Build mode	<table border="0"> <tr> <td>P565-1027/1028</td> <td>8 parts</td> </tr> <tr> <td>P210-764x</td> <td>1 part</td> </tr> <tr> <td>P852-644x</td> <td>1,5 parts</td> </tr> <tr> <td colspan="2"> </td> </tr> <tr> <td>P565-1027/1028</td> <td>8 parts</td> </tr> <tr> <td>P210-764x</td> <td>1 part</td> </tr> </table>	P565-1027/1028	8 parts	P210-764x	1 part	P852-644x	1,5 parts			P565-1027/1028	8 parts	P210-764x	1 part
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P210-764x	1 part												
P852-644x	1,5 parts												
P565-1027/1028	8 parts												
P210-764x	1 part												
	Pot life at 20°C: 1 hour  <b>Clean gun immediately after use</b>												
	<b>Standard Build</b> 23-29s. DIN4 (35-45s. BSB4)												
	<u><b>Gravity or Suction feed:</b></u> 1.6-1.8 mm Air cap pressure: 3.7-4.0 bar (55-60 psi) <u><b>Pressure feed:</b></u> 1.0-1.4 mm												
	<u><b>Gravity or Suction feed:</b></u> 1.6-1.8 mm Air cap pressure: 0.675 bar (10psi) max. <u><b>Pressure feed:</b></u> 0.85-1.4 mm HVLP/compliant												
	10-15 minutes between coats, depending on dry film thickness and drying conditions  Flash off 15-30 minutes before stoving												
	<table border="0"> <tr> <td><b>Air Dry (20°C) :</b></td> <td></td> <td><b>Low Bake (60°C metal temperature):</b></td> </tr> <tr> <td>Dust free:</td> <td>10-15 min.</td> <td>Hard dry: 30 min.</td> </tr> <tr> <td>Tack free:</td> <td>30-60 min.</td> <td></td> </tr> <tr> <td>Hard dry:</td> <td>4 hours</td> <td></td> </tr> </table> <p><b>Can be recoated wet-on-wet after a minimum of 30 min air dry</b>  <b>If recoating with Turbo Plus metallic basecoat, allow at least two hours drying time otherwise lifting of the paint film may occur.</b></p>	<b>Air Dry (20°C) :</b>		<b>Low Bake (60°C metal temperature):</b>	Dust free:	10-15 min.	Hard dry: 30 min.	Tack free:	30-60 min.		Hard dry:	4 hours	
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Dust free:	10-15 min.	Hard dry: 30 min.											
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	<b>Wet Flattening:</b> P600 or finer      Solid Colours P860 or finer      Basecoats.												
	<b>Machine sanding:</b> P240 or finer      Solid Colours. P360 or finer      Basecoats												

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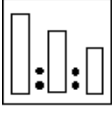




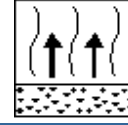





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## Express Mode (Below 540g/L VOC)

 Standard build mode	P565-1027/1028      8 parts P210-7644            1 part P852-6448            1,5 parts
	Pot life at 20°C: 15 mins.  <b>Clean gun immediately after use</b>
	<b>Standard Build</b> 23-29s. DIN4 (35-45s. BSB4)
	<b>Gravity or Suction feed:</b> 1.6-1.8 mm Air cap pressure: 3.7-4.0 bar (55-60 psi)  <b>Do not use in pressure feed system</b>
	<b>Gravity or Suction feed:</b> 1.6-1.8 mm Air cap pressure: 0.675 bar (10psi) max.  <b>Do not use in pressure feed system</b>
	5 minutes between coats, depending on dry film thickness and drying conditions  Flash off 5-10 minutes before stoving
	<b>Force Dry / Low Bake</b>  30°C -: 20 min. 40°C -: 10 min.  Flattable as soon as cooled.
	<b>Wet Flattening:</b> P600 or finer      Solid Colours P860 or finer      Basecoats.
	<b>Machine sanding:</b> P240 or finer      Solid Colours. P360 or finer      Basecoats

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## General Process Notes

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<b>NOTE:</b>	<b>Not recommended for use directly to metal. Use Etch Primer and refer to relevant PDS</b>				
<b>SUBSTRATES:</b>	<ul style="list-style-type: none"> <li>Steel</li> <li>Stainless Steel</li> <li>Aluminium</li> <li>Galvanised steel</li> <li>Zintec</li> <li>Sound Factory finishes</li> <li>Sound works primer</li> <li>Sound old finishes (2-pack)</li> <li>Sound electrocoat</li> <li>GRP</li> <li>“Glasonite”</li> </ul>				
<b>PREPARATION:</b>	<p>Abrade using P180-240 dry sanding machine discs or P180-400 wet and dry paper, then clean with P850-1378 Then pre-prime with Etch Primer P565-625 Primecoat or P565-767 CFE Primer</p> <p>Flat thoroughly using P240- P320 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378</p>				
<b>RECOAT</b>	<p>Drying times will depend on film thickness and drying conditions. In common with other primers, longer drying times before recoat will improve final appearance.</p> <p>Topcoat with TURBO VISION® 2-pack Premium High Flow EHS Topcoat or EHS Turbo Plus or CT Aquabase Also may be recoated with any other Nexa Autocolor Commercial Transport 2-pack topcoat</p> <p>When using CT Aquabase (P962-Line), it is important that P565-1027/1028 is hard dry prior to application of the Aquabase basecoat .</p>				
<b>TINTING</b>	<p>P565-1027 /1028 can be tinted. EHS Turbo Plus Tinters can be added up to a maximum of 5% to P565-1027/1028, which should then be activated and thinned according to the P565-1027/1028 process recommendations.</p> <p>For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS Q0100.</p>				
<b>PLURAL MIXING</b>	<p>P565-1027 / 1028 can be mixed with P210-987 plural mix hardener</p> <table style="margin-left: auto; margin-right: auto;"> <tr> <td>P565-1027 / 1028</td> <td>5 parts</td> </tr> <tr> <td>P210-987</td> <td>1 part</td> </tr> </table> <p>This will then perform as the EHS Hardener mode above</p>	P565-1027 / 1028	5 parts	P210-987	1 part
P565-1027 / 1028	5 parts				
P210-987	1 part				
<b>COVERAGE</b>	At a film thickness of 80 microns – 4.1 m <sup>2</sup> /litre				



**SPECTRAL GREYS**

These primers may be blended as below to give a range of Spectral Greys.

	<b>SG01</b>	<b>SG03</b>	<b>SG05</b>	<b>SG06</b>	<b>SG07</b>
<b>P565-1027 - Grey</b>	-	100g	99.5g	97.5g	88.5g
<b>P565-1028 - White</b>	100g	-	-	-	-
<b>P170-5670 - Black Paste</b>	-	-	0.5g	2.5g	11.5g

**PAINTING PLASTICS**

P565-1027/1028 can be used over the appropriate plastics primer, when painting plastic parts, to give build. When used over very flexible plastics these primers should be mixed:

- 8 parts P565-1027/1028
- 2 parts P100-2020 Flexible Additive for Plastics
- 1.5 parts P210-7644 or P210-7642 Hardener
- 2.5 parts Thinner

Note: The use of the flexible Additive will extend drying times

**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](http://www.ppg.com/Autocolor_MSDS)

**For further information please contact:**

Customer Service Sales Group  
 PPG Industries (UK) Ltd  
 Needham Road  
 Stowmarket  
 Suffolk IP14 2AD

**Tel: 01449 771771**  
**Fax: 01449 773472**

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