

Product Data Sheet

February 2010

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H5620

HS+ Primer Filler P565-5301, P565-5305 & P565-5307

<i>Product</i>	<i>Description</i>
P565-5301	HS+ Primer Filler – White Spectral Grey 01
P565-5305	HS+ Primer Filler – Grey Spectral Grey 05
P565-5307	HS+ Primer Filler – Dark Grey Spectral Grey 07
P210-832/-796/-798	2K MS Hardeners – Fast/Medium-Fast/Medium
P210-8480/-8483	2K HS Special Hardeners
P850-1490/1491/1492/ 1493/1494/1495	2K Thinners
P850-1692/1693/1694	2K Low VOC Thinners
P100-2020	Flexible Additive for Plastics

Product Description

P565-5301, P565-5305 and P565-5307 (P565-530X primer fillers) are 2K HS acrylic primer fillers, designed for use under 2K topcoats (P420/P421/P471), 2K Basecoats (P422), Aquabase™ (P965), & Aquabase Plus (P989). They are easy to apply and sand and give excellent final appearance and durability.

A range of Spectral Grey primers can be achieved using P565-5301/5305/5307, which ensure that high quality colour matches can be achieved quickly and easily while optimising topcoat usage.

SUBSTRATES AND PREPARATION

The P565-530x primer fillers should only be applied over :

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





Wet or dry paper	P280-P320 (GRP P400)
Dry machine sanding	P180-P220

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

Process

	<p>P565-5301/5305/5307 5 parts P210-832/-796/-798/8483/8480 1 part P850-16XX or 14XX Thinner 1 part</p>
	<p>NOTE: DO NOT add Accelerators</p>
	<p>Activated viscosity: 20 - 25 secs DIN4 @ 20°C Pot-life: 45 - 60 min at 20°C</p> <p>Clean gun immediately after use</p>
	<p>Fluid Tip</p> <p>Gravity Fed: 1.6 - 1.8 mm Inlet Pressure: Refer to spraygun manufacturers recommendation (normally 2 bar / 30 psi).</p>
	<p>Fluid Tip</p> <p>Gravity Fed: 1.6 - 1.8 mm Pressure: Refer to spraygun manufacturer's recommendation (0.7 bar / 10 psi max at air cap).</p>
	<p>2-4 coats to give a film thickness of 75 - 200 microns</p> <p>NB: Film build depends on thinner addition and fluid tip size.</p>
	<p>Between coats: Approx. 5 - 7 minutes depending on spraying conditions</p> <p>Before Force Drying: Approx. 5 - 7 minutes depending on film thickness applied</p>

Process

	<p>Air-dry at 20°C:</p> <ul style="list-style-type: none"> 2 - 3 hours 75-100 microns 3 - 4 hours 100-150 microns 4 - 6 hours 150-200 microns <p>Baking at a metal temperature of 60°C: 20 - 30 minutes depending on film thickness</p>
	<p>Short wave: 8-12 minutes</p> <p>Medium Wave: 12 minutes</p> <p>Infrared drying times given require the short wave infrared lamp to be positioned 70-100 cm away from the panel. Allow P565-530x 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>Finish with the following grades: -</p> <p>P360 or finer: Solid colours / single layer metallic colours P400 or finer: Basecoats</p>
	<p>Finish with the following grades: -</p> <p>P600 or finer: Solid colour P800 or finer: Single layer metallic colours P800 or finer: Basecoats</p>
<p>TOPCOAT</p>	<p>P565-530x primer fillers can be directly topcoated with 2K topcoats (P420/P421/P471), 2K basecoats (P422), Aquabase™ (P965), & Aquabase Plus (P989).</p> <p>If P565-530x 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>

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Process

PAINTING PLASTICS

P565-530x primer fillers may be applied over primed plastic.
 If P565-530x primer fillers are applied over a flexible plastic, e.g. PP/EPDM, PBT (Pocan) or PUR then they must be mixed as follows: -

P565-530x 5 parts
 P100-2020 (Flexible additive for plastics) 1 part
Then activate and thin in the normal manner.

Addition of P100-2020 can cause a reduction in the drying and sanding performance.
 For more detailed information on the painting of plastic substrates, refer to the Painting Plastics PDS.

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	P565-5301	100		100g	250g	500g
SG3	P565-5301	65	1.85	65g	163g	325g
	P565-5305	35	1	35g	87g	175g
SG5	P565-5305	100		100g	250g	500g
SG6	P565-5305	48	0.95	48g	120g	240g
	P565-5307	52	1.05	52g	130g	260g
SG7	P565-5307	100		100g	250g	500g

Process

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: -

Thinner Ideal temperature range:

P850-1490 /-1692	Below 20°C
P850-1491 /-1692/-1693	15-25°C
P850-1492 /-1693	20-30°C
P850-1493 /-1693/-1694	25-35°C
P850-1494 /-1694	30-40°C
P850-1495 /-1694	Above 35°C

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

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