ENVIROBASE®
HIGH PERFORMANCE

Product Information

ECS61 White, ECS67 Black A-Chromatic Sealer

SPECIAL CANADA

Product Description

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

This special product information sheet is designed to provide directions for creating A-Chromatic shades G3, G5 and G6 using only the ECS61 White and ECS67 Black sealers along with appropriate hardener and reducer.

The fast drying A-Chromatic Sealers have superior flow properties and excellent topcoat holdout. 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.

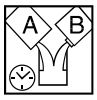
APPLICATION GUIDE:

Mixing Ratio

ECS6x Sealer:	**3 Vols.**
EH391 Hardener:	**1 Vol.**
DT1855 Reducer:	**1 Vol.**

Hardener	**Reducer**
EH391 Standard Undercoat Hardener	DT1855 Compliant Reducer Slow

Pot Life



1 hour at 70°F (21°C)

Additives

SLV814 Universal Flexibilizer:	
Ready to Spray ECS6x Sealer:	10 Vols.
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

Note: For best overall results, refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.

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 70°F (21°C) — 10 minutes

Dry to Handle 70°F (21°C) — 1 hour

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

IR (Infrared) — 10 minutes Medium Wave
5 minutes Short Wave

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

APPLICATION GUIDE (cont'd):

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

*A*Chromatic Gray Mixing Chart — *A*Chromatic LV Sealer

This chart can be used to mix the A-Chromatic LV Sealer.
The G3-G6 ratios will help to achieve better hiding when used as a guide for mixing the A-Chromatic LV Sealer.

Mix Ratio By Volume		Mix Ratio By Cumulative Weight Parts/Grams							
	Mix Ratio	4 oz.	6 oz.	8 oz.	12 oz.	16 oz.	20 oz.	24 oz.	32 oz.
G3	ECS61 White	106.4	159.6	212.8	319.2	425.6	532.0	638.4	851.2
	ECS67 Black	116.8	175.2	233.6	350.4	467.2	583.9	700.7	934.3
	EH391 Undercoat Hardener	150.5	225.7	300.9	451.4	601.8	746.3	902.7	1203.6
	DT1855 Compliant Reducer Slow	173.2	259.9	346.5	519.7	693.0	859.3	1039.5	1385.9
G5	ECS61 White	84.2	126.3	168.4	252.6	336.8	420.9	505.1	673.5
	ECS67 Black	116.5	174.7	233.0	349.5	466.0	582.5	699	932.
	EH391 Undercoat Hardener	150.2	225.2	300.3	450.5	600.6	744.8	901	1201.3
	DT1855 Compliant Reducer Slow	173	259.4	345.9	518.9	691.8	857.8	1037.7	1383.6
G6	ECS61 White	32.7	49.1	65.5	98.2	131.0	163.7	196.4	261.9
	ECS67 Black	115.8	173.7	231.6	347.5	463.3	579.1	694.9	926.6
	EH391 Undercoat Hardener	149.5	224.2	299	448.5	597.9	741.5	896.9	1195.9
	DT1855 Compliant Reducer Slow	172.3	258.4	344.5	516.8	689.1	854.5	1033.6	1378.2

Technical Data		
	ECS6x : EH391 : DT1855	**ECS6x : EH391 : DT1855 + SLV814**
RTS Combinations	3 : 1 : 1	3 : 1 : 1 +10%
Applicable Use Category	Primer Sealer	Primer Sealer
VOC Actual (g/L)	173-180	161-168
VOC Actual (lbs./ US gal.)	1.44-1.50	1.34-1.40
VOC Regulatory (g/L) (less water less exempt)	319-325	307-312
VOC Regulatory (lbs./ US gal.) (less water less exempt)	2.66-2.71	2.56-2.60
Density (g/L)	1330-1401	1322-1385
Density (lbs./ US gal.)	11.10-11.69	11.03-11.56
Volatiles wt. %	53.4-55.3	55.1-56.7
Water wt. %	0.1-0.2	0.1-0.2
Exempt wt. %	39.8-42.8	42.3-44.9
Water vol. %	0.1-0.2	0.1-0.2
Exempt vol. %	44.4-45.6	46.2-47.2

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.
- Store waterborne and solvent borne waste separately. A competent agent with appropriate certification must handle all waterborne wastes. Wastes must be disposed in accordance with all Federal, State, Provincial and local laws and regulations.
- 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

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