

Product Data Sheet

May 2006

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H1310

High-Build Surfacer/Filler P565-761 - Normal Solids System

<i>Product</i>	<i>Description</i>
P565-761	High-Build Primer Surfacer/Primer Filler
P210-760/-770/-794	2K Hardeners
P850-1491/-1492/-1493/-1494	2K Thinners
P850-1692/-1693/-1694	2K Low VOC Thinners
P100-2020	Flexible Additive for Plastics

Product Description

P565-761 is a 2-pack acrylic, flattable primer, which has been developed for use under 2K Topcoats (P420/P421), 2K HS Plus topcoat (P471), 2K Basecoats (P422), **Aquabase™** Basecoats (P965) and **Aquabase** Plus Basecoats (P989).

P565-761 can be used as high build primer filler or as a primer surfacer to give excellent topcoat appearance.

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Substrates and Preparation

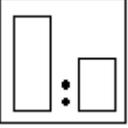
P565-761 should only be applied over:

Well-scuffed and degreased bare steel. Use Nexa Autocolor 2-pack Etch Primer for maximum durability on large areas. Aluminium should be etch primed.
Well-flatted GRP, polyester fillers, works primer and old finishes in sound condition.

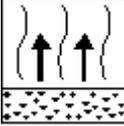
Good preparation is vital in order to obtain the best results from this product. The following grades of flating paper are recommended:

Wet or dry paper P280-P320 (GRP P400)
Dry machine sanding P220-P280

NOTE: Not recommended for spot repairs over thermoplastic acrylic and old lacquer finishes. Apply to complete panels only.

PROCESS		
USAGE	PRIMER SURFACER (80-150 microns)	PRIMER FILLER (150-200 microns)
	P565-761 4 parts P210-760/-770/-794 1 part P850-2K Thinners 1 part (see Products)	P565-761 4 parts P210-760/-770/-794 1 part
	17-21 secs DIN4 (21-27 secs BSB4) Pot-life : 2-3 hours at 20°C Clean gun immediately after use.	30-35 secs DIN4 (41-48 secs BSB4) Pot-life : 1-2 hours at 20°C Clean gun immediately after use
	Gravity fed gun is recommended Fluid tip: Gravity fed : 1.6-1.8 mm Pressure : 2.7-3.3 bar (40-50 psi)	Gravity fed gun is recommended Fluid tip : Gravity Fed : 1.8-2.2 mm Pressure : 2.7-3.3 bar (40-50 psi)
	Fluid tip : Gravity fed : 1.6-1.8 mm Pressure : 0.7 bar 10 psi (max at air cap)	Fluid tip : Gravity fed : 1.8-2.2 mm Pressure : 0.7 bar 10psi (max at air cap)

PROCESS

USAGE	PRIMER SURFACER (80-150 microns)	PRIMER FILLER (150-200 microns)
	2-3 coats to give a film thickness of 80-150 microns (3-6 thou) 3 - 4 coats to give a film thickness of 150-200 microns (6-8 thou)	3 - 4 coats to give a film thickness of 150-200 microns (6-8 thou)
	Approx. 5 minutes between coats No flash-off required before baking	Approx. 5-10 minutes between coats Approx. 20 minutes before low bake
 	Air-dry at 20°C : 4 hours Bake at a metal temperature of 60°C : 30 minutes Flash off 5 minutes Short wave :10-15 minutes	Air-dry at 20°C : 6 hours Bake at a metal temperature of 60°C: 40 minutes Not recommended
	Finish with the following grades :- P600 : Solid colours / single layer metallic colours P800 or finer : Basecoats	
	P320 or finer : Solid colours / single layer metallic colours P360 or finer : Basecoats	
<p>TOPCOAT</p>	P565-761 can be directly topcoated with 2K topcoats (P420, P421) 2K HS Plus topcoat(P471) 2K Basecoats (P422), Aquabase™ Basecoats (P965) and Aquabase Plus Basecoats (P989). Once flatted if P565-761 is left for more than 2 days it should be flatted prior to application of further undercoat or topcoat.	

GENERAL PROCESS NOTES

PAINTING PLASTICS

P565-761 may be applied over primed plastic.

If P565-761 is applied over a flexible plastic, e.g. PP/EPDM, PBT (Pocan) or PUR it must be mixed as follows :-

P565-761 5 parts

P100-2020 (Flexible additive for plastics) 1 part

Then activate and thin in the normal manner.

Addition of P100-2020 may lead to deterioration of the flattening and drying properties.

For more detailed information on the painting of plastic substrates, refer to the Painting Plastics PDS.

TINTING

P565-761 can be tinted with all **Nexa Autocolor** 2K mixing basics (excluding aluminium, pearl and special effects basics) and also P420- solid colour mixes.

The following mixing ratio is recommended and should not be exceeded :-

P565-761 95%

P420/P425/P429 5%

This mixture should then be activated and thinned in the normal way before spraying.

Addition of P420/P425/P429 may lead to deterioration of flattening properties and slower drying.

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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Product Data Sheet

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