

Product Information

ECP11 White, ECP15 Gray, ECP17 Black A-Chromatic Surfacer

Product Description

A-Chromatic Surfacers ECP11 White, ECP15 Gray, and ECP17 Black are premium quality, low VOC primer surfacers specifically designed for use under ENVIROBASE® High Performance (EHP™) waterborne basecoat.

A-Chromatic Surfacers offer excellent adhesion, film build, surface leveling and gloss holdout over a wide range of substrates. A variety of A-Chromatic grays can be achieved by inter mixing the white, gray and black surfacers. This versatile, quick drying, easy to apply and sand primer may be applied as a conventional spray filler or primer surfacer. A-Chromatic surfacers may also be accelerated for faster air dry process as needed.

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 P280 / US 240 grit discs (dry) or European P360 / US320 grade paper (wet). Exposed bare metal should be spot-primed with a suitable bare metal primer (see below).



Electrodeposition Primer must be thoroughly cleaned as outlined above. When using A-chromatic Surfacer as a spray filler or primer surfacer, abrade the electrodeposition primer as recommended in the “original paintwork” section.

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 and primed with SX1071 *OneChoice* Etch Primer after sanding.

Polyester Body Fillers should be dry sanded with European P180 / US 180 followed by 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

When mixed as:

Spray Filler

ECP1x Surfacer: 4 Vols
EH39x Hardener: 1 Vol

Primer Surfacer

ECP1x Surfacer: 4 Vols
EH391/392 Hardener: 1 Vol
D87xx/DT18xx Thinner: 1 Vol

Accelerated Primer Surfacer

ECP1x Surfacer: 4 Vols
EH391/392 Hardener: 1 Vol
D87xx/DT18xx Thinner: 1 Vol
SL93LV Accelerator: +10%

Accelerated Primer Surfacer Mix Ratio by Cumulative Weight in Parts (Grams) 4 : 1 : 1 +10%

Volume	4 oz. / ¼ pint	8 oz. / ½ pint	16 oz. / pint	32 oz. / quart
ECP1x	132 (117)	264 (234)	528 (468)	1055 (936)
EH391/EH392	157 (140)	315 (279)	630 (558)	1258 (1116)
D8764 or DT1845	179 (159)	358 (317)	716 (634)	1430 (1269)
SL93LV	195 (173)	390 (346)	781 (692)	1560 (1384)

Note: Use fast hardener and thinner only. Additional volumes may be found on PAINTMANAGER® program software.

NR 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)

2.1 Thinner Selection

D8764: Fast Compliant Thinner
D8774: Medium Compliant Thinner
D8767: Slow Compliant Thinner
DT1845: Cool Temperature 18-25°C (65-77°F)
DT1850: Medium Temperature 25-35°C (77-95°F)
DT1855: Hot Temperature over 35°C (95°C)

Hardener Selection

EH391: Standard Undercoat Hardener
EH392: Slow Undercoat Hardener

Pot Life



When sprayed as a ...

Spray Filler
Primer Surfacer
Accelerated Primer Surfacer

30 minutes at 70°F (21°C)
1 hour at 70°F (21°C)
30 minutes at 70°F (21°C)

Additives



Flexible Parts

Ready to Spray
Universal Flexibilizer

ECP1x: 10 Vols
SLV814 1 Vol

Spray gun setup



When Sprayed as a ...

4:1 Spray Filler 1.7-2.0 mm or equivalent
4:1:1 Primer Surfacer 1.6-1.8 mm or equivalent
4:1:1+10% Accelerated Primer Surfacer 1.6-1.8 mm or equivalent

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

As a:

Spray Filler

Primer Surfacer

Accelerated Primer Surfacer



Apply: Max of 4 wet coats
Film build per wet coat 5.0 mils
Dried film build per coat 2.0 mils

2-3 wet coats
3.0 mils
1.0 mils

2-3 wet coats
3.0 mils
1.0 mils

Flash Off 70°F (21°C)



As a:

Spray Filler

Primer Surfacer

Accelerated Primer Surfacer

Between Coats 5-10 minutes
Force Dry N/A

5-10 minutes
10 minutes

0 minutes
N/A

APPLICATION GUIDE (cont'd):

Drying Times	As a:	<u>Spray Filler</u>	<u>Primer Surfacer</u>	<u>Accelerated Primer Surfacer</u>
	Dust-free 70°F (21°C)	15 minutes	15 minutes	5 minutes
	Dry to Handle 70°F (21°C)	60 minutes	60 minutes	10 minutes
	Dry to Sand Air Dry 70°F (21°C) Force Dry 140°F (60°C)*	6 hours Do Not Force Dry	1½ Hours 30 minutes	20-30 minutes N/A
	Tape Time Air Dry 70°F (21°C) Force Dry 140°F (60°C)*	N/A N/A	N/A N/A	20-30 minutes N/A
	IR (Infrared) Medium Wave Short Wave	Do Not Force Dry	20 minutes 10 minutes	N/A N/A

*Force dry times are quoted for metal temperature. Additional time should be allowed in the force-drying schedule to allow metal to reach recommended temperature.

Overcoat/Recoat	As a:	<u>Spray Filler</u>	<u>Primer Surfacer</u>	<u>Accelerated Surfacer</u>
	Dry to Topcoat 70°F (21°C) sanding 140°F (60°C)	6 hours after sanding	1½ hours after sanding	30 minutes after
	Grade wet	N/A	30 minutes after sanding	N/A
	Grade dry	European P600 / US 400 followed by European P1200 / US 600 European P360 / US 320 followed by European P1000 / US 500		
	Overcoat with	<i>Envirobase High Performance Basecoat</i>		

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.

When using A-Chromatic Surfacer in a spot repair, adopt the following procedures:

- Thoroughly sand the surface to the edge of the panel or to a distance several centimeters beyond the damaged area, whichever is smaller.
- After applying the material and allowing it to dry as recommended, be careful to thoroughly level the repair edge when sanding.
- Do not attempt spot repair on original or refinish thermoplastic applications, lacquer or 1K finishes.

Also, A-Chromatic Surfacers and its ancillaries are sensitive to moisture, so all equipment must be perfectly dry. Partially used cans of hardener must be carefully closed.

Technical Data

	4:1 Spray Filler	4:1:1 Primer Surfacer	4:1:1+10% Accelerated Primer/
Surfacer			
Total Dry Film Build:			
Minimum after sanding	50µ / 2.0 mils	50µ / 2.0 mils	50µ / 2.0 mils
Maximum after sanding	250µ / 10.0 mils	150µ / 6.0 mils	150µ / 6.0 mils
Film build per wet coat	125µ / 5.0 mils	100µ / 4.0 mils	100µ / 4.0 mils
Dried film build per coat	50µ / 2.0 mils	37µ / 1.5 mils	37µ / 1.5 mils

Technical Data (Cont'd)

2.1	Primer Filler	Primer Surfacer	Accelerated Primer Surfacer	Flexible Primer Surfacer
	ECP1x : EH391/EH392	ECP1x : EH391/EH392 : D87xx/DT18xx	ECP1x : EH391/ EH392 : D8764/DT1845 + SL93LV	ECP1x : EH391/EH392 : D87xx/DT18xx + SLV814
RTS Combinations	4 : 1	4 : 1 : 1	4 : 1 : 1+10%	4 : 1 : 1+10%
Applicable Use Category	Primer	Primer	Primer	Primer (Specialty)
VOC Actual (g/L)	137-143	115-119	104-108	108-111
VOC Actual (lbs./ US gal.)	1.14-1.19	0.96-0.99	0.87-0.90	0.90-0.93
VOC Regulatory (g/L) (less water less exempt)	242-252	240-250	241-250	232-242
VOC Regulatory (lbs./ US gal.) (less water less exempt)	2.01-2.10	2.0-2.09	2.01-2.09	1.94-2.02
Density (g/L)	1503-1554	1430-1520	1421-1502	1412-1492
Density (lbs./ US gal.)	12.54-12.97	11.93-12.68	11.86-12.54	11.78-12.45
Volatiles wt. %	46.0-48.2	53.9-54.6	57.6-58.4	55.4-56.1
Water wt. %	0.0	0.0	0.0	0.0
Exempt wt. %	37.1-38.7	46.3-46.4	50.6-50.8	48.1-48.2
Water vol. %	0.0	0.0	0.0	0.0
Exempt vol. %	43.1-43.4	52.6-52.7	56.7-56.8	53.6-53.7
Solids vol.%	40.1-40.8	33.4-34.0	30.5-31.0	33.2-33.7
Solids wt.%	51.8-54.0	45.4-46.1	41.6-42.4	43.9-44.6
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	649	540	493	537
NR	Primer Filler	Primer Surfacer	Accelerated Primer Surfacer	Flexible Primer Surfacer
	ECP1x : EH392	ECP1x : EH391/EH392 : D87x/DT8xx	ECP1x : EH391/ EH392 : D87x/DT8xx + SL93LV	ECP1x : EH391/EH392 : D87x/DT8xx + SLV814
RTS Combinations	4 : 1	4 : 1 : 1	4 : 1 : 1+10%	4 : 1 : 1+10%
Applicable Use Category	Primer	Primer	Primer	Primer (Specialty)
VOC Actual (g/L)	137-143	186-260	169-236	173-241
VOC Actual (lbs./ US gal.)	1.14-1.19	1.55-2.17	1.41-1.97	1.44-2.01
VOC Regulatory (g/L) (less water less exempt)	242-252	328-408	327-406	316-392
VOC Regulatory (lbs./ US gal.) (less water less exempt)	2.01-2.10	2.74-3.40	2.73-3.39	2.64-3.27
Density (g/L)	1503-1554	1384-1437	1380-1427	1370-1418
Density (lbs./ US gal.)	12.54-12.97	11.55-11.99	11.51-11.91	11.43-11.83
Volatiles wt. %	46.0-48.2	51.0-53.4	55.1-57.4	52.7-55.1
Water wt. %	0.0	0.0	0.0	0.0
Exempt wt. %	37.1-38.7	33.5-39.4	39.0-44.6	36.3-41.9
Water vol. %	0.0	0.0	0.0	0.0
Exempt vol. %	43.1-43.4	35.9-43.7	41.6-48.7	38.4-45.6
Solids vol.%	40.1-40.8	33.4-34.0	30.5-31.0	33.2-33.7
Solids wt.%	51.8-54.0	46.6-49.0	42.6-44.9	44.9-47.3
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	649	540	493	537

A-Chromatic Gray Mixing Chart

A-Chromatic Surfacer

This chart can be used to mix the A-Chromatic Surfacer.
The G1-G7 ratios will help to achieve better hiding when used as a guide for mixing the A-Chromatic Surfacer.

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	ECP11	4	126	252	508	1025	142	258	574	1158
	EH391	1	151	301	607	1224	171	340	686	1383
	D87xx/DT18xx	1	177	354	713	1437	200	400	806	1624
G3	ECP11	3	94	189	381	769	106	213	430	869
	ECP15	1	126	252	509	1026	142	285	575	1159
	EH391	1	150	301	607	1225	169	340	686	1384
	D87xx/DT18xx	1	177	354	713	1439	200	400	806	1626
G5	ECP15	4	127	253	511	1030	143	286	577	1164
	EH391	1	151	302	609	1229	171	341	688	1389
	D87xx/DT18xx	1	177	355	715	1442	200	401	808	1629
G6	ECP15	Mix By Weight Only	81	162	327	658	91	183	369	743
	ECP17		123	247	498	1001	139	279	563	1131
	EH391		148	296	597	1199	167	334	675	1355
	D87xx/DT18xx		174	348	703	1413	197	393	794	1597
G7	ECP17	4	122	243	491	990	138	275	555	1119
	EH391	1	146	292	590	1189	165	330	667	1343
	D87xx/DT18xx	1	173	345	696	1402	195	390	786	1584

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

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.



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