NEXA AUTOCOLOR

INNOVATING REPAIR SOLUTIONS

Designed for use with

Aquabase PLUS

PDS N4.14C NR

October 2018

AQUABASE® PLUS
P565-3141, P565-3145, P565-3147
HS Plus Wet-on-Wet Sealer LV / National Rule

For National Rule Markets

PRODUCT DESCRIPTION

AQUABASE® Plus HS Plus Wet-on-Wet Sealers LV are acrylic urethane wet on wet undercoats developed for use under AQUABASE® Plus Waterborne Basecoat color. They offer easy application with excellent holdout and durability.

As components of the Spectral Grey undercoat system, HS Plus Wet-on-Wet Sealer LV are available in white, grey and dark grey and are used to achieve the full range of Spectral Grey shades SG01 through SG07. Each basecoat formula references a specific Spectral Grey undercoat shade. Using the specified Spectral Grey undercoat is a vital step to achieve proper color match resulting in consistent results.

- *Spectral Grey System = Reduced color costs*
- *Excellent Holdout = Less rework*
- *Fast Dry = Reduced Process Time*

Products	
P565-3141 (White)/-3145 (Grey) /-3147 (Black)	HS Plus Wet-on-Wet Sealers LV
P210-5475/-5476	Hardeners
P850-1692/-1693/-1694/-1695	Thinner
P100-2020	Flexible Additive
SL814	Universal Flexibilizer

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

HS Plus Wet-on-Wet Sealers LV

NATIONAL RULE PROCESS	
MIX RATIO 	**P565-314x Wet-on-Wet Sealer LV** 4 parts **P210-547x Hardener** 1 part **P850-169x Reducer** 1 part
POTLIFE 	**Sprayable Pot Life:** Pot Life: 1 hour at 70°F (21°C) Viscosity: 17 - 20 seconds DIN4 at 70°F (21°C)
SPRAYGUN & AIR PRESSURE 	**Fluid Tip:** 1.4 - 1.6 mm **HVLP:** 10 PSI cap pressure **Compliant:** 29 - 40 PSI at the gun **Note:** Refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.
APPLICATION 	**Apply:** 1 - 2 coats (approximately 1.0 - 2.0 mils) **Note:** Film build will depend on fluid tip selection
FLASH TIME 	**Between coats:** 5 - 10 minutes
DRY TIMES  	**Air Dry:** 1 coat: 15 minutes at 70°F (21°C) 2 coats: 30 minutes at 70°F (21°C) **Infrared:** Short Wave: 8 - 12 minutes after 5 minutes flash
TOPCOAT 	**Time to topcoat:** 1 coat: 15 minutes at 70°F (21°C) 2 coats: 30 minutes at 70°F (21°C)

All force dry times are quoted for surface temperature.
Additional time must be allowed during force dry to allow surface to reach recommended temperature.

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HS Plus Wet-on-Wet Sealers LV

GENERAL PROCESS NOTES

SUBSTRATES

HS Plus Wet-on-Wet Sealers LV can be applied over:

Factory primer, GRP/Fiberglass, existing finishes in good condition, and polyester putties after degreasing and machine sanding with P320-P400 grit dry.

E-Coat - After proper cleaning and degreasing, HS Plus Wet-on-Wet Sealers LV may be applied over OEM e-coat replacement parts without sanding. For optimum performance, exterior parts should be lightly abraded and cleaned prior to the application of wet-on-wet sealer.

Bare Metal - Before applying HS Plus Wet-on-Wet Sealers LV over bare steel or aluminum, ONECHOICE® SX1071 Etch Prime must first be applied.

PROCESS NOTES

CHOICE OF HARDENER AND THINNER

Hardener and thinner selection will depend mainly on temperature, but also on air movement and size of repair.

P210-5475	HS Plus Surfacer / Sealer Hardener
P210-5476	Undercoat Hardener - Slow
P850-1692	Thinner - Low Temperature
P850-1693	Thinner - Mid Temperature
P850-1694	Thinner - High Temperature
P850-1695	Thinner - Very High Temperature

All drying times in this summary will depend on the film thickness applied and temperature.

For optimum performance, paint systems should not be applied cold. For best results, allow adequate time for paint to reach 70°F (21°C).

PLASTICS USAGE

		Flexible	Very Flexible
P565-314x	HS Plus Wet-on-Wet Sealers LV	5 parts	2 parts
P100-2020/SL814	Flexible Additive	1 part	1 part

Plastics - When using HS Plus Wet-on-Wet Sealers LV on plastics, they must be flexed at a 5:1 (20%) ratio with P100-2021 Flexible Additive prior to activating and thinning.
More detail on refinishing plastics can be found in PDS N7.1C

RECOATABILITY

HS Plus Wet-on-Wet Sealer LV can be directly top coated with *Aquabase* Plus waterborne basecoat after:

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

If left to dry longer than 72 hours, sealer must be sanded prior to top coating. If dry film is below 1 mil after sanding, additional sealer must be applied.

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HS Plus Wet-on-Wet Sealers LV

SPECTRAL GREYS

Aquabase Plus Spectral Grey Mixing Chart	P565-314x HS Plus Wet on Wet Sealers

This chart can be used to mix P565-314x HS Plus Primer-Surfacers LV. The SG01-SG07 ratios will help to achieve better hiding when used as a guide for mixing the Spectral Grey Primer-Surfacers

MIX RATIO BY VOLUME			MIX RATIO BY WEIGHT Cumulative Weight in Grams			
Ratio			¼ Pint	½ Pint	1 Pint	1 Quart
SG01	P565-3141 P210-547x P850-169x	4 1 1	**118** **143** **159**	236 286 318	**473** **572** **636**	945 1144 1273
SG03	P565-3141 (70%) P565-3145 (30%) P210-547x P850-169x	3 1 1 1	**89** **118** **143** **159**	177 236 286 318	**354** **472** **572** **636**	709 946 1143 1272
SG05	P565-3145 P210-547x P850-169x	4 1 1	**118** **143** **159**	236 285 317	**471** **570** **634**	942 1141 1270
SG06	P565-3145 (70%) P565-3147 (30%) P210-547x P850-169x	3 1 1 1	**88** **118** **142** **158**	177 235 285 317	**353** **470** **569** **633**	707 940 1139 1268
SG07	P565-3147 P210-547x P850-169x	4 1 1	**117** **142** **158**	233 283 315	**467** **566** **630**	934 1132 1261

Note: These weights will produce approximately 97.5% of the volume stated to allow for mixing in the can. If an exact quart, pint, half-pint, etc. is required, multiply all weights by 1.025.
All weights have been rounded off to whole numbers.

EQUIPMENT CLEANING

Approved NEXA AUTOCOLOR® or PPG Cleaning Solvent

VOC COMPLIANCE

To ensure accurate mixing, best performance & VOC compliance:

- Use the correct mixing ratio for the regulated areas.
- Do not add extra hardener, thinner or change the recommended mixing ratio.
- Do not use hardeners or thinners that are not specified in this process summary.
- Do not tint except where as referenced in the Spectral Grey chart.

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HS Plus Wet-on-Wet Sealers LV

GENERAL PROCESS NOTES

RTS Combinations	**Standard System:** P565-314x : P210-547x : P850-169x	**Flexible System:** (Premix P565-314x : P100-2020 at 5 : 1) P565-314x/P100-2020 : P210-547x : P850-169x
Volume Ratio	4 : 1 : 1	4 : 1 : 1
Applicable Use Category	Primer Sealer	Specialty Coating / Flexed Primer Sealer
VOC Actual (g/L)	229-231	258-284
VOC Actual (lbs./Gal)	1.91-1.93	2.15-2.37
VOC Regulatory (g/L) (less water, less exempts)	381-386	398-436
VOC Regulatory (lbs./Gal) (less water, less exempts)	3.18-3.22	3.32-3.64
Solids wt. %	43.4-44.0	41.7-44.6
Solids vol. %	32.8-33.1	32.0-34.8

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 SDSs of all the components since the mixture will have the hazards of all of 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.

EMERGENTY 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 public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statement listed on label. Statement and methods descried are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only an dare not to be construed as representations or warrantied as to performance, results 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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