



# PDS N4.13C NR

## October 2018

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

*For National Rule Markets*

#### 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
P850-1692/-1693/-1694/-1695	Thinners
P100-2020	Flexible Additive
SL814	Universal Flexibilizer

**THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY**

# HS Plus Wet-on-Wet Sealers

## NATIONAL RULE PROCESS

<b>MIX RATIO</b> 	<b>P565-312x Wet-on-Wet Sealer</b> <b>P210-547x Hardener</b> <b>P850-169x Thinner</b>	3 parts 1 part 1 part
<b>POTLIFE</b> 	<b>Sprayable Pot Life:</b> Pot Life: Viscosity:	1 hour at 70°F (21°C) 15 - 17 seconds DIN4 at 70°F (21°C)
<b>SPRAYGUN &amp; AIR PRESSURE</b> 	<b>Fluid Tip:</b> <b>HVLP:</b> <b>Compliant:</b>	1.4 - 1.6 mm 10 PSI cap pressure 29 - 40 PSI at the gun*
<b>APPLICATION</b> 	<b>Apply:</b>  <b>Note:</b> Film build will depend on fluid tip selection	1 - 2 coats (approximately 1.0 - 2.0 mils)
<b>FLASH TIME</b> 	<b>Between coats:</b>	5 - 10 minutes
<b>DRY TIMES</b>  	<b>Air Dry:</b> 1 coat: 2 coats:  <b>Infrared:</b> Short Wave:	15 minutes at 70°F (21°C) 30 minutes at 70°F (21°C)  8 - 12 minutes after 5 minutes flash
<b>TOPCOAT</b> 	<b>Time to topcoat:</b> 1 coat: 2 coats:	15 minutes at 70°F (21°C) 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

## 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
P850-1692	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

P565-312x	HS Plus Wet on Wet Sealer	5 parts
P100-2020/SL814	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 P100-2020 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	104	207	417	834
	P210-547x	1	134	266	535	1070
	P850-169x	1	153	305	612	1224
SG03	P565-3121 (70%)	3	69	138	278	556
	P565-3125 (30%)		103	206	415	831
	P210-547x	1	132	265	533	1068
SG05	P565-3125 (70%)	3	102	204	412	824
	P210-547x	1	131	263	530	1060
	P850-169x	1	150	302	607	1214
SG06	P565-3125 (70%)	3	68	136	275	555
	P565-3127 (30%)		102	204	411	822
	P210-547x	1	131	263	529	1058
SG07	P565-3127 (30%)	1	150	302	606	1212
	P210-547x	3	101	203	409	818
	P850-169x	1	130	262	527	1054
		1	149	301	604	1208

**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 : P850-169x	Flexible System: (Premix P565-312x : P100-2020 at 5 : 1) P565-312x/P100-2020 : P210- 547x : P850-169x
Volume Ratio	3 : 1 : 1	3 : 1 : 1
Applicable Use Category	Primer Sealer	Specialty Coating / Flexed Primer Sealer
VOC Actual (g/L)	334-345	346-376
VOC Actual (lbs./Gal)	2.79-2.88	2.89-3.14
VOC Regulatory (g/L) (less water, less exempts)	445-461	448-489
VOC Regulatory (lbs./Gal) (less water, less exempts)	3.71-3.85	3.74-4.08
Solids vol. %	34.4-35.9	33.0-36.7
Solids wt. %	47.8-49.2	45.3-48.7

### 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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