

# Product Data Sheet

Nov 2018

INTERNATIONAL MASTER. FOR PROFESSIONAL USE ONLY

## H5700

### 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
P210-832	2K MS Express Hardener
P210-796	2K MS Hardener – Normal
P210-798	2K MS Hardener – Slow
P850-1491/1492/1493/1494/1495	2K 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),

Product Data Sheet

**2K Fast-Build 4:1 Primers - P565-5501, 5505, 5507****H5700****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.

Product Data Sheet

**2K Fast-Build 4:1 Primers - P565-5501, 5505, 5507**
**H5700**
**SANDING FILLER PROCESS**

	<table border="0"> <thead> <tr> <th></th> <th style="text-align: center;">Parts by Vol.</th> <th style="text-align: center;">Parts By Weight</th> </tr> </thead> <tbody> <tr> <td>P565-550X</td> <td style="text-align: center;">4</td> <td style="text-align: center;">100g</td> </tr> <tr> <td>P210-832/-796/-798</td> <td style="text-align: center;">1</td> <td style="text-align: center;">15g</td> </tr> <tr> <td>P850-14XX</td> <td style="text-align: center;">1 *</td> <td style="text-align: center;">13.5g</td> </tr> </tbody> </table> <p>* Extra thinner up to a total of 1.5 parts can be added if preferred</p>		Parts by Vol.	Parts By Weight	P565-550X	4	100g	P210-832/-796/-798	1	15g	P850-14XX	1 *	13.5g
	Parts by Vol.	Parts By Weight											
P565-550X	4	100g											
P210-832/-796/-798	1	15g											
P850-14XX	1 *	13.5g											
	<p>The pot life is 30-40 minutes at 20°C.</p>												
	<p>32 - 38 seconds DIN 4 at 20°C</p>												
	<p>Fluid Tip 1.8 -1.9 mm For best results gravity gun recommended. Adjust pressure according to spraygun manufactures recommendations</p>												
	<p>Apply 3 full coats with intermediate flash off between coats. (150-200 microns dry film thickness)</p>												
	<p>Until fully matt, normally 3 – 5 mins between coats at 20°C</p>												
	<table border="0"> <thead> <tr> <th></th> <th style="text-align: center;"><u>Bake / 60°C (Metal)</u></th> <th style="text-align: center;"><u>Air Dry / 20°C</u></th> </tr> </thead> <tbody> <tr> <td>Using Hardener P210-832</td> <td style="text-align: center;">15 mins</td> <td style="text-align: center;">1.5 hours</td> </tr> <tr> <td>Using Hardener P210-796</td> <td style="text-align: center;">20 mins</td> <td style="text-align: center;">2.5 hours</td> </tr> <tr> <td>Using Hardener P210-798</td> <td style="text-align: center;">30 mins</td> <td style="text-align: center;">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 P210-832	15 mins	1.5 hours	Using Hardener P210-796	20 mins	2.5 hours	Using Hardener P210-798	30 mins	3 hours
	<u>Bake / 60°C (Metal)</u>	<u>Air Dry / 20°C</u>											
Using Hardener P210-832	15 mins	1.5 hours											
Using Hardener P210-796	20 mins	2.5 hours											
Using Hardener P210-798	30 mins	3 hours											
	<p>Flash off 5 mins before IR drying. <b>Guide drying time - 10-15 minutes</b> using a short or medium wave IR Unit. Note: Lamp to panel distance should be 70-100cm-for high power &amp; short wave lamps. <b>Drying is dependent on lamp power and efficiency.</b> <i>Allow panel to cool thoroughly before attempting to sand.</i></p>												
	<p>Finish with the following grades: - P360 or finer: Single layer solid colours (Direct Gloss) P400 or finer: Basecoats</p>												
	<p>Finish with the following grades: - P600 or finer: Single layer solid colours (Direct Gloss) P800 or finer: Basecoats</p>												
<p>RECOAT</p>	<p>P565-550X Fast-Build 4:1 Primers can be directly topcoated with <i>Nexa Autocolor</i> 2K topcoat systems or with a wet-on-wet primer.</p>												

Product Data Sheet

**2K Fast-Build 4:1 Primers - P565-5501, 5505, 5507**
**H5700**

## 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
<b>SG1</b>	P565-5501	100		100g	250g	500g
<b>SG3</b>	P565-5501	75	3	75g	188g	375g
	P565-5505	25	1	25g	62g	125g
<b>SG5</b>	P565-5505	100		100g	250g	500g
<b>SG6</b>	P565-5505	45	0.90	45g	112.5g	225g
	P565-5507	55	1.10	55g	137.5g	275g
<b>SG7</b>	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:
P210-832/796	P850-1492/1493	15 - 25°C
P210-832/796	P850-1493	20 - 30°C
P210-796/798	P850-1493/-1494	25 - 35°C
P210-798	P850-1494/1495	30 - 40°C
P210-798	P850-1495	Above 35°C

# Product Data Sheet

**2K Fast-Build 4:1 Primers - P565-5501, 5505, 5507**
**H5700**
**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
P210-832/796/798 Hardeners	321g	641.5g	962.3	1238g	1924.5g
P850-1492/3/4/5 Thinners	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
MS 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.

Product Data Sheet

**2K Fast-Build 4:1 Primers - P565-5501, 5505, 5507****H5700****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.

**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**

Product Data Sheet

Nexa Autocolor<sup>®</sup>, **ZK**<sup>®</sup>, and Aquabase<sup>®</sup> are registered marks of PPG Industries Ohio, Inc. Copyright © 2018 PPG Industries Ohio, Inc. All rights reserved. Copyright in the above product numbers that are original is asserted by PPG Industries Ohio, Inc.