

# Product Data Sheet

November 2006



FOR PROFESSIONAL USE ONLY

# H5520V

## 2K Roller Primer P565-8605

<i>Product</i>	<i>Description</i>
P565-8605	2K Roller Primer
P170-5670	HS Tinter for Spectral Greys
P210-832, P210-796, P210-798	MS Hardeners

### Product Description

P565-8605 is a 2-pack acrylic, flattable primer, developed for use under 2K HS Plus Topcoat (P471) or Aquabase™ Basecoat (P965). It is easy to apply via foam roller and is designed for use on small repair areas.

It is easy to block and sand, giving excellent final appearance and durability. A range of dark Spectral Grey colours (SG05, 06 and 07) can be made using P565-8605 with P170-5670, ensuring that high quality colour matches can be achieved quickly and easily while optimising topcoat usage.

### Substrates and Preparation

P565-8605 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. 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 flattening P280-P400 (GRP P400)  
Dry machine sanding P220-P320

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**NOTE:** Not recommended for spot repairs over thermoplastic acrylic, old lacquer finishes or sensitive substrates. Apply to small repair areas only.

**Usage**

**Weight activation is strongly recommended for accuracy.  
Weight Mixes for Spectral Greys 05 – 07. Tinting and Activation**

**Spectral Grey 05 component weights for given RFU volumes**

RFU volume	0.1	0.2	0.4	0.6	L
P565-8605 Roller Primer	125.4	250.8	501.7	752.5	g
P210-832/ 796/ 798 MS Hardener	14.9	29.8	59.7	89.5	g

**Spectral Grey 06 component weights for given RFU volumes**

RFU volume	0.1	0.2	0.4	0.6	L
P565-8605 Roller Primer	124.2	248.3	496.7	745	g
P170-5670 HS Tinter for Spectral Greys	1.3	2.5	5	7.5	g
P210-832/ 796/ 798 MS Hardener	14.9	29.8	59.7	89.5	g

**Spectral Grey 07 component weights for given RFU volumes**

RFU volume	0.1	0.2	0.4	0.6	L
P565-8605 Roller Primer	119.1	238.3	476.6	714.9	g
P170-5670 HS Tinter for Spectral Greys	6.3	12.5	25.1	37.6	g
P210-832/ 796/ 798 MS Hardener	14.9	29.8	59.7	89.5	g

If scales are not available, then the undercoat may be activated by volume :

**Volume mixing:**

P565-8605 2K Roller Primer                      5 parts  
 P210-832 / 796 / 798 MS Hardener              1 part

**SPECTRAL GREYS**


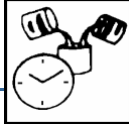
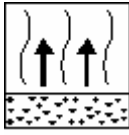



For each of the Spectral Grey primer variants specified, the following mixing ratio applies:

	SG05	SG06	SG07
P565-8605	100	99	95
P170-5670	0	1	5

**N.B. Mixing ratios are weight percentages.**

This mixture should then be activated in the normal way before application.

**PROCESS**

	<p><b>Application</b></p> <ol style="list-style-type: none"> <li>1. Use of good quality high density foam rollers is essential. Use of a suitable roller tray allows easy control of paint loading on the roller</li> <li>2. Load the roller from a suitable roller tray. Removed excess paint from the roller.</li> <li>3. The first coat covers the largest area. Subsequent coats cover smaller areas.</li> <li>4. Apply paint from the centre of the repair patch, rolling outwards using light pressure.</li> <li>5. Use the roller with less paint loading to fade hard edges of each coat.</li> <li>6. Allow the paint to flow out on the panel; avoid over- working, which can leave an uneven surface.</li> <li>7. When one coat becomes matt, it is ready for the next coat.</li> </ol>
	<p><b>Pot-life at 20°C:</b> 40 minutes Clean roller tray immediately after use.</p>
	<p>4 coats to give a film thickness of 90-120 microns (3-5 thou)</p>
	<p>Approx. 5 minutes between coats</p>
	<p><b>Air-dry at 20°C:</b> 3-4 hours (Depending on film thickness) <b>Stoving at a metal temperature of 60°C :</b> 20-30 minutes</p>
	<p><b>Infra-red drying</b> times given require the short wave infra-red lamp to be positioned 70-100 cm away from the panel. Use IR unit on half power for 5 minutes before applying full power for approximately 15 minutes. Drying times will depend on the type of infra-red lamp used. Drying time will depend on film thickness.</p>
	<p><b>Flatting</b></p> <ol style="list-style-type: none"> <li>1. Apply guide coat to the primer patch.</li> <li>2. Apply guide coat to the blocked repair.</li> <li>3. Block the primer down with P320 grade paper. Keep blocking within the primer patch to avoid scratches in the surrounding paintwork. Working the block in a circular motion will help this.</li> <li>4. DA sand with P360 or finer (for use under solid colours) or P400 or finer (for use under basecoat colours), to remove linear scratches and feather out the primer edges.</li> </ol>
	<p><b>Topcoat</b></p> <p>P565-8605 can be directly topcoated with 2K HS Plus Topcoat (P471) or Aquabase™ basecoat (P965). Once flatted, if P565-8605 is left for more than 2 days it should be re-flatted prior to application of further undercoat or topcoat.</p>

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**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.

**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](http://www.ppg.com/Autocolor_MSDS)

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