ENVIROBASE®
HIGH PERFORMANCE

Product Information

ECP11 White, ECP15 Gray, ECP17 Black
A-Chromatic Surfacer

Product Description

A-Chromatic Surfacers ECP11 White, ECP15 Gray, and ECP17 Black are premium quality, low VOC primer surfacers specifically designed for use under ENVIROBASE® High Performance (EHP™) waterborne basecoat.

A-Chromatic Surfacers offer excellent adhesion, film build, surface leveling and gloss holdout over a wide range of substrates. A variety of A-Chromatic grays can be achieved by inter mixing the white, gray and black surfacers. This versatile, quick drying, easy to apply and sand primer may be applied as a conventional spray filler or primer surfacer. A-Chromatic surfacers may also be accelerated for faster air dry process as needed.

Preparation of Substrate

In all cases wash all surfaces to be painted with soap and water, then apply the appropriate ONECHOICE® cleaner. Ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.

Original Paintwork should be sanded using European P280 / US 240 grit discs (dry) or European P360 / US320 grade paper (wet). Exposed bare metal should be spot-primed with a suitable bare metal primer (see below).

Electrodeposition Primer must be thoroughly cleaned as outlined above. When using A-chromatic Surfacer as a spray filler or primer surfacer, abrade the electrodeposition primer as recommended in the “original paintwork” section.

Aluminum, Bare Steel, and Galvanized Steel must be clean, rust-free and abraded thoroughly using European P180 / US 180 to European P280 / US 240 grit paper and primed with SX1071 *OneChoice* Etch Primer after sanding.

Polyester Body Fillers should be dry sanded with European P180 / US 180 followed by European P280 / US 240 grit paper.

Gel Coated fiber glass and SMC should be dry sanded using European P280 / US 240 grit paper.

Plastic should be dry sanded with European P600 / US 400 (use a finer grit for softer plastics) and prime first with a Plastic Adhesion Promoter.

APPLICATION GUIDE:

Mixing Ratio

When mixed as:

Spray Filler	Primer Surfacer	Accelerated Primer Surfacer
ECP1x Surfacer: 4 Vols	ECP1x Surfacer: 4 Vols	ECP1x Surfacer: 4 Vols
EH39x Hardener: 1 Vol	EH391/392 Hardener: 1 Vol	EH391/392 Hardener: 1 Vol
	D87xx/DT18xx Thinner: 1 Vol	D87xx/DT18xx Thinner: 1 Vol

Accelerated Primer Surfacer Mix Ratio by Cumulative Weight in Parts (Grams) 4 : 1 : 1 +10%

Volume	4 oz. / ¼ pint	8 oz./ ½ pint	16 oz./ pint	32 oz./ quart
ECP1x	132 (117)	264 (234)	528 (468)	1055 (936)
EH391/EH392	157 (140)	315 (279)	630 (558)	1258 (1116)
D8764 or DT1845	179 (159)	358 (317)	716 (634)	1430 (1269)
SL93LV	195 (173)	390 (346)	781 (692)	1560 (1384)

Note: Use fast hardener and thinner only. Additional volumes may be found on PAINTMANAGER® program software.

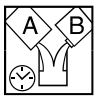
Thinner Selection

D8764:	Fast Compliant Thinner
D8774:	Medium Compliant Thinner
D8767:	Slow Compliant Thinner
DT1845:	Cool Temperature 18-25°C (65-77°F)
DT1850:	Medium Temperature 25-35°C (77-95°F)
DT1855:	Hot Temperature over 35°C (95°C)

Hardener Selection

EH391:	Standard Undercoat Hardener
EH392:	Slow Undercoat Hardener

Pot Life



When sprayed as a…	
Spray Filler	30 minutes at 70°F (21°C)
Primer Surfacer	1 hour at 70°F (21°C)
Accelerated Primer Surfacer	30 minutes at 70°F (21°C)

Additives

Flexible Parts

Ready to Spray	ECP1x:	10 Vols
Universal Flexibilizer	SLV814	1 Vol

Spray gun setup

When Sprayed as a …		
4:1	Spray Filler	1.7-2.0 mm or equivalent
4:1:1	Primer Surfacer	1.6-1.8 mm or equivalent
4:1:1+10%	Accelerated Primer Surfacer	1.6-1.8 mm or equivalent

Spray Pressure

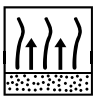
HVLP at the air cap	10 psi
Compliant at the spray gun	29-40 psi

Note: For best overall results, refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.

Number of Coats

As a:	Spray Filler	Primer Surfacer	Accelerated Primer Surfacer
Apply:	Max of 4 wet coats	2-3 wet coats	2-3 wet coats
Film build per wet coat	5.0 mils	3.0 mils	3.0 mils
Dried film build per coat	2.0 mils	1.0 mils	1.0 mils

Flash Off 70°F (21°C)



As a:	Spray Filler	Primer Surfacer	Accelerated Primer Surfacer
Between Coats	5-10 minutes	5-10 minutes	0 minutes
Force Dry	N/A	10 minutes	N/A

APPLICATION GUIDE (cont'd):

Drying Times	**As a:**	**Spray Filler**	**Primer Surfacer**	**Accelerated Primer Surfacer**
	Dust-free 70°F (21°C)	15 minutes	15 minutes	5 minutes
	Dry to Handle 70°F (21°C)	60 minutes	60 minutes	10 minutes
	Dry to Sand Air Dry 70°F (21°C) Force Dry 140°F (60°C)*	6 hours Do Not Force Dry	1½ Hours 30 minutes	20-30 minutes N/A
	Tape Time Air Dry 70°F (21°C) Force Dry 140°F (60°C)*	N/A N/A	N/A N/A	20-30 minutes N/A
	IR (Infrared) Medium Wave Short Wave	Do Not Force Dry	20 minutes 10 minutes	N/A N/A

*Force dry times are quoted for metal temperature. Additional time should be allowed in the force-drying schedule to allow metal to reach recommended temperature.

Overcoat/Recoat	**As a:**	**Spray Filler Primer**	**Primer Surfacer**	**Accelerated Surfacer**
	Dry to Topcoat 70°F (21°C) sanding	6 hours after sanding	1½ hours after sanding	30 minutes after
	140°F (60°C)	N/A	30 minutes after sanding	N/A
	Grade wet Grade dry	European P600 / US 400 followed by European P1200 / US 600 European P360 / US 320 followed by European P1000 / US 500		
	Overcoat with	*Envirobase* High Performance Basecoat		

Performance Guidelines

The use of HVLP spray equipment can give an increase in transfer efficiency of around 25% depending upon the make and model of the equipment used.
When using A-Chromatic Surfacer in a spot repair, adopt the following procedures:

- Thoroughly sand the surface to the edge of the panel or to a distance several centimeters beyond the damaged area, whichever is smaller.
- After applying the material and allowing it to dry as recommended, be careful to thoroughly level the repair edge when sanding.
- Do not attempt spot repair on original or refinish thermoplastic applications, lacquer or 1K finishes.

Also, A-Chromatic Surfacers and its ancillaries are sensitive to moisture, so all equipment must be perfectly dry. Partially used cans of hardener must be carefully closed.

Technical Data

	4:1 Spray Filler	4:1:1 Primer Surfacer	4:1:1+10% Accelerated Primer/ Surfacer
Total Dry Film Build:			
Minimum after sanding	50µ / 2.0 mils	50µ / 2.0 mils	50µ / 2.0 mils
Maximum after sanding	250µ / 10.0 mils	150µ / 6.0 mils	150µ / 6.0 mils
Film build per wet coat	125µ / 5.0 mils	100µ / 4.0 mils	100µ / 4.0 mils
Dried film build per coat	50µ / 2.0 mils	37µ / 1.5 mils	37µ / 1.5 mils

Technical Data (Cont'd)

	Primer Filler	Primer Surfacer	Accelerated Primer Surfacer	Flexible Primer Surfacer
	ECP1x : EH391/EH392	**ECP1x : EH391/EH392 : D87xx/DT18xx**	**ECP1x : EH391/ EH392 : D87xx/DT18xx + SL93LV**	**ECP1x : EH391/EH392 : D87xx/DT18xx + SLV814**
RTS Combinations	4 : 1	4 : 1 : 1	4 : 1 : 1+10%	4 : 1 : 1+10%
Applicable Use Category	Primer	Primer	Primer	Primer (Specialty)
VOC Actual (g/L)	137-143	115-119	104-108	108-111
VOC Actual (lbs./ US gal.)	1.14-1.19	0.96-0.99	0.87-0.90	0.90-0.93
VOC Regulatory (g/L) (less water less exempt)	242-252	240-250	241-250	232-242
VOC Regulatory (lbs./ US gal.) (less water less exempt)	2.01-2.10	2.0-2.09	2.01-2.09	1.94-2.02
Density (g/L)	1503-1554	1430-1520	1421-1502	1412-1492
Density (lbs./ US gal.)	12.54-12.97	11.93-12.68	11.86-12.54	11.78-12.45
Volatiles wt. %	46.0-48.2	53.9-54.6	57.6-58.4	55.4-56.1
Water wt. %	0.0	0.0	0.0	0.0
Exempt wt. %	37.1-38.7	46.3-46.4	50.6-50.8	48.1-48.2
Water vol. %	0.0	0.0	0.0	0.0
Exempt vol. %	43.1-43.4	52.6-52.7	56.7-56.8	53.6-53.7
Solids vol.%	40.1-40.8	33.4-34.0	30.5-31.0	33.2-33.7
Solids wt.%	51.8-54.0	45.4-46.1	41.6-42.4	43.9-44.6
Sq. Ft. Coverage at 1 mil. at 100%	649	540	493	537

A-Chromatic Gray Mixing Chart — A-Chromatic Surfacer

This chart can be used to mix the A-Chromatic Surfacer.
The G1-G7 ratios will help to achieve better hiding when used as a guide for mixing the A-Chromatic Surfacer.

Mix Ratio By Volume			Mix Ratio By Cumulative Weight							
			Grams				Parts			
	Mix Ratio		¼ Pint	½ Pint	Pint	Quart	¼ Pint	½ Pint	Pint	Quart
G1	**ECP11**	**4**	**126**	252	**508**	1025	**142**	258	**574**	1158
	EH391	**1**	**151**	301	**607**	1224	**171**	340	**686**	1383
	D87xx/DT18xx	**1**	**177**	354	**713**	1437	**200**	400	**806**	1624
G3	**ECP11**	**3**	**94**	189	**381**	769	**106**	213	**430**	869
	ECP15	**1**	**126**	252	**509**	1026	**142**	285	**575**	1159
	EH391	**1**	**150**	301	**607**	1225	**169**	340	**686**	1384
	D87xx/DT18xx	**1**	**177**	354	**713**	1439	**200**	400	**806**	1626
G5	**ECP15**	**4**	**127**	253	**511**	1030	**143**	286	**577**	1164
	EH391	**1**	**151**	302	**609**	1229	**171**	341	**688**	1389
	D87xx/DT18xx	**1**	**177**	355	**715**	1442	**200**	401	**808**	1629
G6	**ECP15**	**Mix By Weight Only**	**81**	162	**327**	658	**91**	183	**369**	743
	ECP17		**123**	247	**498**	1001	**139**	279	**563**	1131
	EH391		**148**	296	**597**	1199	**167**	334	**675**	1355
	D87xx/DT18xx		**174**	348	**703**	1413	**197**	393	**794**	1597
G7	**ECP17**	**4**	**122**	243	**491**	990	**138**	275	**555**	1119
	EH391	**1**	**146**	292	**590**	1189	**165**	330	**667**	1343
	D87xx/DT18xx	**1**	**173**	345	**696**	1402	**195**	390	**786**	1584

HEALTH AND SAFETY

See Safety Data Sheet and Labels for additional safety information and handling instructions.



- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDS of all the components, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Store waterborne and solvent borne waste separately. A competent agent with appropriate certification must handle all waterborne wastes. Wastes must be disposed in accordance with all Federal, State, Provincial and local laws and regulations.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

Emergency Medical or Spill Control Information: (412) 434-4515; In Canada (514) 645-1320

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