



## PDS N4.1.2C

June 2009

### ***P565-5401 White, 5405 Grey & 5407 Black***

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

### **PRODUCT DESCRIPTION**

HS Plus Primer-Surfacers are 2-pack acrylic urethane sandable primers designed for use under Aquabase Plus™ waterborne basecoat. 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. HS Plus Primer-Surfacers are available in white, grey and black and are used to achieve the full range of Spectral Grey colors. Using Spectral Grey Undercoats can reduce the amount of required colored topcoat.

- 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

Designed for Use With

***Aquabase***  
PLUS

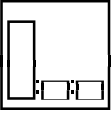
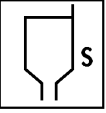





## **HS PLUS PRIMER-SURFACER**

### **PRODUCTS**

<b><i>P565-5401</i></b>	<b><i>HS Plus Primer-Surfacer - White</i></b>
<b><i>P565-5405</i></b>	<b><i>HS Plus Primer-Surfacer - Grey</i></b>
<b><i>P565-5407</i></b>	<b><i>HS Plus Primer-Surfacer - Black</i></b>
<b><i>P210-5475</i></b>	<b><i>HS Plus Surfacer / Sealer Hardener</i></b>
<b><i>P850-1775</i></b>	<b><i>HS Plus Mid Temperature Reducer</i></b>

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

# PROCESS

MIX RATIO	Primer-Surfacer	Spray Filler
	P565-540X      4 P210-5475      1 P850-1775      1	P565-540X      4 P210-5475      1
<b>POTLIFE</b> 	Primer-Surfacer    4 : 1 : 1      1 hour at 70°F (21 °C) Spray Filler        4 : 1            30 minutes at 70°F (21 °C)	
<b>SPRAYGUN &amp; AIR PRESSURE</b> 	Primer Surfacer    1.6 -1.8 mm Spray Filler        1.7 - 2.0 mm  Max. 10 psi cap press  Refer to gun manufacturers recommended air pressure.	
<b>APPLICATION</b> 	Apply 3 full coats to give a dry film thickness of 4-6 mils.	
<b>FLASH TIME</b> 	5-10 minutes between coats at 70°F (21 °C)	
<b>DRY TIMES</b> 	<b>Air-dry at 70°F (21 °C)</b>  Primer Surfacer:    1.5 hours at 2-3 mils Spray Filler*:        6 hours or overnight at 4-6 mils  <b>Force Dry*:</b> 30 minutes at 140°F (60°C) metal temperature <b>Infra-Red* :</b> 8-12 minutes  * Do not force dry when used as a spray filler	
<b>SANDING</b> 	<b>Wet Sanding:</b> P600 / P800  <b>Machine Sanding:</b> P360 / P400	

# HS PLUS PRIMER-SURFACER

## SPECTRAL GREYS

MIX RATIO BY VOLUME		MIX RATIO BY WEIGHT Cumulative Weight In Grams			
	Components	1/4 Pint	1/2 Pint	Pint	Quart
SG01 Primer-Surfacer	P565-5401	126	252	508	1025
	P210-5475	151	301	607	1224
	P850-1775	177	354	713	1437
SG02 Primer-Surfacer	P565-5401	120	240	484	977
	P565-5405	126	252	509	1026
	P210-5475	150	301	599	1224
	P850-1775	177	354	705	1438
SG03 Primer-Surfacer	P565-5401	94	189	381	769
	P565-5405	126	252	509	1026
	P210-5475	150	301	607	1225
	P850-1775	177	354	713	1439
SG04 Primer-Surfacer	P565-5401	42	84	169	342
	P565-5405	126	253	510	1029
	P210-5475	151	302	608	1228
	P850-1775	177	355	714	1441
SG05 Primer-Surfacer	P565-5405	127	253	511	1030
	P210-5475	151	302	609	1229
	P850-1775	177	355	715	1442
SG06 Primer-Surfacer	P565-5405	81	162	327	658
	P565-5407	123	247	498	1001
	P210-5475	148	296	597	1199
	P850-1775	174	348	703	1413
SG07 Primer-Surfacer	P565-5407	122	243	491	990
	P210-5475	146	292	590	1189
	P850-1775	173	345	696	1402

## PLASTICS USAGE

		Flexible	Very Flexible
P565-540X	HS Plus Primer-Surfacer	5	2
P100-2021	LV Flexible Additive	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-SURFACER

## SUBSTRATES

P565-5401, P565-5405 and P565-5407 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.

P565-5401, P565-5405 and P565-5407 can be applied over aluminum and galvanized metals after etch priming with P565-9880 Etch Primer.

**Note:** For maximum durability over bare steel, an etch primer should first be applied.

Over thermoplastic acrylic and old lacquer finishes, P565-540X must be applied to the complete panel.

---

## RECOATABILITY

P565-5401, P565-5405 and P565-5407 must be sanded before top coating with Aquabase Plus Basecoat.

After sanding, if P565-540X is left for 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.

Infra-red drying times given require the short wave infra-red lamp to be positioned 28-40 inches away from the panel. Allow P565-540X 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. Do not infrared dry when used in the spray filler mode of 4 : 1.

# HS PLUS PRIMER-SURFACER

## 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.
- Do not add extra hardener, thinner or change the recommended mixing ratio.
- Do not use hardeners or thinners that are not specified in this process summary.
- Do not tint except where as referenced in the Spectral Grey chart

## EQUIPMENT CLEANING

Approved Cleaning Solvent

## 2K PERFORMANCE SPECIFICATIONS

RTS Combinations:	Spray-Filler	Primer- Surfacer	Flexible System	Very Flexible System
	P565-540X : P210-5475	P565-540X : P210- 5475 : P850-1775	(Premix P565-540X : P100-2021 at 5 : 1 ratio:) P565-540X : P210-5475 : P850-1775	(Premix P565-540X : P100-2021 at 2 : 1 ratio:) P565-540X : P210-5475 : P850-1775
Volume Ratio:	4 : 1	4 : 1 : 1	4 : 1 : 1	4 : 1 : 1
Applicable Use Category	Primer	Primer	Primer	Primer
VOC Actual (g/L)	137 - 142	114 - 118	113 - 117	113 - 115
VOC Actual (lbs/gal)	1.15 - 1.19	0.96 - 0.99	0.95 - 0.98	0.95 - 0.97
VOC Regulatory (less water less exempt) (g/L)	238 - 249	238 - 249	230 - 240	224 - 230
VOC Regulatory (less water less exempt) (lbs/gal)	1.99 - 2.08	1.99 - 2.08	1.92 - 2.00	1.87 - 1.92
Density (g/L)	1505 - 1556	1479 - 1521	1434 - 1469	1390 - 1418
Density (lbs/gal)	12.56 - 12.98	12.34 - 12.69	11.97 - 12.26	11.60 - 11.83
Volatiles wt. %	45.9 - 48.1	53.9 - 55.9	54.5 - 56.3	55.1 - 56.6
Water wt. %	0.0	0.0	0.0	0.0
Exempt wt. %	37.1 - 38.7	46.4 - 47.9	46.8 - 48.1	47.2 - 48.3
Water vol. %	0.0	0.0	0.0	0.0
Exempt vol. %	43.0 - 43.3	52.5 - 52.8	51.2 - 51.4	49.9 - 50.08

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