

# Product Data Sheet

May 2012



INTERNATIONAL MASTER  
FOR PROFESSIONAL USE ONLY

## H5870V

### Primer Filler P565-4501, P565-4505 & P565-4507

<i>Product</i>	<i>Description</i>
P565-4501	Primer Filler – White Spectral Grey 01
P565-4505	Primer Filler – Grey Spectral Grey 05
P565-4507	Primer Filler – Dark Grey Spectral Grey 07
P210-8620	Hardener – Medium
P210-8615	Hardener - Fast
P850-1490/1491/1492/1493/1494/1495	2K Thinners
P850-1692/1693/1694/1695	2K Low VOC Thinners
P852-1690	2K Accelerator Thinner

#### Product Description

P565-4501, P565-4505 and P565-4507 are 2K HS acrylic primer fillers, designed for use under **Nexa Autocolor** topcoat systems. They are easy to apply and sand and give excellent final appearance and durability.

These Primers are specifically designed to meet OEM specifications.

A range of Spectral Grey primers can be achieved using P565-4501/4505/4507, which ensure that coverage can be achieved quickly and easily while optimising topcoat usage.

## SUBSTRATES AND PREPARATION

The P565-450x primer fillers should only be applied over:

Well-sanded and degreased bare steel. Use **Nexa Autocolor** 2-pack Etch Primer, P565-9850 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 final substrate preparation: -

### When using as a Sandable Product






Wet flattening P280-P320 (GRP P400)  
Dry machine sanding P180-P220

### When using as a Wet-On-Wet product


Wet flattening P400 or finer  
Dry machine sanding P320 or finer

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

## Primer-Filler & Primer-Surfacer Process

	Primer Filler	Primer Surfacer
	<p>P565-4501/4505/4507      6 parts</p> <p>P210-8620/8615      1 part</p> <p>P850-1490/1/2/3/4/5      0 - 0.5 parts Or P850-1692/3/4</p>	<p>P565-4501/4505/4507      6 parts</p> <p>P210-8620/8615      1 part</p> <p>P850-1490/1/2/3/4/5      1 part Or P850-1692/3/4 Or P852-1690</p>
	<p>Viscosity: 40 - 85 secs DIN4 @ 20°C</p> <p>Pot-life: 30 - 40 min at 20°C</p> <p><b>Clean gun immediately after use</b></p>	<p>Viscosity: 25 - 35 secs DIN4 @ 20°C</p> <p>Pot-life: 60 min at 20°C 30 min at 20°C with P852-1690</p> <p><b>Clean gun immediately after use</b></p>
	<p><b>Fluid Tip</b></p> <p>Gravity Fed: 1.8 - 2.2 mm</p> <p>Inlet Pressure: Refer to spraygun manufacturers recommendation (normally 2 bar / 30 psi).</p>	<p><b>Fluid Tip</b></p> <p>Gravity Fed: 1.6 - 1.8 mm</p> <p>Inlet Pressure: Refer to spraygun manufacturers recommendation (normally 2 bar / 30 psi).</p>
	<p>2 - 3 coats (max 3) to give a film thickness of 100 - 200 microns</p> <p><b>NB:</b> Film build depends on thinner addition and fluid tip size.</p>	<p>2 - 3 coats to give a film thickness of 80 - 140 microns</p> <p><b>NB:</b> Film build depends on thinner addition and fluid tip size.</p>
	<p><b>Between coats:</b>      Approx. 7 - 10 minutes depending on spraying conditions</p> <p><b>Before Force Drying:</b>      Approx. 7 - 10 minutes depending on film thickness applied</p>	

## Primer-Filler & Primer-Surfacer Process

	Primer Filler	Primer Surfacer
	<p><b>Air-dry at 20°C:</b></p> <p>3 - 4 hours 100 - 125 microns 4 - 5 hours 125 - 160 microns 5 - 6 hours 160 - 200 microns</p> <p><b>Baking at a metal temperature of 60°C:</b> 30 minutes Do Not Force Dry if thickness is above 160 microns</p>	<p><b>Air-dry at 20°C:</b></p> <p>2 hours 80-140 microns thinned with P852-1690 2 - 3 hours 80-100 microns 3 - 4 hours 100-120 microns 4 - 6 hours 120-140 microns</p> <p><b>Baking at a metal temperature of 60°C:</b> 30 minutes Do Not Force Dry if thickness is above 160 microns</p>
	<p><b>Short wave:</b> 8-12 minutes</p> <p><b>Medium Wave:</b> 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 P565-450x 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><b>Finish with the following grades: -</b></p> <p>P360 or finer: Single layer solid colours (Direct Gloss) P400 or finer: Basecoats.</p>	
	<p><b>Finish with the following grades: -</b></p> <p>P600 or finer: Single layer solid colours (Direct Gloss). P800 or finer: Basecoats.</p>	
<b>TOPCOAT</b>	<p>P565-450x primer fillers can be directly topcoated with <b>Nexa Autocolor 2K</b> topcoat systems.</p> <p>If P565-450x 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>	



## Wet-On-Wet Process

	<p>P565-4501/4505/4507                      6 parts</p> <p>P210-8620/8615                              1 part</p> <p>P850-1490/1/2/3/4/5                      1.5 parts Or P850-1692/3/4/5</p>
	<b>NOTE: DO NOT add Accelerators</b>
	<p>Viscosity:                              20 - 25 secs DIN4 @ 20°C Pot-life:                                 30 - 45 min at 20°C</p> <p style="text-align: center;"><b>Clean gun immediately after use</b></p>
	<p><b>Fluid Tip</b></p> <p>Gravity Fed:                              1.3 - 1.4 mm</p> <p>Inlet Pressure:                              Refer to spraygun manufacturers recommendation (normally 2 bar / 30 psi).</p>
	1-2 coats
	<b>Between Coats:</b> Approx. 10 minutes depending on spraying conditions
	<p><b>Drying Before Topcoat:</b></p> <p>20-30 Minutes for Solventborne topcoats 30 Minutes for Waterborne topcoats</p>
<b>TOPCOAT</b>	After the drying schedule above, P565-450X Wet-On-Wet can be directly topcoated with <b>Nexa Autocolor 2K</b> topcoat systems.
<b>Note:</b> For optimum performance a dedicated Wet-On-Wet product should be used. e.g. P565-3030/3031	



## Spectral Grey

### SPECTRAL GREYS

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

	Product number	Mix % (by wt.)	Mix Parts	Mix by Target Weight		
				100g	250g	500g
SG1	P565-4501	100		100g	250g	500g
SG3	P565-4501	70	7	70g	175g	350g
	P565-4505	30	3	30g	75g	150g
SG5	P565-4505	100		100g	250g	500g
SG6	P565-4505	40	2	40g	100g	200g
	P565-4507	60	3	60g	150g	300g
SG7	P565-4507	100		100g	250g	500g

## General Process Notes

### CHOICE OF THINNER

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

<u>P850-14xx Thinner</u>	<u>Ideal temperature range:</u>
P850-1490	Below 20°C
P850-1491	15-25°C
P850-1492	20-30°C
P850-1493	25-35°C
P850-1494	30-40°C
P850-1495	Above 35°C

<u>P850-16xx Thinner</u>	<u>Ideal temperature range:</u>
P852-1690	Up to 25°C
P850-1692	20 - 30°C
P850-1693	25 - 35°C
P850-1694	30 - 40°C
P850-1695	Above 35°C

### 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.

**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](http://www.nexaautocolor.com)

### For further information please contact:

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