



Technical Data Sheet

T6500V

March 2024

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

High Build Epoxy Primer – P580-65XX	
Product	Description
P580-6501	High Build Epoxy Primer - White
P580-6505	High Build Epoxy Primer - Grey
P580-6507	High Build Epoxy Primer - Dark Grey
P580-6510	High Build Epoxy Primer - Beige
P275-3068	Activator for Epoxy Primer
P850-6254	Thinner for High Build Epoxy Primer - Slow
P850-6255	Thinner for High Build Epoxy Primer - Medium


Product Description

High Build Epoxy Primer – P580-65xx is a high performance amine cured epoxy primer. It has high volume solids with excellent adhesion properties and corrosion resistance over most common commercial transport substrates. In ready-for-use mode, the VOC content of this product is lower than 500 g/l. It is ideal under the Turbo Vision topcoat range.

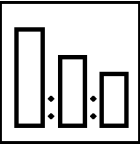


TURBO VISION®

Substrates and Preparation

Prepare the Substrate as follows:		Cleaning:
Substrates:	Sanding:	
Steel	Abraded with P80-150	<p>The substrate to be painted must be dry, clean, free of corrosion, grease & mould release agents.</p> <p>Substrates need to be thoroughly wiped using the appropriate degreaser (P850-1367 Degreaser & P850-1378 Spirit Wipe)</p>
Blast Cleaned Steel	To SA 2.5 (Rz not above 40µm)	
Aluminium	Abraded with P240 or Blast Cleaned to a maximum blast profile of 30µm	
Anodized Aluminium	Without any mechanical treatment	
Galvanised Steel	Abraded with Red ScotchBrite®	
Stainless Steel	Abraded with P80-P150	
GRP	Abraded with P320-400	
OE Finishes and Aged Paintwork	Abraded with P320-400	

Process

	Conventional or Pressure Pot or Air Assisted Airless Application												
	Standard Process	Air Assisted Airless Process											
	Activation ratio by volume	Activation ratio by volume											
	<table border="0"> <tr> <td>P580-65XX</td> <td>3 parts</td> </tr> <tr> <td>P275-3068</td> <td>1 part</td> </tr> <tr> <td>P850-6254/5</td> <td>0.5-1 parts</td> </tr> </table> <p>For 2K Plural-mix equipment it is recommended to pre-thin the primer 3 : 0.5 with Thinner. The pre-thinned paint should then be activated 3.5 : 1 with Hardener</p>	P580-65XX	3 parts	P275-3068	1 part	P850-6254/5	0.5-1 parts	<table border="0"> <tr> <td>P580-65XX</td> <td>3 parts</td> </tr> <tr> <td>P275-3068</td> <td>1 part</td> </tr> <tr> <td>P850-6254/5</td> <td>0 - 0.5 parts</td> </tr> </table> <p>For 2K Plural-mix equipment it is recommended to pre-thin the primer 3 : 0.5 with Thinner. The pre-thinned paint should then be activated 3.5 : 1 with Hardener</p>	P580-65XX	3 parts	P275-3068	1 part	P850-6254/5
P580-65XX	3 parts												
P275-3068	1 part												
P850-6254/5	0.5-1 parts												
P580-65XX	3 parts												
P275-3068	1 part												
P850-6254/5	0 - 0.5 parts												



TURBO VISION[®]

Process		
	Conventional and Pressure Feed Application	Air Assisted Airless Application
	Spray Viscosity at 20°C: 22-25 seconds DIN4	Spray Viscosity at 20°C: 25-35 seconds DIN4
	Potlife at 20°C: 5 hours Sprayable time at 20°C: 2 Hours	Potlife at 20°C: 5 hours Sprayable time at 20°C: 2 Hours
	Gravity Feed: 1.6-1.8 mm tip Suction Feed: 1.8-2.0 mm tip Both with Air Pressure : 2.0-2.5 bars	Tip Size: 11 to 13 Thou (0.28 to 0.33 mm) Paint Pressure: 70-120 bars Air Atomization: 2.0-3.5 bars
	Pressure Feed: 1.1-1.2 mm tip Paint Pressure : 0.3-1.0 bars Fluid flow rate: 280-320 cc/min Air Pressure : 2.0-2.5 bars	
	Number of Coats Apply 2 full coats This gives 90-110 microns Dry Film Thickness minimum. Or: apply 1 light coat followed immediately by 1 full coat to give 50-70 µm Dry Film Thickness (on aluminium substrate only). Please note that a minimum of 50 microns DFT is required on aluminium	
	10-15 minutes minimum between coats If Baking is required, flash off 10-15 minutes minimum before baking 45-60 minutes at 60°C metal temperature	
	P580-65xx can be sanded if required, either after overnight air dry or after baking. Sand with P320-400 discs	
	Air Dry (20°C) : Dust free: 30 min. Tack free: 2-4 hours. Hard dry: 16-24 hours	Low Bake (60°C metal temperature): Hard dry: 45 - 60 min.



TURBO VISION®



Can be recoated wet-on-wet with topcoats after 45 minutes at 20°C, or up to 7 days with no sanding required.

P580-65xx can be directly topcoated with Turbo Vision® Topcoats (P650-Line), Turbo Plus UHS Topcoats (P498-Line), Nexa Autocolour Aquabase Basecoat, and Nexa Autocolour 2K Basecoat (P422-Line)

If recoating wet-on-wet with P422-Line solventborne basecoat it is advised to not activate the basecoat with hardener.

If recoating with activated P422-Line solventborne basecoat, it is recommended that the primer is either baked 1 hour at 60C, or air dried overnight before recoating.

General Process Notes

CHOICE OF HARDENER AND THINNER

The exact choice of hardener and thinner combination will depend on the gun set-up used, air movement, size of repair, temperature and application conditions. However, below is a general guide :

Hardener	Temperature Range	Recommended Thinner
P275-3068	Below 25°C	P850-6255
P275-3068	Above 25°C or large areas	P850-6254

Mixing to give Different Grey Shades

% by weight	SG1	SG3	SG5	SG6	SG7
P580-6501	100	75	--	--	--
P580-6505	--	25	100	48	--
P580-6507	--	--	--	52	100



TURBO VISION[®]

Ready for use Data

Activation ratio by volume	3:1	3:1:0.5	3:1:1
P580-65xx	3	3	3
P275-3068 Hardener	1	1	1
P850-625X Thinner	-	0.5	1
Volume solids %	56%	50%	45%
Solids by weight %	72.2%	67.0%	62.6%
Density	1.42	1.35	1.31
VOC	393	446	489
Theoretical coverage m ² /L at 50 microns DFT	11.5	10.0	9.0

Health and Safety

The EU limit value for these products (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 these products 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

For further information please contact:

Customer Service Sales Group
PPG Industries (UK) Ltd
Needham Road
Stowmarket
Suffolk IP14 2AD

Tel: 01449 771771

