ENVIROBASE®
HIGH PERFORMANCE

Product Information

ECS81 White, ECS85 Gray, ECS87 Dark Gray A-Chromatic Sealers

Product Description

A-Chromatic Sealers ECS81White, ECS85 Gray and ECS87 Dark Gray are premium quality sealers designed specifically for use under ENVIROBASE® High Performance Waterborne Basecoat.

For use under *Envirobase* High Performance basecoat, these A-Chromatic Sealers are ready to top coat in 15 minute and have the best leveling and blend edge properties available today . All 3 sealer colors were selected to match A-Chromatic shades G1, G5 and G7 and with a simple mix ratio, G3 and G6 can easily be achieved. The sealer 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 P400 grit discs (dry) or P600 grade paper (wet). Exposed bare 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 P280 - P320 grit paper. These substrates must be primed with SX1071 Etch Primer.

Electrodeposition Primer must be thoroughly cleaned and can be directly overcoated with the A-Chromatic Sealer without abrading.

Polyester Body Fillers should be dry sanded and finished with P320-P400 grit paper.

Gel Coated Fiber Glass and SMC should be dry sanded using P320-400 grit paper.

Plastic should be dry sanded with P600 (use a finer grit for softer plastics) and prepared first with a Plastic Adhesion Promoter before sealing.

APPLICATION GUIDE:

Mixing Ratio for ECS8X Sealers Compliant

ECS8x Sealer: 4 Vols.
EH391/EH392 Hardener: 1 Vol.
ECRxx/DT18xx Thinner: 1 Vol.

Pot Life at 70°F (21°C): 1 hour

Hardener:
EH391: Standard Undercoat Hardener
EH392: Slow Undercoat Hardener

Recommended Reducer:
ECR65 Low Temp Reducer
ECR75 Mid Temp Reducer
ECR85 High Temp Reducer

Thinner/Reducer
DT1845 Compliant Reducer Normal
DT1850 Compliant Reducer Medium
DT1855 Compliant Reducer Slow

Optional Additives:

None
Addition of flexibilizer when painting over plastic is not required.

Spraygun Set-up and Pressure:

Fluid Tip: 1.4 - 1.6 mm or equivalent
Spray Viscosity: 15 - 17 seconds DIN4 @70°F (21°C)

Application:

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 coat
Dry film build: 0.7 - 1.0 mils

Flash Off 70°F (21°C):

Before topcoating: 15 minutes
70°F (21°C)

After 8 hours, sealer must be sanded. If sanded film is below 0.7 mil, sealer must be reapplied.

Drying Times:

Dust-Free 10 minutes
70°F (21°C)

Dry to handle 20 - 30 minutes
70°F (21°C)

Tape Time 1 hour
70°F (21°C)

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)

Note: After 8 hours, sealer must be sanded. If sanded film is below 0.7 mil, sealer must be reapplied.

Grade wet: P1000 / US 500 grade paper
Grade dry: 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 unsanded 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 smaller.
- Do not apply over thermoplastic finishes such as lacquer.
- Partially used cans of hardener must be kept closed to prevent moisture contamination.

Technical Data:

RTS Combinations	**ECS8x : EH391/EH392 : ECRxx/DT18xx**
Ratio	4 : 1 : 1
Applicable Use Category	Primer Sealer
VOC Actual (g/L)	49 - 133
VOC Actual (lbs./ US gal.)	0.41 - 1.11
VOC Regulatory (less water, less exempt (g/L)	114 - 248
VOC Regulatory (less water, less exempt (lbs./ US gal.)	0.95 - 2.07
Density (g/L)	1421- 1493
Density (lbs./ US gal)	11.86 - 12.46
Volatiles wt.%	50.9 - 54.3
Water wt.%	0.0
Exempt wt.%	41.6 - 51.0
Water vol.%	0.0
Exempt vol.%	46.2 - 57.4
RTS Solids vol.%	37.1 - 38.5
RTS Solids wt.%	45.7 - 49.1
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	595 - 616

A-Chromatic Gray Mixing Chart — A-Chromatic Sealer

This chart can be used to mix the A-Chromatic Sealer
The G1-G7 ratios will help to achieve proper color match when used as a guide for mixing the A-Chromatic 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	ECS81	4	125	250	499	999	141	282	564	1127
	EH39x	1	150	300	598	1197	169	338	675	1350
	Reducer/Thinner	1	170	341	681	1361	192	384	768	1536
G3	ECS81	2.67	83	166	333	666	94	188	376	752
	ECS85	1.33	125	250	500	1000	141	282	564	1129
	EH39x	1	150	299	599	1198	169	338	676	1352
	Reducer/Thinner	1	170	341	681	1362	192	384	769	1537
G5	ECS85	4	125	251	501	1002	141	283	566	1131
	EH39x	1	150	300	600	1200	169	339	677	1354
	Reducer/Thinner	1	171	341	682	1364	193	385	770	1540
G6	ECS85	2.22	70	139	278	557	79	157	314	628
	ECS87	1.78	125	250	500	999	141	172	564	1128
	EH39x	1	150	299	598	1197	169	228	675	1351
	Reducer/Thinner	1	170	340	681	1361	192	274	768	1537
G7	ECS87	4	124	249	498	995	140	281	562	1123
	EH39x	1	149	298	597	1193	168	337	673	1347
	Reducer/Thinner	1	170	339	679	1358	192	383	766	1532

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.
- 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

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, result, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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PPG Automotive Refinish
19699 Progress Drive
Strongsville, OH 44149
800.647.6050

Follow us online:

www.ppgrefinish.com

PPG Canada Inc.
2301 Royal Windsor Drive, Unit #6
Mississauga, Ontario L5J 1K5
888.310.4762

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