

Product Data Sheet

Nov 2018



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H5700V

2K Fast-Build 4:1 Primers P565-5501 P565-5505 P565-5507

<i>Product</i>	<i>Description</i>
P565-5501	FAST-BUILD 4:1 PRIMER - WHITE
P565-5505	FAST-BUILD 4:1 PRIMER - GREY
P565-5507	FAST-BUILD 4:1 PRIMER - DARK GREY
P210-842	2K HS Hardener - Fast
P210-8430	2K HS Hardener – Medium Fast
P210-844	2K HS Hardener – Medium
P850-1491/1492/1493/1494/1495	2K Thinners
P850-1692/1693/1694/1695	2K Low VOC Thinners

PRODUCT DESCRIPTION

Fast-Build 4:1 Primers are acrylic primer fillers formulated to high solids with high in-can structure. Fast-Build 4:1 primers are particularly suitable for spot repair & panel repair work in the refinish bodyshop giving excellent film build, fast drying and good sag resistance. Fast-Build 4:1 primers are compatible with a range of **NEXA AUTOCOLOR®** hardeners & thinners. After drying, Fast-Build primers sand easily and have good holdout over a wide range of substrates such as sound original paintwork, bare steel, polyester body fillers and suitable adhesion primers.

By combining P565-5501, P565-5505 & P565-5507, the Spectral Grey shades can be obtained. In this way, the topcoat consumption and the total repair process time may be optimised. (See Spectral Grey section),

Fast-Build 4:1 primers can be topcoated with **Nexa Autocolor® 2K HS+** Topcoat (P471), **AQUABASE® Plus** Basecoat (P989), 2K topcoats (P420/P421) and 2K Basecoats (P422),

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2K Fast-Build 4:1 Primers - P565-5501, 5505, 5507**H5700V****SUBSTRATES AND PREPARATION**

The P565-550X surfacers 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 - P240

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

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SANDING FILLER PROCESS

	<table border="0"> <thead> <tr> <th></th> <th>Parts by Vol.</th> <th>Parts By Weight*</th> </tr> </thead> <tbody> <tr> <td>P565-550X</td> <td>4</td> <td>100g</td> </tr> <tr> <td>P210-842/-8430/-844</td> <td>1</td> <td>15g</td> </tr> <tr> <td>P850-XXXX</td> <td>1</td> <td>13.5g</td> </tr> </tbody> </table> <p>*See weight mix chart on page 5 for accurate mixing.</p>		Parts by Vol.	Parts By Weight*	P565-550X	4	100g	P210-842/-8430/-844	1	15g	P850-XXXX	1	13.5g
	Parts by Vol.	Parts By Weight*											
P565-550X	4	100g											
P210-842/-8430/-844	1	15g											
P850-XXXX	1	13.5g											
	The pot life is 30-40 minutes at 20°C.												
	32 - 38 seconds DIN 4 at 20°C												
	Fluid Tip 1.8 -1.9 mm For best results gravity gun recommended. Adjust pressure according to spraygun manufactures recommendations												
	Apply 3 full coats with intermediate flash off between coats. (150-200 microns dry film thickness)												
	Until fully matt, normally 3 – 5 mins between coats at 20°C												
	<table border="0"> <thead> <tr> <th></th> <th><u>Bake / 60°C (Metal)</u></th> <th><u>Air Dry / 20°C</u></th> </tr> </thead> <tbody> <tr> <td>Using Hardener P210-842</td> <td>15 mins</td> <td>1.5 hours</td> </tr> <tr> <td>Using Hardener P210-8430</td> <td>20 mins</td> <td>2.5 hours</td> </tr> <tr> <td>Using Hardener P210-844</td> <td>30 mins</td> <td>3 hours</td> </tr> </tbody> </table> <p><i>Allow panel to cool thoroughly before attempting to sand.</i></p>		<u>Bake / 60°C (Metal)</u>	<u>Air Dry / 20°C</u>	Using Hardener P210-842	15 mins	1.5 hours	Using Hardener P210-8430	20 mins	2.5 hours	Using Hardener P210-844	30 mins	3 hours
	<u>Bake / 60°C (Metal)</u>	<u>Air Dry / 20°C</u>											
Using Hardener P210-842	15 mins	1.5 hours											
Using Hardener P210-8430	20 mins	2.5 hours											
Using Hardener P210-844	30 mins	3 hours											
	Flash off 5 mins before IR drying. Guide drying time - 10-15 minutes using a short or medium wave IR Unit. Note: Lamp to panel distance should be 70-100cm-for high power & short wave lamps. Drying is dependent on lamp power and efficiency. <i>Allow panel to cool thoroughly before attempting to sand.</i>												
	Finish with the following grades: - P360 or finer: Single layer solid colours (Direct Gloss) P400 or finer: Basecoats												
	Finish with the following grades: - P600 or finer: Single layer solid colours (Direct Gloss) P800 or finer: Basecoats												
RECOAT	P565-550X Fast-Build 4:1 Primers can be directly topcoated with Nexa Autocolor 2K topcoat systems or with a wet-on-wet primer.												

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PROCESS NOTES

PAINTING PLASTICS

P565-550x Fast Build Primers may be applied over primed plastic. Most automotive plastics are quite firm but if P565-550x Fast-Build primers are applied over a very flexible plastic, e.g. PP/EPDM, PBT (Pocan) or PUR then they must be mixed as follows: -

P565-550x 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

Spectral Greys are shades of primer used to optimise repair process saving material and time.
 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	P565-5501	100		100g	250g	500g
SG3	P565-5501	75	3	75g	188g	375g
	P565-5505	25	1	25g	62g	125g
SG5	P565-5505	100		100g	250g	500g
SG6	P565-5505	45	0.90	45g	112.5g	225g
	P565-5507	55	1.10	55g	137.5g	275g
SG7	P565-5507	100		100g	250g	500g

CHOICE OF HARDENER AND THINNER

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

Hardener:	Thinner:	Ideal temperature range:
P210-842/8430	P850-1X92/-1693	15 - 25°C
P210-842/8430	P850-1X93	20 - 30°C
P210-8430/844	P850-1X93/-1694	25 - 35°C
P210-844	P850-1X94/1X95	30 - 40°C
P210-844	P850-1X95	Above 35°C

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MIXING BY WEIGHT
SANDING FILLER MODE:
4 : 1 : 1 MIXING RATIO
Weights are in grams & cumulative. Do not tare the scale between additions

Target Paint Volume (L)	0.25L	0.5L	0.75L	1.0L	1.5L
P565-550X Primer	279.5g	559g	839g	1118g	1677g
P210-842/8430/844 Hardeners	321g	641.5g	962.3	1238g	1924.5g
P850-1692/3/4/5 Thinner	355g	710g	1065g	1427g	2130g

PRE-THINNED OPTION FOR P565-5505
PRE-THINNED OPTION FOR P565-5505 – MIXING MACHINE STORAGE

It is possible to store the larger 2L pack of P565-5505 Grey on the mixing machine pre-thinned. G5 is the most often used Spectral Grey shade - To save time in product preparation, thinner can be added to the primer pack & the material stirred on a mixing machine.

To use – only the hardener needs to be added at a 5:1 ratio

1. Take a new 2L tin of P565-5505 Grey Fast-Build 4:1 primer and hand stir.
2. Add 0.5L of one of the recommended 2K thinners.
(There is sufficient space in the 2L can to add thinner)
3. Hand stir to fully incorporate the thinner with the primer.
4. Attach a mixing machine stirring lid to the tin.
5. Place on the mixing machine and stir for 5 mins.
6. Stir twice daily or ideally just before use.
(Do not leave the pre-thinned product for more than 2 weeks without stirring)

To make Pre-thinned material ready to spray, Mix as follows:

	<u>Volume</u>	<u>Weight</u>
Mixing Ratio: Pre-thinned P565-5505 Fast-Build Primer	5 vol	100g
HS Hardener (See Page 1)	1 vol	13g

- The pre-thinned mode is also available through PAINTMANAGER® Software.

- It is not possible to combine the pre-thinned P565-5505 primer with P565-5501/5507 to create Spectral Grey shades.

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PERFORMANCE LIMITATIONS

2K Fast-Build 4:1 Primers perform best when the primer, hardener & thinner are at temperatures above 18°C

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.

Note:

Combinations of this product with P100-2020 will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre.

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

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