

**PDS N4.11C**

November 2008

## **P565-5201 & P565-5205**

# ***HS PLUS PRIMER-SURFACERS***

### **PRODUCT DESCRIPTION**

**P565-5201** and **P565-5205** are 2-pack acrylic sandable primers, designed for use under 2K™ Basecoat (P422) and 2K™ HS Plus Topcoat (P471). They are easy to apply and sand, and give excellent final appearance and durability.

HS Plus Primer-Surfacers are a component of the Spectral Grey Undercoat System. P565-5201/5205 and HS Plus Spectral Grey SG06 are used to achieve the full range of Spectral Grey colors. Using Spectral Grey Undercoats can reduce the amount of colorcoats required.

- High build = fewer coats, materials savings
- Excellent holdout = less rework
- Fast dry = reduced process time
- Spectral Greys System = reduced color coats
- Superior sanding = labor savings
- Meets VOC regulations

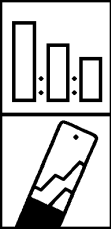
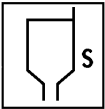


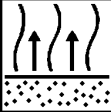


## ***HS PLUS PRIMER-SURFACERS***

### **PRODUCTS**

<b><i>P565-5201</i></b>	<b><i>HS Plus Primer Surfacer - White</i></b>
<b><i>P565-5205</i></b>	<b><i>HS Plus Primer Surfacer - Grey</i></b>
<b><i>P210-5375</i></b>	<b><i>HS Plus Undercoat Hardener – Mid-Temp</i></b>
<b><i>P850-1775</i></b>	<b><i>HS Plus Mid-Temp Reducer</i></b>
<b><i>P170-5267</i></b>	<b><i>HS Plus Tinter for Spectral Grey 6</i></b>

**THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY**

# PROCESS

<b>MIX RATIO</b> 	P565-5201/5205 5 P210-5375 1 P850-1775 1
<b>VISCOSITY &amp; POTLIFE</b> 	Activated viscosity: 23-27 seconds Din#4  Pot Life: 1 hour at 70°F Clean gun immediately after use.
<b>SPRAYGUN &amp; AIR PRESSURE</b> 	1.6 -1.9mm Max. 10 psi cap press  Refer to gun manufacturers recommended air pressure.
<b>APPLICATION</b> 	Apply 3 full coats to give a film thickness of 4-6 mils.  <b>NOTE:</b> Film builds depends on tip size selected. For best results follow recommendation above.
<b>FLASH TIME</b> 	5-10 minutes between coats at 70°F (21°C).
<b>DRY TIMES</b> 	<b>Minimum Air-dry times at 70°F (21 C)</b> 2 hours at 3-4 mils 3 hours at 6 mils  <b>Force Dry:</b> 20 minutes at 140°F (60°C) metal temperature <b>Infra-Red:</b> 8-12 minutes
<b>SANDING</b> 	<b>Wet Sanding:</b> P600 or finer for Single Layer colors P800 or finer for Basecoats  <b>Machine Sanding:</b> P320 or finer for Single Layer colors P360 or finer for Basecoats

# HS PLUS PRIMER-SURFACERS

## TINTING – SPECTRAL GREYS

MIX RATIO BY VOLUME			MIX RATIO BY WEIGHT Cumulative Weight In Grams			
	MIX RATIO		Quart	Pint	1/2 Pint	1/4 Pint
SG01 Surfacer	P565-5201	5	1121	561	280	140
	P210-5375	1	1284	641	321	161
	P850-1775	1	1455	728	364	182
SG02 Surfacer	P565-5201 (95)	5	1065	533	266	133
	P565-5205 (5)		1121	560	280	140
	P210-5375	1	1284	641	321	161
	P850-1775	1	1455	728	364	182
SG03 Surfacer	P565-5201 (80)	5	899	450	225	112
	P565-5205 (20)		1121	560	280	140
	P210-5375	1	1284	641	321	161
	P850-1775	1	1455	728	364	182
SG04 Surfacer	P565-5201 (50)	5	555	228	139	69
	P565-5205 (50)		1115	557	279	139
	P210-5375	1	1278	639	319	160
	P850-1775	1	1449	725	362	181
SG05 Surfacer	P565-5205	5	1109	555	277	139
	P210-5375	1	1272	636	318	159
	P850-1775	1	1443	722	361	180
SG06 Surfacer	P565-5205 (96)	5	1064	532	226	133
	P170-5267 (4)		1095	548	274	137
	P210-5375	1	1258	629	315	157
	P850-1775	1	1429	715	357	179

**NOTE:** These weights will produce approximately 97.5% of the volume stated to allow for mixing in the can. If an exact quart, pint and half-pint etc. is required multiply all weights by 1.025. All weights have been rounded off to whole numbers.

	Flexible	Very Flexible
P565-520X HS Plus Primer-Surfacers	5	2
P100-2021 Flexible Additive for Plastics	1	1
NOTE: This mixture should then be activated and thinned as normal. More detail on refinishing plastics can be found in PDS N7.1C.		

# ***HS PLUS PRIMER-SURFACERS***

## **SUBSTRATES**

P565-5201 and P565-5205 can be applied directly over bare steel, factory primer, GRP / Fiberglass, existing finishes in good condition after degreasing and sanding with P180-P220 grit dry.

P565-5201 and P565-5205 can be applied over aluminum and galvanized metals after etch priming with an Etch Primer.

**Note:** For maximum durability over bare steel, a Nexa Autocolor Etch Primer should first be applied.

Over thermoplastic acrylic and old lacquer finishes, P565-5201 and P565-5205 must be applied to the complete panel.

---

## **RECOATABILITY**

P565-5201 and P565-5205 can directly topcoated with 2K™ HS Plus topcoat (P471) and 2K™ Basecoat (P422).

After sanding, if P565-5201 or P565-5205 is left for longer than 3 days, it must be re-sanded prior to further application of primer, sealer or topcoat.

---

## **GENERAL PROCESS NOTES**

It is recommended that P565-5201 and P565-5205 are **not** stored on a mixing machine. Hand stir before each use.

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

Infra-red drying times given require the short wave infra-red lamp to be positioned 28-40 inches away from the panel. Allow P565-5201/5205 to flash off for 5 minutes before drying with the infra-red lamp. Drying times will depend on the type of infra-red lamp used.

# HS PLUS PRIMER-SURFACERS

## VOC COMPLIANCE:

### To ensure accurate mixing, best performance & VOC compliance:

- When mixed as directed these products will achieve <2.1lbs, 250g/l VOC.
- Use the correct mixing ratio for the regulated areas.
- Use an appropriate mixing stick.
- Do not add extra hardener, thinner or change the recommended mixing ratio.
- Do not use Hardeners & Thinner not specified in this process summary.
- Do not tint with Topcoat colors.
- Achieve SG06 with only the correct Tinter at the ratio specified in this process summary.

## EQUIPMENT CLEANING

Approved Cleaning Solvent

## 2K PERFORMANCE SPECIFICATIONS

	Standard system: P565-520X : P210-5375 : P850-1775	Flexible system: (Premix P565-520X : P100-2021 at 5 : 1 ratio) P565-520X/P100-2021 : P210-5375 : P850-1775	Very Flexible system: (Premix P565-520X : P100-2021 at 2 : 1 ratio) P565-520X/P100-2021 : P210-5375 : P850-1775
<b>RTS Combinations:</b>			
<b>Volume Ratio:</b>	5 : 1 : 1	5 : 1 : 1	5 : 1 : 1
<b>Applicable Use Category</b>	Primer	Primer	Primer
<b>VOC Actual (g/L)</b>	119 - 133	119 - 131	120 - 129
<b>VOC Actual (lbs/gal)</b>	0.99 - 1.12	0.99 - 1.09	1.00 - 1.08
<b>VOC Regulatory (less water less exempt) (g/L)</b>	219 - 242	217 - 237	214 - 230
<b>VOC Regulatory (less water less exempt) (lbs/gal)</b>	1.83 - 2.02	1.81 - 1.98	1.79 - 1.92
<b>Density (g/L)</b>	1552 - 1578	1493 - 1516	1434 - 1454
<b>Density (lbs/gal)</b>	12.95 - 13.17	12.46 - 12.65	11.97 - 12.13
<b>Volatiles wt. %</b>	46.4 - 47.7	47.8 - 48.9	49.3 - 50.2
<b>Water wt. %</b>	0.0	0.0	0.0
<b>Exempt wt. %</b>	38.7 - 39.1	39.8 - 40.1	41.0 - 41.2
<b>Water vol. %</b>	0.0	0.0	0.0
<b>Exempt vol. %</b>	45.2 - 45.7	44.6 - 45.1	44.1 - 44.4

For further information please contact:

**Nexa Autocolor-USA**  
19699 Progress Drive  
Strongsville, OH 44149

**Nexa Autocolor-Canada**  
2301 Royal Windsor Drive  
Mississauga, Ontario L5J 1K5