

Designed for use with



January 2020

AQUABASE[®] PLUS P565-3141 & P565-3147 HS Plus Wet-on-Wet Sealers LV **Special**

PRODUCT DESCRIPTION

AQUABASE[®] Plus HS Plus Wet-on-Wet Sealers LV P565-3141 and P565-3147 are acrylic urethane wet on wet undercoats developed for use under AQUABASE[®] Plus Waterborne Basecoat color.

This special product information sheet is designed to provide directions for creating Spectral Grey shades SG03, SG05, and SG06 using only the P565-3141 White and P565-3147 Black sealers along with appropriate hardener and thinner.

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.

| | |
|---------------------------------------|-------------------------------|
| Products | |
| P565-3141 (White) & P565-3147 (Black) | HS Plus Wet-on-Wet Sealers LV |
| P210-5475 | Hardeners |
| P850-1775 | Thinner |
| P100-2021 | LV Flexible Additive |
| SLV814 | Universal Flexibilizer |

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

HS Plus Wet-on-Wet Sealers LV

| PROCESS | |
|----------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| MIX RATIO | P565-314x Wet-on-Wet Sealer LV 4 parts P210-5475 Hardener 1 part P850-1775 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 |
| P850-1775 | Slow Reducer |

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

| | | | |
|------------------|-------------------------------|----------|---------------|
| P565-314x | HS Plus Wet-on-Wet Sealers LV | Flexible | Very Flexible |
| P100-2021/SLV814 | Flexible Additive | 5 parts | 2 parts |
| | | 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.

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 HS Plus Wet on Wet Sealers LV. The SG03-SG06 ratios will help to achieve better hiding when used as a guide for mixing the Spectral Grey Wet on Wet Sealers LV

| MIX RATIO BY VOLUME | | | MIX RATIO BY WEIGHT Cumulative Weight in Grams | | | |
|---------------------|-----------|------|---------------------------------------------------|--------|--------------|---------|
| Ratio | | | ¼ Pint | ½ Pint | 1 Pint | 1 Quart |
| SG03 | P565-3141 | 3.6 | 120.2 | 240.4 | 480.8 | 961.5 |
| | P565-3147 | 0.4 | 133.4 | 266.7 | 533.5 | 1066.9 |
| | P210-5475 | 1 | 161.4 | 322.8 | 645.7 | 1291.3 |
| | P850-1775 | 1 | 191.3 | 382.6 | 765.1 | 1530.3 |
| SG05 | P565-3141 | 2.89 | 96.2 | 192.3 | 384.6 | 769.2 |
| | P565-3147 | 1.11 | 133.0 | 266.1 | 532.2 | 1064.3 |
| | P210-5475 | 1 | 161.1 | 322.2 | 644.4 | 1288.7 |
| | P850-1775 | 1 | 191.0 | 381.9 | 763.8 | 1527.7 |
| SG06 | P565-3141 | 1.13 | 37.4 | 74.8 | 149.9 | 299.1 |
| | P565-3147 | 2.87 | 132.2 | 264.5 | 529.0 | 1057.9 |
| | P210-5475 | 1 | 160.3 | 320.6 | 641.2 | 1282.4 |
| | P850-1775 | 1 | 190.2 | 380.3 | 760.6 | 1521.3 |

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.

HS Plus Wet-on-Wet Sealers LV

GENERAL PROCESS NOTES

| RTS Combinations | Standard System: P565-314x : P210-5475 : P850-1775 | Flexible System: (Premix P565-314x : P100-2021 at 5 : 1) P565-314x/P100-2021 : P210-5475 : P850-1775 |
|------------------------------------------------------|----------------------------------------------------------|------------------------------------------------------------------------------------------------------------------|
| Volume Ratio | 4 : 1 : 1 | 4 : 1 : 1 |
| Applicable Use Category | Primer Sealer | Primer Sealer |
| VOC Actual (g/L) | 92-96 | 83-98 |
| VOC Actual (lbs./Gal) | 0.77-0.80 | 0.69-0.82 |
| VOC Regulatory (g/L) (less water, less exempts) | 213-216 | 200-216 |
| VOC Regulatory (lbs./Gal) (less water, less exempts) | 1.78-1.80 | 1.67-1.80 |
| Density (g/L) | 1416-1431 | 1383-1401 |
| Density (lbs./Gal) | 11.82-11.94 | 11.54-11.69 |
| Volatiles wt. % | 58.6-59.3 | 58.6-61.7 |
| Water wt. % | 0.0 | 0.0 |
| Exempt wt. % | 52.1-52.7 | 51.7-55.8 |
| Water vol. % | 0.0 | 0.0 |
| Exempt vol. % | 56.5-57.0 | 54.5-59.0 |
| Solids vol. % | 32.8-33.1 | 31.9-34.8 |
| Solids wt. % | 40.7-41.4 | 38.3-41.4 |
| Sq. ft. coverage/ US Gal at 1 mil at 100% transfer | 526-531 | 511-558 |

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.

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 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 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, 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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