ENVIROBASE®
HIGH PERFORMANCE

Product Information

ECP35 2.1 VOC High Production Surfacer

Product Description

2.1 VOC high production surfacer is a premium quality, high build, low VOC primer surfacer specifically designed for use under ENVIROBASE® High Performance waterborne basecoat.

The ECP35 high production primer surfacer offers excellent adhesion, film build, surface leveling and gloss holdout over a wide range of substrates. The product will be offered in medium gray. This versatile, quick drying, easy to apply and sand primer will be applied as a primer surfacer.

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 this 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:

Mix Ratio:

ECP35: 4 parts

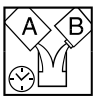
EH39x: 1 part

ECR65/ECR75/ECR85: 1 part

*Do not use ECR98

Thinner Selection		**Hardener Selection**	
ECR65:	up to 29ºC (85ºF)	EH391:	Standard Undercoat Hardener
ECR75:	26-35ºC (80-95ºF)	EH392:	Slow Undercoat Hardener
ECR85:	32ºC (90ºF +)		

Pot Life



45 minutes at 70°F (21°C)

Additives

Flexible Parts

10% Ready to Spray	ECP35	10 Vols
Universal Flexibilizer	SLV814	1 Vol

Spray gun setup

4:1:1	Primer Surfacer	1.4mm 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.

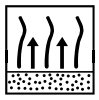
Application

Apply:	2-3 wet coats
Film build per wet coat	3.5 mils
Dried film build per coat	1.5 -2.0 mils

Flash Off
70°F (21°C)

Between Coats	2-3 minutes
Force Dry	10 minutes

Drying Times

	Primer Surfacer
 Dust-free 70°F (21°C)	15 minutes
 Dry to Handle 70°F (21°C)	60 minutes
 Dry to Sand Air Dry 70°F (21°C)	60 minutes
 Force Dry 140°F (60°C)*	15 minutes
 IR (Infrared)	
Short Wave	10 minutes
Medium Wave	20 minutes

*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.

APPLICATION GUIDE (cont'd):

Overcoat/Recoat **Primer Surfacer**

Dry to Topcoat
70°F (21°C) Immediately after sanding
140°F (60°C) 15 minutes after sanding

Grade wet European P600 / US 400 followed by European P1200 / US 600
Grade dry 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 primer 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, primer surfacer 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

4:1:1 Primer Surfacer

Total Dry Film Build:	
Minimum after sanding	50µ / 2.0 mils
Maximum after sanding	150µ / 6.0 mils
Film build per wet coat	100µ / 4.0 mils
Dried film build per coat	37µ / 1.5 mils

*Theoretical coverage in sq. ft./ US gallon ready-to-spray (RTS), 1.0 mil dry film thickness

RTS Information	Primer Surfacer	Flexible Primer Surfacer
	ECP35 : EH391/EH392 : ECR65/75/85	**ECP35 : EH391/EH392 : ECR65/75/85 + SLV814**
RTS Combinations	4 : 1 : 1	4 : 1 : 1+10%
Applicable Use Category	Primer	Primer (Specialty)
VOC Actual (g/L)	108-111	102-104
VOC Actual (lbs./ US gal.)	0.90-0.93	0.85-0.87
VOC Regulatory (g/L) (less water less exempt)	205-211	200-205
VOC Regulatory (lbs./ US gal.) (less water less exempt)	1.71-1.76	1.67-1.71
Density (g/L)	1472-1479	1450-1456
Density (lbs./ US gal.)	12.28-12.34	12.10-12.15
Volatiles wt. %	46.0-46.2	48.1-48.2
Water wt. %	0.0	0.0
Exempt wt. %	38.5-38.6	41.0-41.1
Water vol. %	0.0	0.0
Exempt vol. %	47.2-47.4	48.7-48.9
Solids vol.%	39.7	38.9
Solids wt.%	53.9-54.0	51.8-51.9
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	637	624

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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