



# PDS N4.13C

October 2018

## AQUABASE<sup>®</sup> PLUS P565-3121, P565-3125, P565-3127 HS Plus Wet-on-Wet Sealers

### PRODUCT DESCRIPTION

AQUABASE<sup>®</sup> Plus HS Plus Wet-on-Wet Sealers are acrylic urethane 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 Sealers are available in white, grey and black 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	
P565-3121 (White)/-3125 (Grey) /-3127 (Black)	HS Plus Wet-on-Wet Sealers
P210-5475/-5476	Hardeners
P850-1772/-1775	Thinners
P100-2021	LV Flexible Additive
SLV814	Universal Flexibilizer

**THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY**

# HS Plus Wet-on-Wet Sealers

PROCESS	
<b>MIX RATIO</b> 	<b>P565-312x Wet-on-Wet Sealer</b> 3 parts <b>P210-547x Hardener</b> 1 part <b>P850-177x Reducer</b> 1 part
<b>POTLIFE</b> 	<b>Sprayable Pot Life:</b> Pot Life:                                1 hour at 70°F (21°C) Viscosity:                                15 - 17 seconds DIN4 at 70°F (21°C)
<b>SPRAYGUN &amp; AIR PRESSURE</b> 	<b>Fluid Tip:</b> 1.4 - 1.6 mm <b>HVLP:</b> 10 PSI cap pressure <b>Compliant:</b> 29 - 40 PSI at the gun*  <b>Note:</b> Refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.
<b>APPLICATION</b> 	<b>Apply:</b> 1 - 2 coats (approximately 1.0 - 2.0 mils)  <b>Note:</b> Film build will depend on fluid tip selection
<b>FLASH TIME</b> 	<b>Between coats:</b> 5 - 10 minutes
<b>DRY TIMES</b> 	<b>Air Dry:</b> 1 coat:                                    15 minutes at 70°F (21°C) 2 coats:                                   30 minutes at 70°F (21°C)  <b>Infrared:</b> Short Wave:                              8 - 12 minutes after 5 minutes flash
<b>TOPCOAT</b> 	<b>Time to topcoat:</b> 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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## GENERAL PROCESS NOTES

### SUBSTRATES

HS Plus Wet-on-Wet Sealers 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 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 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
P850-1772	Fast Reducer
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

P565-312x	HS Plus Wet-on-Wet Sealers	5 parts
P100-2021/SLV814	Flexible Additive	1 part

Plastics - When using HS Plus Wet-on-Wet Sealers 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 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

## SPECTRAL GREYS

### Aquabase Plus Spectral Grey Mixing Chart

### P565-312x HS Plus Wet on Wet Sealers

This chart can be used to mix P565-312x HS Plus Wet on Wet Sealers. The SG01-SG07 ratios will help to achieve better hiding when used as a guide for mixing the Spectral Grey Wet on Wet Sealers

MIX RATIO BY VOLUME			MIX RATIO BY WEIGHT Cumulative Weight in Grams			
Ratio			¼ Pint	½ Pint	1 Pint	1 Quart
SG01	P565-3121	3	<b>104</b>	207	<b>417</b>	834
	P210-547x	1	<b>134</b>	266	<b>535</b>	1070
	P850-177x	1	<b>166</b>	329	<b>662</b>	1324
SG03	P565-3121 (70%)	3	<b>69</b>	138	<b>278</b>	556
	P565-3125 (30%)		<b>103</b>	206	<b>415</b>	831
	P210-547x	1	<b>132</b>	265	<b>533</b>	1068
	P850-177x	1	<b>163</b>	328	<b>660</b>	1322
SG05	P565-3125	3	<b>102</b>	204	<b>412</b>	824
	P210-547x	1	<b>131</b>	263	<b>530</b>	1060
	P850-177x	1	<b>162</b>	326	<b>657</b>	1314
SG06	P565-3125 (70%)	3	<b>68</b>	136	<b>275</b>	555
	P565-3127 (30%)		<b>102</b>	204	<b>411</b>	822
	P210-547x	1	<b>131</b>	263	<b>529</b>	1058
	P850-177x	1	<b>162</b>	326	<b>656</b>	1312
SG07	P565-3127	3	<b>101</b>	203	<b>409</b>	818
	P210-547x	1	<b>130</b>	262	<b>527</b>	1054
	P850-177x	1	<b>161</b>	325	<b>654</b>	1308

**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

## GENERAL PROCESS NOTES

RTS Combinations	Standard System: P565-312x : P210-547x : P850-177x	Flexible System: (Premix P565-312x : P100-2021 at 5 : 1) P565-312x/P100-2021 : P210- 547x : P850-177x
Volume Ratio	3 : 1 : 1	3 : 1 : 1
Applicable Use Category	Primer Sealer	Primer Sealer
VOC Actual (g/L)	170 - 179	151 - 165
VOC Actual (lbs./Gal)	1.42 - 1.49	1.26 - 1.38
VOC Regulatory (g/L) (less water, less exempts)	309 - 326	290 - 304
VOC Regulatory (lbs./Gal) (less water, less exempts)	2.58 - 2.72	2.42 - 2.54
Density (g/L)	1335 - 1399	1310 - 1375
Density (lbs./Gal)	11.14 - 11.67	10.93 - 11.47
Volatiles wt. %	52.7 - 55.7	53.6 - 58.7
Water wt. %	0.0	0.0
Exempt wt. %	39.9 - 42.9	41.4 - 47.6
Water vol. %	0.0	0.0
Exempt vol. %	44.7 - 45.6	45.2 - 49.6
Solids vol. %	34.4 - 35.9	33.1 - 36.7
Solids wt. %	44.3 - 47.4	41.3 - 46.4
Sq. ft. coverage/ US Gal at 1 mil at 100% transfer	551 - 576	530 - 589

### 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 dare 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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