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# Product Information

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## ECS61 White, ECS65 Gray, ECS67 Black A-Chromatic Sealer

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### Product Description

A-Chromatic Sealer ECS61 White, ECS65 Gray and ECS67 Black are premium quality, wet on wet sealers designed specifically for use under ENVIROBASE® High Performance Waterborne Basecoat.

The fast drying A-Chromatic Sealers have superior flow properties and excellent topcoat holdout. A variety of A-Chromatic grays can be achieved by intermixing of the three packaged sealers. 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.

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### 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 an 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.

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**APPLICATION GUIDE:**

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**Mixing Ratio**

**ECS6x Sealer:** 3 Vols.  
**EH391 Hardener:** 1 Vol.  
**D87xx/DT18xx Thinner:** 1 Vol.

**Thinner Selection**

D8764: Fast Compliant Thinner  
D8774: Medium Compliant Thinner  
D8767: Slow Compliant Thinner  
DT1845: Normal Compliant Thinner  
DT1850: Medium Compliant Thinner  
DT1855: Slow Compliant Thinner

**Hardener Selection**

EH391: Standard Undercoat Hardener

**Pot Life**

1 hour at 70°F (21°C)

**Additives**

**Ready-to-Spray ECS6X Sealer:** 10 Vols.  
**SLV814 Universal Flexibilizer:** 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

**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)  
Medium Wave: 10 minutes  
Short Wave: 5 minutes

## APPLICATION GUIDE (cont'd):

### 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  
Grade dry

P1000 / US 500 grade paper

P1000 / US 500 grade paper

### 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

	<b>ECS6x : EH391: D87xx/DT18xx</b>	<b>ECS6x : EH391: D87xx/DT18xx + SLV814</b>
<b>RTS Combinations</b>	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

**AChromatic Gray Mixing Chart****AChromatic Sealer**

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

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	ECS61	3	104	207	417	834	117	234	471	942
	EH391	1	134	266	535	1070	151	300	604	1209
	D87xx/DT18xx	1	166	329	662	1324	187	372	748	1496
G3	ECS61	2	69	138	278	556	78	156	314	628
	ECS65	1	103	206	415	831	116	233	469	939
	EH391	1	132	265	533	1068	149	299	602	1207
	D87xx/DT18xx	1	163	328	660	1322	184	371	746	1494
G5	ECS65	3	102	204	412	824	115	230	465	931
	EH391	1	131	263	530	1060	148	297	599	1198
	D87xx/DT18xx	1	162	326	657	1314	183	368	742	1484
G6	ECS65	2	68	136	275	555	77	154	311	627
	ECS67	1	102	204	411	822	115	230	464	929
	EH391	1	131	263	529	1058	148	297	598	1196
	D87xx/DT18xx	1	162	326	656	1312	183	368	741	1482
G7	ECS67	3	101	203	409	818	114	229	462	924
	EH391	1	130	262	527	1054	147	296	595	1191
	D87xx/DT18xx	1	161	325	654	1308	182	367	739	1478

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## HEALTH AND SAFETY

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See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

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- 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 MSDS 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 MSDS 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 MSDS.
  - Always observe all applicable precautions and follow good safety and hygiene practices.
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### Emergency Medical or Spill Control Information: (412) 434-4515; In Canada (514) 645-1320

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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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PPG Automotive Refinish  
19699 Progress Drive  
Strongsville, OH 44149  
800.647.6050

PPG Canada Inc.  
2301 Royal Windsor Drive, Unit #6  
Mississauga, Ontario L5J 1K5  
888.310.4762

Follow us online:  

[www.ppgrefinish.com](http://www.ppgrefinish.com)

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