

# Product Data Sheet

November 2016

INTERNATIONAL MASTER  
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# T8500V

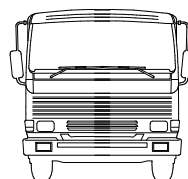
## HP Chromate Free Epoxy Primer P580-3501/-3502/-3503/-3504

<i>Product</i>	<i>Description</i>
P580-3501	HP Chromate Free Epoxy Primer - White
P580-3502	HP Chromate Free Epoxy Primer - Grey
P580-3503	HP Chromate Free Epoxy Primer - Beige
P580-3504	HP Chromate Free Epoxy Primer - Black
P275-3022	Hardener for Epoxy Primer
P275-3025	Plural Mix Hardener
P275-3027	Plural Mix Hardener
P850-1480	Thinner for HP C.F. Epoxy Primer
P850-1479	Thinner for HP C.F. Epoxy Primer - Slow

### Product Description

P580-3501/-3502/-3503/-3504 are high performance amine cured epoxy primers. They are high solids and fast curing products 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 540 g/l.

P580-3501/-3502/-3503/-3504 are ideal under the Turbo Plus, HS Turbo Plus or EHS Turbo Plus topcoat range.



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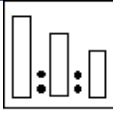






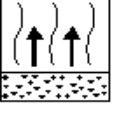



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Product Data Sheet



## Process

	HVLP and Conventional Application	Air Assisted Airless Spray	Airless Spray	
	P580-350X 4 parts P275-3022 1 part Stir thoroughly before adding :- P850-thinners* 1.5 part *see list of thinners above	P580-350X 4 parts P275-3022 1 part Stir thoroughly before adding : P850-thinners 1 part	<b>Plural or standard mix:</b> P580-350X 4 parts P275-3022 1 part	<b>Pluralmix only :</b> P580-350X 2 parts P275-3027 1 part  Or P580-350X 3 parts P275-3025 1 part
	Pot life at 20°C: 4-6 hours Clean gun immediately after use Pot life at 20°C: 4-6 hours Clean gun immediately after use			Pot life at 20°C: N/A  Clean gun immediately after use
	18 – 22 Seconds DIN4 (24 – 30 Seconds BSB4)	30 – 35 s DIN4 (35 – 40 sec BSB4)	71-85s DIN4 (110-130s BSB4)	22 – 24 s DIN4 (26 – 32 seconds BSB4) With P275-3027 30 – 35 s DIN4 (35 – 40 seconds BSB4) With P275-3025
	Gravity or Suction feed: 1.4-1.8 mm Air cap pressure: 3.7-4.0 bar (55-60 psi) Pressure feed: 1.0-1.4 mm			
	Gravity or Suction feed: 1.4-1.8 mm Air cap pressure: 0.675 bar (10psi) max. Pressure feed: 0.85-1.4 mm HVLP			
		Airless: 0.33-0.37 mm (13-15 thou) tip Approx. 140 bar (2000 psi) fluid pressure Air Assisted Airless: 0.33-0.37 mm (13-15 thou) tip Approx. 70 bar (1000 psi) fluid pressure Approx. 1.4-1.8 bar (20-25 psi) air cap pressure		
	2 single coats to give 50-75 microns (2-3 thou) dry film thickness	1-2 coats to give 75-100 microns (3-4 thou) dry film thickness		
	10-15 minutes between coats, depending on dry film thickness and drying conditions  Flash off 15-30 minutes before stoving			
	Air Dry (20°C) : Dust free: 10-15 min. Tack free: 60 min. Hard dry: 16 hours		Low Bake (60°C metal temperature): Hard dry: 60 min.	
Can be recoated wet-on-wet after a minimum of 1 hour air dry. After 7 days maximum but after 24 hours a thorough clean of the surface is recommended.				
	Wet Flattig: P600 or finer.			
	Machine sanding: P240 or finer.			

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**Process**

Substrate	Preparation	Notes
Steel	Blast cleaning is the preferred surface treatment for maximum durability and optimum paint usage. Alternatively flat thoroughly using P80-P180 dry sanding machines discs or P120-P220 wet and dry paper, then clean with P850-1378	Surface must be free from oil/grease, millscale and rust
Stainless Steel	Degrease with P850-1367 and scuff using P180-240 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378	
Aluminium	Flat thoroughly using P240 dry sanding machine discs or Scotchbrite, then clean with P850-1378	Not recommended over jointed aluminium sections. Please, seek advice from your local Nexa Autocolor representative
Sound Factory finishes Sound works primer Sound old finishes (2-pack) Sound electrocoat	Flat thoroughly using P240-P320 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378	Old synthetic finishes must be well cured and non-bleeding
Weathered galvanised steel / Zintec	Clean with P273-901, degrease with P850-1367 and sand using Scotchbrite Fine or P180-P320 dry sanding machine discs	Surface must be free from oxidation residues
Hot dipped galvanised steel	Thoroughly degrease with P850-1367, scuff with Scotchbrite Fine or P400 wet and dry paper, then clean with P850-1378	
GRP "Glasonite"	Clean with P273-901. Flat thoroughly using P240-P280 dry sanding machine discs or P320-P400 wet and dry paper, then clean with P850-1378	Take care not to break through the gel coat when flattening GRP

P580-350X series primers are NOT recommended for use over etch primers or thermoplastic substrates.

For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS Q0100.



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## General Process Notes

### RECOAT

Drying times will depend on film thickness and drying conditions. In common with other primers, longer drying times before recoat will improve final appearance. May be recoated with **Nexa Autocolor** Commercial Transport 2-pack primers/undercoats or directly topcoated with **Nexa Autocolor** Commercial Transport 2-pack topcoats. If topcoated with CT Aquabase P962-Line, it is important that P580-3501/-3502/-3503/-3504 are fully baked or left to dry overnight. See appropriate PDS for further details.

### APPLICATION EQUIPMENT INFORMATION

#### HVLP

The most suitable HVLP gun for the application of Commercial Transport products is the pressure feed system.

Air cap pressure : 0.675 bar (10 psi) maximum  
Paint pressure : 0.3-1.0 bar (5-15 psi)  
If long fluid lines are used, the paint pressure will need to be increased.

#### DRYING

The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation and excessive film thickness will extend the drying times. Overnight temperatures above 15°C are essential for the primer to fully cure.

#### COVERAGE (on ready-for-use paint)

At 4:1:1.5 : Approx. 7 m<sup>2</sup> per litre at a dry film thickness of 50 microns

At 4:1 : Approx. 9 m<sup>2</sup> per litre at a dry film thickness of 50 microns  
Or 4,5 m<sup>2</sup> per litre at a dry film thickness of 100 microns

#### PLURAL MIX USE

Hardeners P275-3022 or P275-3027 can be used with these primers, when needed for plural mixing.  
The mixing ratio is 4 parts primer to 1 part P275-3022  
or 3 parts primer to 1 part P275-3025  
or 2 parts primer to 1 part P275-3027.

P275-3022 is the slower hardener.  
P275-3025 is the medium hardener  
P275-3027 is the faster hardener.

Note: P275-3027 should ONLY be used in a plural mix situation, as it gives a short pot life.

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## SPECTRAL GREYS

For each of the Spectral Grey primer variants specified the following mixing ratio applies:

	Product number	Mix % (by wt.)	Mix Parts	Mix by Target Weight		
				100g	250g	500g
SG1	P580-3501	100		100g	250g	500g
SG3	P580-3501	90	9	90g	225g	450g
	P580-3502	10	1	10g	25g	50g
SG5	P580-3502	100		100g	250g	500g
SG6	P580-3502	70	7	70g	175g	350g
	P580-3504	30	3	30g	75g	150g
SG7	P580-3502	17	1.7	17g	42.5g	85g
	P580-3504	83	8.3	83g	207.5g	415g

### VOC INFORMATION

The EU limit value for this product (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 this product 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](http://www.ppg.com/Autocolor_MSDS)

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