

Product Information

ECS21 White, ECS25 Gray, ECS27 Black A-Chromatic LV Sealer

Product Description

A-Chromatic LV Sealer ECS21, ECS25 and ECS27 are premium quality, wet on wet sealers specifically for use under ENVIROBASE® High Performance Waterborne Basecoat.

This fast drying A-Chromatic LV sealer has superior flow properties and excellent topcoat holdout. A variety of A-Chromatic grays can be achieved by intermixing of the three packaged sealers. The sealers can be applied over unsanded OEM e-coat, sanded original finishes and/or properly prepared and treated bare steel, aluminum, fiberglass and plastic.

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 P400 / US 360 grit discs (dry) or European P600 / US 400 grade paper (wet). Exposed metal should be spot-primed with a suitable bare metal primer (see below).



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 (wet). These substrates must be primed with an etch primer. Additional film build over etch primers is strongly recommended, a minimum of 1.5 mils of the A-Chromatic LV Sealer must be applied in two coats.

Electrodeposition Primer must be thoroughly cleaned and may then be directly overcoated with the A-Chromatic LV Sealer as a Wet-on-Wet Sealer without abrading.



Polyester Body Fillers should be dry sanded using 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



ECS2x LV Sealer: 4 Vols.
EH391/EH392 Hardener: 1 Vol.
DT18xx Thinner: 1 Vol.

Thinner Selection

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)

Pot Life



1 hour at 70°F (21°C)

Additives



SLV814 Universal Flexibilizer:
Ready to Spray ECS2x LV Sealer: 10 Vols.
SLV814: 1 Vol.

Spraygun set up



Fluid Tip: 1.4 - 1.6 mm or equivalent
Spray Viscosity: 20 - 25 seconds #2 Zahn at 70°F (21°C)

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



1 - 2 coats
Film build per wet coat: 2.5 mils
Dried film build per coat: 1.0 mils

Flash Off 70°F (21°C)



Between Coats: 5 - 10 minutes
Before Baking: 5 - 10 minutes
Before topcoating: 15 minutes at 70°F (21°C) for 1 coat
30 minutes at 70°F (21°C) for 2 coats

After 72 hours, sealer must be sanded. If sanded film is below 1 mil, sealer must be reapplied.

Drying Times



Dust-Free
70°F (21°C) 10 minutes

Dry to handle
70°F (21°C) 1 hour

Tape Time
70°F (21°C) 1½ hours



IR (Infrared) 10 minutes Medium Wave
5 minutes Short Wave

APPLICATION GUIDE (cont'd):

Overcoat/Recoat



Envirobase High Performance

15 minutes at 70°F (21°C) for 1 coat
30 minutes at 70°F (21°C) for 2 coats

Note: After 72 hours, sealer must be sanded. If sanded film is below 1 mil, sealer must be reapplied.



Grade wet:
Grade dry:

P1000 / US 500 grade paper
P1000 / US 500 grade paper

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.
- For all substrates except un-sanded electrodeposition primer, ensure that the surface is thoroughly sanded to the panel edge or to a distance several centimeters beyond the damaged area, whichever is the smaller.
- Do not attempt spot repair on original or refinish thermoplastic applications, lacquer or 1K finishes.
- Partially used cans of hardener must be carefully closed.

Technical Data

Total Dry Film Build:

Minimum	25μ / 1.0 mils
Maximum	37μ / 1.5 mils
Film build per wet coat	62.5μ / 2.5 mils
Dried film build per coat	25μ / 1.0 mils
% solids by volume RTS	34.5%
Theoretical coverage*	550 sq. ft. per US gallon

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

	ECS2x : EH391 : DT18xx	ECS2x : EH392 : DT18xx	ECS2x : EH391 : DT18xx + SLV814	ECS2x : EH392 : DT18xx + SLV814
RTS Combinations	4 : 1 : 1	4 : 1 : 1	4 : 1 : 1+10%	4 : 1 : 1+10%
Applicable Use Category	Primer Sealer	Primer Sealer	Primer Sealer	Primer Sealer
VOC Actual (g/L)	95	111	90	105
VOC Actual (lbs./ US gal.)	0.80	0.93	0.75	0.87
VOC Regulatory (g/L) (less water less exempt)	218	246	210	236
VOC Regulatory (lbs./ US gal.) (less water less exempt)	1.82	2.05	1.75	1.97
Density (g/L)	1372 - 1431	1365 - 1424	1359 - 1412	1352 - 1405
Density (lbs./ US gal.)	11.45 - 11.94	11.39 - 11.88	11.34 - 11.78	11.28 - 11.72
Volatiles wt. %	57.4 - 59.4	57.3 - 59.3	58.7 - 60.5	58.6 - 60.4
Water wt. %	0.0	0.0	0.0	0.0
Exempt wt. %	50.5 - 52.7	49.3 - 51.5	52.1 - 54.1	51.0 - 52.9
Water vol. %	0.0	0.0	0.0	0.0
Exempt vol. %	56.6	55.0	57.3	55.8

AChromatic Gray Mixing Chart

AChromatic LV Sealer

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

	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	ECS21	4	116	232	464	928	131	262	523	1047
	EH39x	1	141	282	564	1128	159	318	636	1272
	DT18xx	1	167	334	668	1336	188	377	753	1507
G3	ECS21	3	87	174	348	696	98	196	392	785
	ECS25	1	116	232	464	928	131	262	523	1047
	EH39x	1	141	282	564	1128	159	318	636	1272
	DT18xx	1	167	334	668	1336	188	377	753	1507
G5	ECS25	4	116	232	464	928	131	262	523	1047
	EH39x	1	141	282	564	1128	159	318	636	1272
	DT18xx	1	167	334	668	1336	188	377	753	1507
G6	ECS25	3	87	174	348	696	98	196	392	785
	ECS27	1	116	232	464	928	131	262	523	1047
	EH39x	1	141	282	564	1128	159	318	636	1272
	DT18xx	1	167	334	668	1336	188	377	753	1507
G7	ECS27	4	115	230	460	920	130	259	519	1038
	EH39x	1	140	280	560	1120	158	316	632	1263
	DT18xx	1	166	332	664	1328	187	374	749	1498

HEALTH AND SAFETY

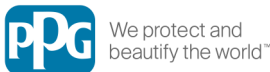
See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



- 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 MSDS 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 MSDS 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 MSDS.
- 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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