ENVIROBASE®
HIGH PERFORMANCE

Product Information

ECS61 White, ECS65 Gray, ECS67 Black A-Chromatic Sealer

Product Description

A-Chromatic Sealer ECS61White, ECS65 Gray and ECS67 Black are premium quality, wet on wet sealers designed specifically for use under ENVIROBASE® High Performance Waterborne Basecoat.

The fast drying A-Chromatic Sealers have 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 un-sanded 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 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 European P180 / US 180 to European P280 / US 240 grit paper (wet). These substrates must be primed with SX1071 Etch Primer, Additional film build over etch primers is strongly recommended, a minimum of 1.5 mils of the A-Chromatic Sealer must be applied in two coats.

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

Polyester Body Fillers should be dry sanded with 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

ECS6x Sealer:	**3 Vols.**
EH391/EH392 Hardener:	**1 Vol.**
D87x/DT8xx Thinner:	**1 Vol.**

Thinner Selection

D870 / DT860: up to 18°C (65°F)
D871 / DT870: 18-25°C (65-77°F)
D872 / DT885: 25-35°C (77-95°F)
D873 / DT895: over 35°C (95°C)

Hardener Selection

EH391: Standard Undercoat Hardener
EH392: Slow Undercoat Hardener

Pot Life

1 hour at 70°F (21°C)

Additives

Plasticizer:		
Universal	Ready to Spray ECS6x Sealer:	10 Vols
Flexibilizer	SL814/SLV814	1 Vol

Spraygun set up

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

Spray Pressure

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

Number of Coats

1 - 2 wet 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 10 minutes
70°F (21°C)

Dry to Handle 1 hour
70°F (21°C)

Tape Time 1½ hours
Air Dry 70°F (21°C)

IR (Infrared)

Medium Wave	10 minutes
Short Wave	5 minutes

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 After 72 hours, sealer must be sanded. If sanded film is below 1 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 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	25µm / 1.0 mils
Maximum	37µm / 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*	Approx. 550 sq. ft.

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

	ECS6x : EH391/EH392 : D87x/DT8xx	**ECS6x : EH391/EH392 : D87x/DT8xx + SL814**	**ECS6x : EH391/EH392 : D87x/DT8xx + SLV814**
RTS Combinations	3 : 1 : 1	3 : 1 : 1 +10%	3 : 1 : 1 +10%
Applicable Use Category	N/A	N/A	N/A
VOC Actual (g/L)	262-366	293-388	242-337
VOC Actual (lbs./ US gal.)	2.19-3.05	2.44-3.23	2.01-2.80
VOC Regulatory (g/L) (less water less exempt)	401-480	429-495	387-464
VOC Regulatory (lbs./ US gal.) (less water less exempt)	3.35-4.01	3.58-4.13	3.23-3.87
Density (g/L)	1280-1303	1248-1268	1275-1295
Density (lbs./ US gal.)	10.68-10.87	10.41-10.58	10.64-10.81
Volatiles wt. %	51.4-52.1	52.4-53.0	53.4-53.9
Water wt. %	0.0	0.0	0.0
Exempt wt. %	23.6-31.2	22.0-29.1	27.6-34.6
Water vol. %	0.0	0.0	0.0
Exempt vol. %	23.6-34.7	21.5-31.5	27.3-37.3

*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 better hiding 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	ECS61	3	104	209	417	835	117	235	470	941
	EH39x	1	134	268	537	1073	151	302	604	1208
	D87x/DT8xx	1	154	309	617	1234	174	348	695	1391
G3	ECS61	2	70	139	278	556	78	157	314	627
	ECS65	1	104	208	416	831	116	234	468	937
	EH39x	1	134	267	535	1070	151	301	602	1205
	D87/DT8xx	1	154	308	615	1231	173	346	693	1387
G5	ECS65	3	103	206	412	824	116	232	465	929
	EH39x	1	133	266	531	1062	150	299	598	1197
	D87x/DT8xx	1	153	306	612	1224	172	344	688	1379
G6	ECS65	2	69	137	275	550	77	155	310	619
	ECS67	1	103	206	411	823	116	232	463	927
	EH39x	1	133	265	530	1061	149	299	597	1195
	D87x/DT8xx	1	157	314	627	1254	177	353	707	1413
G7	ECS67	3	102	205	409	819	115	231	482	922
	EH39x	1	132	264	529	1057	149	298	595	1191
	D87x/DT8xx	1	152	305	609	1218	172	343	686	1372

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.

We protect and beautify the world™

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