



PDS N3.2

January 2005

P565-713

CHROMATE FREE ETCH PRIMER

PRODUCT DESCRIPTION

Chromate Free Etch Primer provides excellent adhesion to all metal surfaces with excellent anti-corrosion properties.

Chromate Free Etch Primer is an approved etch primer for warranty repair systems.

• Excellent Adhesion = less rework

• Universal = suitable for all metal surfaces

CHROMATE FREE ETCH PRIMER

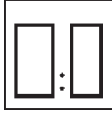

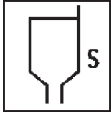


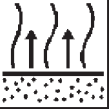

PRODUCTS

P565-713 ***Chromate Free Etch Primer***

P275-210 ***Normal Activator For Chromate Free Etch Primer***

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

CHROMATE FREE ETCH PRIMER

<p>MIXING RATIO</p>  	<p>P565-713 1 part P275-210 1 part</p>
<p>VISCOSITY & POT LIFE</p> 	<p>Viscosity: 18-21 seconds DIN 4 @ 70°F (21°C). Pot Life: 24 hours @ 70°F (21°C). Note: Freshly mixed material will provide best corrosion resistance.</p>
<p>SPRAY GUN AND AIR PRESSURE</p> 	<p>Siphon: 1.6-1.8mm (.063" - .070") 50-55 psi at the gun Gravity: 1.3-1.6mm (.050" - .063") 50-55 psi at the gun HLVP: 0.8-1.7mm (.031" - .067") Max 10 psi cap pressure 3-8 psi fluid pressure (pressurized cup only) (HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)</p>
<p>APPLICATION</p> 	<p>2 single coats (approx. 1.0 mil)</p>
<p>FLASH-OFF</p> 	<p>5 minutes between coats.</p>
<p>DRYING TIME</p> 	<p>15 minutes minimum @ 70°F (21°C). Allow a longer dry time if temperature is lower than 70°F (21°C). Note: Apply an Nexa Autocolor Primer-Surfacer or sealer as soon as Chromate Free Etch Primer is dry.</p>

CHROMATE FREE ETCH PRIMER

SUBSTRATES

Chromate Free Etch Primer can be applied over bare steel, aluminum, galvanized metals and GRP / Fiberglass after degreasing and machine sanding with P180-P220 dry.

RECOATABILITY

Chromate Free Etch Primer must be recoated with either an Nexa Autocolor Primer-Surfacer or Sealer before applying a 2K™ topcoat. If Chromate Free Etch has been left uncoated longer than 24 hours, scuff sand and apply an additional coat.

GENERAL PROCESS NOTES

DO NOT apply 2K™ topcoats directly over Chromate Free Etch Primer. Polyester fillers can be applied over Chromate Free Etch after a Minimum of 1 Hour air dry @ 70°F (21°C).

EQUIPMENT CLEANING

Approved cleaning solvent

2K™ PERFORMANCE SPECIFICATIONS

Product:	P565-713
Category:	Pretreatment
VOC As Packaged:	5.47 lbs. per gal/655 gm/l
VOC RFU:	6.1 lbs. per gal/ 732 gm/l
RFU Weight Solids:	22.7% @ 1:1
RFU Volume Solids:	14.5% @ 1:1

For further information please contact:

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