

PDS N4.1.2C

May 2015

A background image showing a person in a white protective suit and mask, using a spray gun to apply paint to a car's wheel.

P565-5005 HS EXPRESS PRIMER SURFACER

PRODUCT DESCRIPTION

P565-5005 HS Express Primer Surfacers is a highly productive primer surfacer designed for use under 2K[®] Basecoat (P422-line), 2K HS Topcoat (P420/P421-line) and AQUABASE[®] Plus waterborne basecoat. This surfacer provides exceptional film build and sandability while delivering premium adhesion, surface leveling, and gloss holdout.

- Fast dry = reduced process time
- High build = fewer coats, materials savings
- Superior sanding = labor savings
- Excellent holdout = less rework

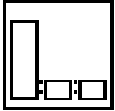
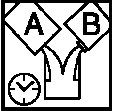


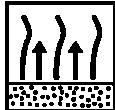


HS EXPRESS PRIMER SURFACER

PRODUCTS

<i>P565-5005</i>	<i>HS Express Primer Surfacers</i>
<i>P210-5585</i>	<i>HS Undercoat Hardener</i>
<i>P210-5595</i>	<i>HS Undercoat Hardener - High Temp 90°F (32°C) and above</i>
<i>P850-1692</i>	<i>Thinner - Low Temperature less than 65°F (18°C)</i>
<i>P850-1693</i>	<i>Thinner - Mid Temperature 65-77°F (18-25°C)</i>
<i>P850-1694</i>	<i>Thinner - High Temperature 77-95°F (25-35°C)</i>
<i>P850-1695</i>	<i>Thinner - Very High Temperature 95°F (35°C) and above</i>
<i>P100-2020</i>	<i>Flexible Additive</i>

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

MIX RATIO	Primer Surfacer	Rollable Primer Surfacer
	P565-5005 4 P210-5585/5595 1 P850-16xx 1	P565-5005 4 P210-5585/5595 1
POTLIFE 	Standard with P210-5585: 4 : 1 : 1 High Temp with P210-5595: 4 : 1 : 1 Rollable Primer Surfacer: 4 : 1	25 - 30 minutes at 70°F (21°C) 15 - 20 minutes at 90°F (32°C) 20 minutes at 70°F (21°C)
SPRAYGUN & AIR PRESSURE 	Primer Surfacer: 1.4 - 1.8 mm HVLP: Maximum of 10 psi cap pressure Compliant: 29 - 40 psi at the gun Refer to gun manufacturer's recommended air pressure.	
APPLICATION 	Apply: 2 - 3 medium wet coats Dry film build per coat: 2.0 - 2.5 mils After sanding maintain a minimum of 2.0 mils and a maximum of 6.0 mils total dry film build	
FLASH TIME 	Between coats: 3 - 5 minutes As temperatures increase over 70°F (21°C), flash times will be shortened. Back-to-back coats may be necessary with increased temperatures.	
DRY TIMES 	Air dry to Sand: 30 - 45 minutes at 70°F (21°C) Force dry to Sand: 10 - 15 minutes at 140°F (60°C) Infrared: Short Wave: 5 minutes Medium Wave: 10 minutes NOTE: Increased film build will increase dry to sand times.	
SANDING 	Wet Sanding: Single Layer Color: P400 Basecoat Color: P600 Machine Sanding: Single Layer Color: P320 or finer Basecoat Color: P360 or finer	

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PLASTICS USAGE

P565-5005	Ready to Spray HS Express Primer Surfacers	5 parts
P100-2020	Flexible Additive	1 part

SUBSTRATES

This product may be applied directly over etch primer, factory primer, GRP/ Gel Coated Fiberglass, existing finishes in good condition and polyester putties after degreasing and sanding with P180-P220 grit dry.

This product may be applied over bare steel, aluminum, and galvanized metals after priming with an appropriate NEXA AUTOCOLOR® or ONECHOICE® Etch Primer.

RECOATABILITY

Primer must be sanded before topcoating.

When dry and sanded, HS Express Primer Surfacers can be directly topcoated with *Nexa Autocolor 2K* Single Layer (P420/P421-line), Basecoat (P422-line) or a 2K wet-on-wet sealer.

After sanding, if part is left longer than 3 days, it must be re-sanded prior to further application of additional primer, sealer or topcoat.

GENERAL PROCESS NOTES

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

Infrared drying times given require the short wave infrared lamp to be positioned 28-40 inches away from the panel. Allow product to flash off for 5 minutes before drying with the infrared lamp. Drying times will depend on the type of infrared lamp used.

VOC COMPLIANCE

To ensure accurate mixing, best performance & VOC compliance:

- Do not add extra hardener, thinner or change the recommended mixing ratio.
- Do not use hardeners or thinners that are not specific in this process summary.

EQUIPMENT CLEANING

Approved Cleaning Solvent

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2K PERFORMANCE SPECIFICIATIONS:

	Rollable Primer Surfacer P565-5005 : P210-5585/5595	Primer Surfacer P565-5005 : P210-5585/5595 : P850-169x	Primer Surfacer P565-5005 : P210-5585/5595 : P850-169x + P100-2020 (Flexible)
RTS Combinations			
Volume Ratio	4 : 1	4 : 1 : 1	4 : 1 : 1 +5%
Applicable Use Category	Primer Surfacer	Primer Surfacer	Specialty Coating (Flexed Primer Surfacer)
VOC Regulatory (less water, less exempt)	3.27-3.30 lbs./US gal (392-393 g/L)	3.91-3.96 lbs./US gal. (468-475 g/L)	3.81-3.84 lbs./ US gal. (457-460 g/L)
Solids Volume	49.3	41.1	43.3
Sq. Ft. Coverage per US Gal. (1 mil @100% transfer efficiency)	790	659	695
RTS Solids by weight	66.5-66.7	59.5-59.8	59.8-60.1

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