

Product Data Sheet

August 2006 - updated June 2009

**INTERNATIONAL MASTER
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U1130

HS High-Build, Primer Surfacer P565-1027 /1028 - Grey / White

<i>Product</i>	<i>Description</i>
<i>P565-1027/8</i>	<i>HS High build, Primer Surfacer – Grey / White</i>
<i>P210-982</i>	<i>EHS Turbo Plus Hardener</i>
<i>P210-821</i>	<i>Turbo Plus Hardener – Slow</i>
<i>P210-822</i>	<i>Turbo Plus Hardener – Medium</i>
<i>P210-987</i>	<i>Hardener for EHS Turbo Plus (Plural Mix Application)</i>
<i>P852-1792</i>	<i>EHS Turbo Plus Additive Thinner – Medium</i>
<i>P852-1794</i>	<i>EHS Turbo Plus Repair Thinner</i>
<i>P852-1799</i>	<i>Rapid Repair Thinner</i>
<i>P850-1391</i>	<i>Turbo Plus Slow Thinner</i>
<i>P850-1392</i>	<i>Turbo Plus Medium Thinner</i>
<i>P850-1393</i>	<i>Turbo Plus Fast Thinner</i>

Product Description

P565-1027 and P565-1028 HS High-build, Primer are high performance 2-Pack undercoats for use under Nexa Autocolor 2-Pack topcoats. When used with EHS Turbo Plus ancillaries, P565-1027/1028 has a ready-for-use VOC of less than 540g/l.

P565-1027 P565-1028 HS High-build, Primer have been specifically designed for application over large areas. They can be used in wet-on-wet and high-build modes and when dry have excellent flattening characteristics.



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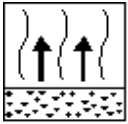



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Product Data Sheet

Standard and Fast Process

	EHS Mode (Below 540g/L VOC)	MS Mode																								
 <p>Standard build mode including wet-on-wet and non-sand</p> <p>High Build mode</p>	<table> <thead> <tr> <th></th><th>By Volume</th><th>By Weight</th></tr> </thead> <tbody> <tr> <td>P565-1027/1028</td><td>7 parts</td><td>95g</td></tr> <tr> <td>P210-982</td><td>1 part</td><td>10g</td></tr> <tr> <td>P852-1792/4</td><td>1 part</td><td>10g</td></tr> </tbody> </table>		By Volume	By Weight	P565-1027/1028	7 parts	95g	P210-982	1 part	10g	P852-1792/4	1 part	10g	<table> <thead> <tr> <th></th><th>By Volume</th><th>By Weight</th></tr> </thead> <tbody> <tr> <td>P565-1027/1028</td><td>4 parts</td><td>55g</td></tr> <tr> <td>P210-821/822</td><td>1 part</td><td>10g</td></tr> <tr> <td>P850-139X</td><td>0.5 parts</td><td>5g</td></tr> </tbody> </table>		By Volume	By Weight	P565-1027/1028	4 parts	55g	P210-821/822	1 part	10g	P850-139X	0.5 parts	5g
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	<p>Pot life at 20°C: 1 hour</p> <p>Clean gun immediately after use</p>	<p>Pot life at 20°C: 1-2 hours</p> <p>Clean gun immediately after use</p>																								
	<p>Standard Build 23-29s. DIN4 (35-45s. BSB4)</p>																									
	<p>Gravity or Suction feed: 1.6-1.8 mm Air cap pressure: 3.7-4.0 bar (55-60 psi) Pressure feed: 1.0-1.4 mm</p>																									
	<p>Gravity or Suction feed: 1.6-1.8 mm Air cap pressure: 0.675 bar (10psi) max. Pressure feed: 0.85-1.4 mm HVLP/compliant</p>																									
	<p>10-15 minutes between coats, depending on dry film thickness and drying conditions</p> <p>Flash off 15-30 minutes before stoving</p>																									
	<p>Air Dry (20°C) : Dust free: 10-15 min. Tack free: 30-60 min. Hard dry: 4 hours</p> <p>Low Bake (60°C metal temperature): Hard dry: 30 min.</p> <p>Can be recoated wet-on-wet after a minimum of 30 min air dry If recoating with Turbo Plus metallic basecoat, allow at least two hours drying time otherwise lifting of the paint film may occur.</p>																									
	<p>Wet Flatting: P600 or finer Solid Colours P860 or finer Basecoats.</p>																									
	<p>Machine sanding: P240 or finer Solid Colours. P360 or finer Basecoats</p>																									

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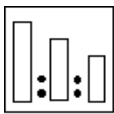




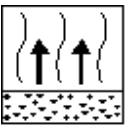



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Express Process

 <p>Standard build mode</p>	<p>P565-1027/1028 7 parts P210-982 1 parts P852-1792/4 1 part</p>
	<p>Pot life at 20°C: 15 mins.</p> <p>Clean gun immediately after use</p>
	<p>Standard Build 23-29s. DIN4 (35-45s. BSB4)</p>
	<p>Gravity or Suction feed: 1.6-1.8 mm Air cap pressure: 3.7-4.0 bar (55-60 psi)</p> <p>Do not use in pressure feed system</p>
 <p>H V L P</p>	<p>Gravity or Suction feed: 1.6-1.8 mm Air cap pressure: 0.675 bar (10psi) max.</p> <p>Do not use in pressure feed system</p>
	<p>5 minutes between coats, depending on dry film thickness and drying conditions</p> <p>Flash off 5-10 minutes before stoving</p>
	<p>Force Dry / Low Bake</p> <p>30°C -: 20 min. 40°C -: 10 min.</p> <p>Flattable as soon as cooled.</p>
	<p>Wet Flatting: P600 or finer Solid Colours P860 or finer Basecoats.</p>
	<p>Machine sanding: P240 or finer Solid Colours. P360 or finer Basecoats</p>

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General Process Notes

NOTE:

**Not recommended for use directly to metal.
Use Etch Primer and refer to relevant PDS**

SUBSTRATES:

Steel
Stainless Steel
Aluminium
Galvanised steel
Zintec
Sound Factory finishes
Sound works primer
Sound old finishes (2-pack)
Sound electrocoat
GRP
"Glasonite"

PREPARATION:

Abrade using P180-240 dry sanding machine discs or P180-400 wet and dry paper, then clean with P850-1378
Then pre-prime with Etch Primer P565-625 Primecoat or P565-767 CFE Primer

Flat thoroughly using P240- P320 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378

RECOAT

Drying times will depend on film thickness and drying conditions. In common with other primers, longer drying times before recoat will improve final appearance.

Topcoat with Turbo Plus, EHS Turbo Plus, or CT Aquabase
Also may be recoated with any other Nexa Autocolor Commercial Transport 2-pack topcoat

When using CT Aquabase (P962-Line), it is important that P565-1027/1028 is hard dry prior to application of the Aquabase basecoat .

TINTING

P565-1027 /1028 can be tinted. Turbo Plus Tinters (**P488, P489, P498 and P494-Lines**) can be added up to a maximum of 5% to P565-1027/1028, which should then be activated and thinned according to the P565-1027/1028 process recommendations.

For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS Q0100.

PLURAL MIXING

P565-1027 / 1028 can be mixed with P210-987 plural mix hardener

P565-1027 / 1028	5 parts
P210-987	1 part

This will then perform as the EHS Hardener mode above

COVERAGE

At a film thickness of 80 microns – 4.1 m²/litre

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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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