



## **PDS N4.0.0**

**January 2005**

# ***ROLLABLE PRIMER PROCESS***

## **PRODUCT DESCRIPTION**

Roll priming is an alternative method of applying Nexa Autocolor HS Primer-Surfacers. When used on small individual or multiple repairs, maximum transfer efficiency is achieved as well as labor and material savings translating into higher shop proficiency.

HS Primer-Surfacers are components of the Spectral Grey Undercoat System. P565-510/511 along with P170-5670 are used to achieve the full range of Spectral Grey colors. Using Spectral Grey Undercoats can reduce the amount of topcoat required. Rollable HS Primer-Surfacers are approved products for warranty repair systems.

- **High Build = fewer coats**
- **Fast Dry = reduced process times**
- **Excellent Holdout = less rework**
- **Spectral Grey System = reduced color coats**
- **100% Transfer efficient = Cost savings**

## **ROLLABLE PRIMER PROCESS**

### **PRODUCTS**

***P565-510***

***HS Primer- Surfacer – Grey***

***P565-511***

***HS Primer- Surfacer – White***

***P210-796***

***MS Hardener – Normal***

***P210-798***

***MS Hardener – Slow***

***P850-16XX***

***2K Thinners***

***8812-1066***

***Light Build Roller***

***8812-1067***

***Medium Build Roller***

***8812-1068***

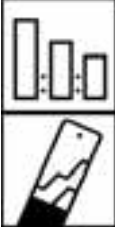


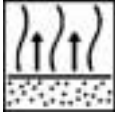


***Roller Handle***

***8812-1069***

***Roller Pan***

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

# ROLLABLE PRIMER PROCESS

<p><b>MIX RATIO</b></p> 	<p>P565-510/511                      5  P210-796/798                        1  P850-16XX                            0.5</p> <p>Note: Only P210-796/798 hardeners may be used.</p>
<p><b>VISCOSITY &amp; POTLIFE</b></p> 	<p><b>Viscosity:</b> 25 seconds Din #4 @ 70°F (21°C) @ 5:1:0.5  45 seconds Din #4 @ 70°F (21°C) @ 5:1</p> <p><b>Pot Life:</b> 30-45 minutes @ 70°F (21°C)</p>
<p><b>APPLICATION</b></p> 	<p><b>2-3 coats</b> (approx. 2 - 4 mils)</p> <p>See "General Process Notes" on page 5 for application information</p>
<p><b>FLASH TIME</b></p> 	<p><b>5-10 minutes</b> between coats</p> <p>Allow 5-minute flash-off before force dry or Infra Red.</p>
<p><b>DRY TIMES</b></p> 	<p><b>Air-dry times at 70°F (21°C)</b>  2-4 hours minimum @ 2-4 mils</p> <p><b>Force Dry (metal temperature):</b>  30 minutes at 140°F (60°C)</p> <p><b>Infra-Red (short wave):</b>  8-12 minutes after 5 minute flash</p>
<p><b>SANDING</b></p> 	<p><b>Wet Sanding:</b>  P400 for Single Layer Color  P600 for Basecoat color</p> <p><b>Machine Sanding:</b>  P320 or finer for Single Layer colors  P400 or finer for Basecoats</p>

# ROLLABLE PRIMER PROCESS

## SPECTRAL GREYS

MIX RATIO BY VOLUME			MIX RATIO BY WEIGHT Cumulative Weight in Grams			
	Mix Ratio		Quart	Pint	½ Pint	¼ Pint
<b>SG01 Surfacer</b>	P565-511	5	1017	509	255	128
	P210-796/8	1	1147	574	287	144
	P850-16XX	0.5	1201	601	301	151
<b>SG02 Surfacer</b>	P565-511 (95)	5	966	483	242	121
	P565-510 ( 5)		1017	509	255	128
	P210-796/8	1	1147	574	287	144
	P850-16XX	0.5	1201	601	301	151
<b>SG03 Surfacer</b>	P565-511 (80)	5	814	407	202	102
	P565-510 (20)		1017	509	255	128
	P210-796/8	1	1147	574	288	144
	P850-16XX	0.5	1201	601	301	151
<b>SG04 Surfacer</b>	P565-511 (50)	5	508	254	127	64
	P565-510 (50)		1017	509	255	128
	P210-796/8	1	1147	574	287	144
	P850-16XX	0.5	1201	601	301	151
<b>SG05 Surfacer</b>	P565-510	5	1017	509	255	128
	P210-796/8	1	1147	574	287	144
	P850-16XX	0.5	1201	601	301	151
<b>SG06 Surfacer</b>	P565-510 (99)	5	1004	502	251	126
	P170-5670 ( 1)		1014	507	254	127
	P210-796/8	1	1143	572	286	143
	P850-16XX	0.5	1197	599	300	150
<b>SG07 Surfacer</b>	P565-510 (98)	5	912	456	228	114
	P170-5670 ( 2)		992	496	248	124
	P210-796/8	1	1122	561	281	141
	P850-16XX	0.5	1176	588	294	147

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

## PLASTICS USAGE

	Flexible	Very Flexible
P565-510/511 HS Primer-Surfacers	5	2
P100-2020 Flexible Additive for Plastics	1	1

**Note:** This mixture should then be activated and thinned at a ratio of 5:1  
The use of flexible additive will extend dry times.

# ROLLABLE PRIMER PROCESS

## SUBSTRATES

HS Primer-Surfacers can be applied over factory primer, GRP/Fiberglass, existing finishes in good condition, polyester putties and bare steel \*, after degreasing and machine sanding starting with P80 followed by P220 grit dry.

HS Primer-Surfacers can also be applied over aluminum and galvanized metals after priming with either Long Life Etch Primer, Chromate Free Etch Primer, or 1K Etch Primer.

\*For optimum performance over bare steel, a Nexa Autocolor Etch Primer should first be applied.

Over thermoplastic acrylic and old lacquer finishes, HS Primer Surfacer should be applied to the complete panel.

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## RECOATABILITY

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

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## GENERAL PROCESS NOTES

After the primer has been properly mixed, pour into the tray and roll the roller into the primer being sure to completely saturate the cover. Allow the primer to fully absorb into the cover and then roll off any excessive material before starting the application.

Using light pressure, apply the first coat from the center, rolling outwards to the feather edge of the repair being sure to stay within the sanded area and covering all scratches, use a “lifting and flicking ” motion to create a feather edge in the primer.

After the first coat has flashed off, again starting at the center of the repair and roll outwards within 1 or 2 inches from the edge of the previous coat again using the “lifting and flicking” method. Repeat this application if a third coat is required. After primer has dried, guide coat and block sand with P240 followed by P400-P600 wet by hand or P320-P400 machine dry.

If higher builds are required, the 0.5 part thinner may be left out of the mix. The reduction of thinner will reduce the flow and leveling and also reduce the pot life.

# ROLLABLE PRIMER PROCESS

## EQUIPMENT CLEANING

Approved Cleaning Solvent

Roller trays may be cleaned and reused. Discard rollers in compliance with local rules and regulations.

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## 2K PERFORMANCE SPECIFICATIONS

<b>Product:</b>	P565-510/511 HS Primer-Surfacer	
<b>Category:</b>	Primer-Surfacer	
<b>VOC As Packaged:</b>	P565-510	3.72 lbs. per gal / 450 gm/l
<b>VOC As Packaged:</b>	P565-511	3.84 lbs. per gal / 464 gm/l
<b>VOC RFU:</b>	P565-510/511	3.86 lbs. per gal / 499 gm/l avg. @ 5:1
<b>VOC RFU:</b>	P565-510/511	4.35 lbs. per gal / 522 gm/l avg. @ 5:1:0.5
<b>RFU Weight Solids</b>	P565-510	67.1% @ 5:1 / 60.5% @ 5:1:0.5
<b>RFU Weight Solids:</b>	P565-511	65.6% @ 5:1 / 55.6% @ 5:1:0.5
<b>RFU Volume Solids:</b>	P565-510	47.8% @ 5:1 / 45.4% @ 5:1:0.5
<b>RFU Volume Solids:</b>	P565-511	46.4% @ 5:1 / 41.9% @ 5:1:0.5

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