

Product Data Sheet

May 2006

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H1420

Fast High-Build Surfacer/Filler Medium Solids System P565-888 & P565-889

<i>Product</i>	<i>Description</i>
P565-888	Fast High-Build Surfacer/Filler, Grey
P565-889	Fast High-Build Surfacer/Filler, White
P210-832/-796/-798/-828	2K MS Hardeners
P170-5670	HS Tinter for Spectral Greys
P850-1490/-1491/-1492/-1493/-1494	2K Thinners
P850-1692/-1693/-1694	2K Low VOC Thinners

Product Description

P565-888 and P565-889 are 2-pack acrylic, flattable primers, developed for use under 2K Topcoats (P420, P421) 2K Basecoats (P422) **Aquabase™** Basecoats (P965) & **Aquabase** Plus basecoats (P989)

They are easy to apply and flat and give excellent final appearance and durability. They can be used in primer surfacer and primer filler mode.

A range of Spectral Grey primers can be achieved using P565-888/889 which ensures that high quality colour matches can be achieved quickly and easily while optimising topcoat usage.

Innovating Repair Solutions

Substrates/Preparation

P565-888/9 should only be applied over: -

Well scuffed and degreased bare steel. Use **Nexa Autocolor** 2-pack Etch Primer for maximum durability.

Aluminium must be etch primed.

An etch primer is **essential** over all substrates when using P210-832 in P565-888/889.

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 these products.

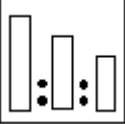





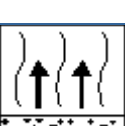

The following grades of flattening paper are recommended: -

Wet or dry paper P280-P320 (GRP P400)

Dry machine sanding P220-P280

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



MS Process

USAGE	PRIMER SURFACER (80-120 microns)	PRIMER FILLER (150-200 microns)
	P565-888/889 5 parts P210-832/-796/798/-828 1 part P850-2K Thinners 0.9 part (see Products)	P565-888/889 5 parts P210-832/-796/798/-828 1 part P850-2K Thinners 0.3 part (see Products)
	16-18 secs DIN4 (20-24 secs BSB4) Pot-life at 20°C : 2 hours Clean gun immediately after use.	30-35 secs DIN4 (41-48 secs BSB4) Pot-life at 20°C : 45 minutes Clean gun immediately after use.
	Gravity feed gun is recommended Fluid tip: Gravity fed: 1.6-1.8 mm Pressure : 2.5-3.5 bar (40-50 psi)	Gravity feed gun is recommended Fluid tip: Gravity fed: 1.8-2.0 mm Pressure : 2.5-3.5 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: 1.8-2.0 mm Pressure: 0.7 bar (10 psi) max at air cap
	Fluid tip: Gravity Fed: 1.6-1.8 mm Inlet Pressure: Refer to spraygun manufacturers recommendation (normally 2 bar / 30 psi).	Fluid tip: Gravity Fed: 1.8-2.0 mm Inlet Pressure: Refer to spraygun manufacturers recommendation (normally 2 bar / 30 psi).
	2-3 coats to give a film thickness of 80-120 microns (3-5 thou)	3-4 coats to give a film thickness of 150-200 microns (6-8 thou)
	Approx. 5 minutes between coats	Approx. 5 minutes between coats Approx. 20 minutes before low bake
	Air-dry at 20°C: 2-4 hours (depending on film thickness) Stoving at a metal temperature of 60°C: 20-30 minutes	Air-dry at 20°C: 5-6 hours (at 200 microns/ 8 thou) Stoving at a metal temperature of 60°C: 40 minutes

Product Data Sheet

Innovating Repair Solutions

MS Process (continued)

	Finish with the following grades: - P600 or finer: Solid colours / single layer metallic colours P800 or finer: Basecoats
	P320 or finer: Solid colours / single layer metallic colours P360 or finer: Basecoats
TOPCOAT	P565-888/9 can be directly topcoated with 2KTopcoats (P420, P421), 2K Basecoats (P422) Aquabase™ Basecoats (P965) & Aquabase Plus basecoat (P989) Once flatted, if P565-888/889 is left for more than 2 days it should be re-flatted prior to application of further undercoat or topcoat.

General Process Notes**PAINTING PLASTICS**

P565-888/9 may be applied over primed plastic.

If P565-888/9 is applied over a flexible plastic, e.g. PP/EPDM, PBT (Pocan) or PUR it must be mixed as follows: -

P565-889 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 plastics, refer to the Painting Plastics PDS.

SPECTRAL GREYS

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

	SG01	SG02	SG03	SG04	SG05	SG06	SG07
P565-889	100	95	80	50	0	0	0
P565-888	0	5	20	50	100	99	88.5
P170-5670	0	0	0	0	0	1	11.5
	SG01	SG02	SG03	SG04	SG05	SG06	
P565-889	100	95	80	50	0	0	
P565-888	0	5	20	50	100	93	
P425-948	0	0	0	0	0	7	

N.B. Mixing ratios are expressed as weight percentages.

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

Innovating Repair Solutions

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY.

General Process Notes

CHOICE OF HARDENER AND THINNER

The exact choice of hardener and thinner combination will depend on the gun set-up used, air movement, temperature and application conditions. However, below is a general guide:

Hardener	Temperature Range	Recommended Thinner
P210-832	< 20°C	P850-1490/-1491/-1492/-1692/-1693
P210-796	< 25°C	P850-1491/-1492/-1692/-1693
P210-798	25 - 30°C	P850-1492/-1493/-1693/-1694
P210-828	30°C +	P850-1493/-1494/-1694

DRYING

All drying times given in this process summary will depend on the film thickness applied and temperature.

Infra-red drying times given require the short wave infra-red lamp to be positioned 70-100 cm away from the panel. Allow P565-888/9 to flash off for 5 minutes before drying with the infra-red lamp. Drying times will depend on the type of infra-red lamp used.

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

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

Nexa Autocolor, **ZK**, Aquabase, Aquadry, Belco and Ecofast are trademarks of PPG Industries.
Copyright © 2006 PPG Industries, all rights reserved.
Copyright in the above product numbers that are original is asserted by PPG Industries.

Scotchbrite is a trademark of 3M UK Plc.

Innovating Repair Solutions