

# Product Data Sheet

May 2018



INTERNATIONAL MASTER. FOR PROFESSIONAL USE ONLY

## H6000V

### 2K Epoxy Primer P565-5225

Product	Description
P565-5225	2K Epoxy Primer
P275-5222	Hardener for Epoxy Primer P565-5225
P275-5223	Performance Hardener for Epoxy Primer P565-5225
P850-1613	Thinner for Epoxy Primer P565-5225

#### Product Description

P565-5225 is a multi-mode 2K Epoxy Surfacer. It is light grey in colour, chromate-free and has good corrosion resistance over bare metal.

P565-5225 has good adhesion to a wide variety of suitably prepared substrates. These include bare and galvanised steel, aluminium, painted surfaces and fillers.

P565-5225 and its two dedicated hardeners - together form a versatile package.

- Hardener P275-5222 offers three modes of use - As a sanding filler, an isolator/sealer under 2K primers & surfacers or as a wet-on-wet for small spot repairs & run-throughs.
- Performance Hardener P275-5223 gives warranty capability as a sanding filler and also can be used as an isolator/sealer under 2K primers & surfacers.

P565-5225 2K Epoxy Primer was developed for use with **Nexa Autocolor®** 2K primers **2K HS+** Topcoat (P471), and **AQUABASE® Plus** Basecoat (P989).

#### Substrates/Preparation

P565-5225 can be applied over:-

- Well sanded and degreased bare steel. (P120 Dry)
- Properly prepared Galvanised steel (P400 Dry)
- Zintec (Fine sanding Pad) and Aluminium (P280-P320 Dry)
- GRP Fibre Glass (P320)
- Polyester fillers (Finish no coarser than P180 Dry when using Filler mode),
- Works primers and old finishes in good condition. (P240-P320 Dry)
- Electrocoat (P320 Dry)

Degrease all surfaces to be painted with the appropriate *Nexa Autocolor* substrate cleaner before and after the preparation and sanding operation.

**2K Epoxy Primer P565-5225**
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**SANDING FILLER PROCESS**

	Using Hardener P275-5222			Using Performance Hardener P275-5223		
	Parts by Vol.	By Weight		Parts by Vol.	By Weight	
	P565-5225	3	100g	P565-5225	3	100g
	P275-5222	1	20.7g	P275-5223	1	20.7g
	P850-1613	0.8	15.8g	P850-1613	1	19.8g
	The pot life is 4 hours at 20°C. paint should					
	23-25 seconds DIN 4 at 20°C			27-29 seconds DIN 4 at 20°C		
	Fluid Tip 1.4-1.6 mm For best results gravity gun recommended. Adjust pressure according to spraygun manufactures recommendations					
	Apply 1 Light coat and 2 Full coats. (100-120 microns dry film thickness) (Allow the primer to flash off between spray coats)					
	5 – 10 mins between coats at 20°C			10 minutes between coats at 20°C		
	<b>Bake at metal temperature of 60°C for 30 minutes.</b> Allow panel to cool thoroughly before attempting to sand.					
	<b>Drying time 10 minutes</b> using a short or medium wave IR Unit. (Time is for guidance only) Note: Lamp to panel distance should be 1m for High Power & Short Wave lamps. Max. panel temperature should not exceed 80°C. <b>Drying is dependent on lamp power and efficiency.</b> Allow panel to cool thoroughly before attempting to sand.					
Air Dry	Air dry for 16 hours at 20°C					
	Machine Sanding : P320-P360 with 2K HS+ Solid Colours P360-P400 with Aquabase™ Plus Basecoat.					
RECOAT	After drying fully and sanding, the primer can be recoated with 2K HS+ (P471), Aquabase Plus Basecoat It can also be recoated with a Wet-on-Wet Surfacer or itself.					

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**2K Epoxy Primer P565-5225**
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**ISOLATOR PROCESS**

	<p><b>Using Hardener P275-5222 or P275-5223</b></p> <table border="1"> <thead> <tr> <th></th> <th>Parts by Vol.</th> <th>By Weight</th> </tr> </thead> <tbody> <tr> <td>P565-5225</td> <td>3</td> <td>100g</td> </tr> <tr> <td>P275-5222/5223</td> <td>1</td> <td>20.7g</td> </tr> <tr> <td>P850-1613</td> <td>1.7</td> <td>33.7g</td> </tr> </tbody> </table>		Parts by Vol.	By Weight	P565-5225	3	100g	P275-5222/5223	1	20.7g	P850-1613	1.7	33.7g
	Parts by Vol.	By Weight											
P565-5225	3	100g											
P275-5222/5223	1	20.7g											
P850-1613	1.7	33.7g											
	<p>The pot life is    8 Hours at 20°C using P275-5223                                            3 Hours at 20°C using P275-5222</p>												
	<p>16 - 20 seconds DIN 4 at 20°C</p>												
	<p>Fluid Tip 1.3-1.4mm                  For best results gravity gun recommended.                  Adjust pressure according to spraygun manufactures recommendations</p>												
	<p>Apply 1 Light coat and 1 Full coat.                  (Allow the primer to flash off between spray coats)</p>												
	<p>5 – 10 mins between spray coats at 20°C</p>												
	<p><b>Drying before application of primer or topcoat.</b></p> <p>Using Hardener P275-5222 10 – 20 minutes (Until matt)                  Using Hardener P275-5223 20 – 30 mins</p> <p><b>Note:</b> If Self levelling Primer P565-5601/5/7 is being applied on top then a minimum drying time of 30 minutes should be given.</p>												
<p>RECOAT</p>	<p>In Isolator mode, P565-5225 must be over coated within 8 hours.</p> <p>After the correct drying time, P565-5225 can be overcoated with any Nexa Autocolor 2K Primer, 2K HS+ (P471) direct gloss or <i>Aquabase</i> Plus Basecoat.</p>												

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**2K Epoxy Primer P565-5225**
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**SPOT REPAIR / WET-ON-WET PROCESS**

	<p><b>Using Hardener P275-5222 Only</b></p> <table border="1" data-bbox="277 465 853 600"> <thead> <tr> <th></th> <th>Parts by Vol.</th> <th>By Weight</th> </tr> </thead> <tbody> <tr> <td>P565-5225</td> <td>3</td> <td>100g</td> </tr> <tr> <td>P275-5222</td> <td>1</td> <td>20.7g</td> </tr> <tr> <td>P850-1613</td> <td>1</td> <td>19.8g</td> </tr> </tbody> </table> <p><i>Note: the Wet-on-Wet Spot Repair mode is not recommended with Performance Hardener P275-5223.</i></p>		Parts by Vol.	By Weight	P565-5225	3	100g	P275-5222	1	20.7g	P850-1613	1	19.8g
	Parts by Vol.	By Weight											
P565-5225	3	100g											
P275-5222	1	20.7g											
P850-1613	1	19.8g											
	<p>Pot life: 4 Hours at 20°C</p>												
	<p>21 - 23 seconds DIN 4 at 20°C</p>												
	<p>Fluid Tip 1.3-1.4mm For best results gravity gun recommended. Adjust pressure according to spraygun manufactures recommendations</p>												
	<p>Apply 1 Light coat and 1 Full coat. (Allow the primer to flash off between spray coats)</p>												
	<p>5 – 10 mins between spray coats at 20°C</p>												
	<p><b>Drying before application of primer or topcoat.</b></p> <p>Using Hardener P275-5222 30-60 min (depending on temp &amp; humidity)</p> <p><b>Note:</b> If Self levelling Primer P565-5601/5/7 is being applied on top then a minimum drying time of 30 minutes should be given.</p>												
<p>RECOAT</p>	<p>P565-5225 must be over coated within 8 hours.</p> <p>After the correct drying time, P565-5225 can be overcoated with any Nexa Autocolor 2K Primer, 2K HS+ (P471) direct gloss or Aquabase Plus Basecoat.</p>												

# Product Data Sheet



**2K Epoxy Primer P565-5225**
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**MIXING BY WEIGHT**
**SANDING FILLER MODE USING HARDENER P275-5222 : 3 : 1 : 0.8 MIXING RATIO**
**Weights are in grams & cumulative. Do not tare the scale between additions**

Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
P565-5225	185.0	370.0	555.0	740.0	925.0
P275-5222	223.3	446.7	670.0	893.3	1116.7
P850-1613	252.7	505.3	758.0	1010.7	1263.3

**SANDING FILLER MODE USING PERFORMANCE HARDENER P275-5223 : 3 : 1 : 1 MIXING RATIO**
**Weights are in grams & cumulative. Do not tare the scale between additions**

Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
P565-5225	177.6	355.2	532.8	710.4	888.0
P275-5223	214.4	428.8	643.2	857.6	1072.0
P850-1613	249.6	499.2	748.8	998.4	1248.0

**ISOLATOR MODE USING HARDENER P275-5222 or P275-5223: 3 : 1 : 1.7 MIXING RATIO**
**Weights are in grams & cumulative. Do not tare the scale between additions**

Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
P565-5225	155.8	311.6	467.4	623.2	778.9
P275-5222/5223	188.1	376.1	564.2	752.3	940.4
P850-1613	240.6	481.1	721.7	962.2	1202.8

**SPOT REPAIR / WET-ON-WET MODE USING HARDENER P275-5222 : 3 : 1 : 1 MIXING RATIO**
**Weights are in grams & cumulative. Do not tare the scale between additions**

Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
P565-5225	177.6	355.2	532.8	710.4	888.0
P275-5222	214.4	428.8	643.2	857.6	1072.0
P850-1613	249.6	499.2	748.8	998.4	1248.0



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### PERFORMANCE LIMITATIONS

2K Epoxy Primer P565-5225 should not be used at temperatures below 10°C or at humidity higher than 80%

### CLEANING OF SPRAY EQUIPMENT

Clean all equipment thoroughly immediately after use with cleaning solvent or thinner.

### **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 the 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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