

Product Information

EC550 En-V® Ultra Gloss Clearcoat

Product Description

The EC550 is a high gloss overall clearcoat designed specifically for use with ENVIROBASE® High Performance Waterborne Basecoat. EC550 has outstanding appearance and gloss retention and is ideal for high temperature and/or large job application. This premium clearcoat continues the easy to apply characteristics of the *En-V* clearcoat platform and provides a robust application window under extreme conditions.

Preparation of Substrate



- Wash all surfaces to be painted with soap and water, then apply the appropriate ONECHOICE®, GLOBAL REFINISH SYSTEM™ or DELTRON® cleaner. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.



- Wet sand with US 500-600 / European P800-P1200 grade paper or dry sanding with US 400-500 / European P600-P800 grade paper.



- Wash off residue and dry thoroughly before re-cleaning with appropriate *OneChoice*, *Global Refinish System* or *Deltron* substrate cleaner. The use of a SX1070 *OneChoice* tack rag is recommended.

APPLICATION GUIDE:

Mixing Ratio for EC550



EC550: 3 parts
ECH5075: 1 part
ECRxx: 1 part



Usable Pot Life at 70°F (21°C): 2 hours

Hardener:

ECH5075 Standard Hardener

Reducer:

ECR65 Low Temp Reducer 65-75°F (18-24°C)
ECR75 Mid Temp Reducer 70-80°F (21-26°C)
ECR85 High Temp Reducer 80-95°F (27-35°C)
ECR98 Hot and Humid Ultra High Temp Reducer 90°F (32°C) and above

See reducer selection guide on page 4 for additional information

Optional Additives:

SLV814 Universal Flexibilizer: add 10% to RTS volume
SLV73 Fisheye Eliminator: add 1 oz. to RTS quart
SLV898 Low VOC Retarder: add 5% to RTS quart
EA10 Compliant Accelerator add 5% to RTS quart

When EC550 is used on plastic parts, the addition of SLV814 Universal Flexibilizer is recommended, not required.

Spraygun Set-up and Pressure:

Fluid Tip: 1.3-1.5 mm
Spray Viscosity: 15 secs DIN4 at 70°F (21°C)
HVLP: 10 maximum psi at the cap
Compliant: Refer to spray gun manufacturer recommendations

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

Application:

Apply: 2 medium wet coats

Film Build:

Minimum Dry Film Build: 2.0 mils
Maximum Dry Film Build: 3.5 mils
Recommended film build per coat wet: 2.0-2.5 mils
Recommended film build per coat dry: 1.0-1.5 mils

Drying Times:

Flash: 10-15 minutes between coats
70°F (21°C)

Dust-free: 100-120 minutes
70°F (21°C)



Air Dry to Re-assemble*: Overnight
70°F (21°C)



Purge Time: 10-15 minutes
Force Dry:* 35 minutes
140°F (60°C)

Tape Time: Overnight
70°F (21°C)

IR (Infrared): N/A

*For in-service delivery at low temperatures (below 60°F/16°C) or inclement weather conditions, bake for 35 minutes at 140°F/60°C metal temperature and cool for one hour prior to putting into service.

Overcoat / Recoat / Polishing:



Overcoat/Recoat Time: After force dry for 35 minutes at 140°F (60°C) metal temperature and cool down for one hour. EC550 must be sanded before recoating with primer, color or clear.



After 4 hours: US 1000 (European P2000) damp, 1500 (European P2500) wet, 3000 Trizac™
After 24 hours: US 1000 (European P2000) dry, 1500 (European P2500) damp, 3000 Trizac™



Overcoat with: *Envirobase* High Performance primer, color or clear

Polishing: Polishing is not normally required. However, to remove minor dirt nibs, sand with P1500 or finer and follow normal polishing procedures. After force dry and cool down cycle.

Performance Guidelines:

Allow basecoat to thoroughly dry before applying EC550 *En-V* Ultra Gloss Clearcoat. If allowed to dry longer than 24 hours, additional basecoat must be applied before clearcoating. The timing will depend on film thickness, temperature and humidity.

Fading Out EC550

Use *OneChoice* SLV840 or SXA840 Uniform Finish Blender to apply from the outside of the repair and moving towards the center of the repaired area to lose the clearcoat blend edge.

Technical Data:

RTS Combinations	EC550 : ECH5075 : ECRxx	EC550 : ECH5075 : ECRxx + EA10	EC550 : ECH5075 : ECRxx + SLV898	EC550 : ECH5075 : ECRxx + SLV814
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating	Clear Coating (Flexed)
Volume Ratio:	3 : 1 : 1	3: 1 : 1 +5%	3 : 1 : 1 +5%	3 : 1 : 1 +10%
VOC Actual (g/L)	137-140	134-137	131-133	128-131
VOC Actual (lbs./ US gal.)	1.14-1.17	1.12-1.14	1.09-1.11	1.07-1.09
VOC Regulatory (less water, less exempt (g/L)	236-241	234-238	236-241	230-234
VOC Regulatory (less water, less exempt (lbs./ US gal.)	1.97-2.01	1.95-1.99	1.97-2.01	1.92-1.95
Density (g/L)	1148-1153	1146-1150	1158-1161	1155-1159
Density (lbs./ US gal)	9.58-9.62	9.56-9.60	9.66-9.69	9.64-9.67
Volatiles wt. %	59.1-59.3	59.4-59.6	61.3-61.5	60.5-60.7
Water wt. %	0.0	0.0	0.0	0.0
Exempt wt. %	47.0-47.2	47.5-47.7	49.8-50.1	49.2-49.4
Water vol. %	0.0	0.0	0.0	0.0
Exempt vol. %	41.9-42.2	42.6-42.9	44.6-44.9	43.9-44.2
Solids vol. %	41.8	41.5	40.0	41.0
Solids wt. %	40.7-40.9	40.4-40.6	38.5-38.7	39.3-39.5
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	670	666	642	658

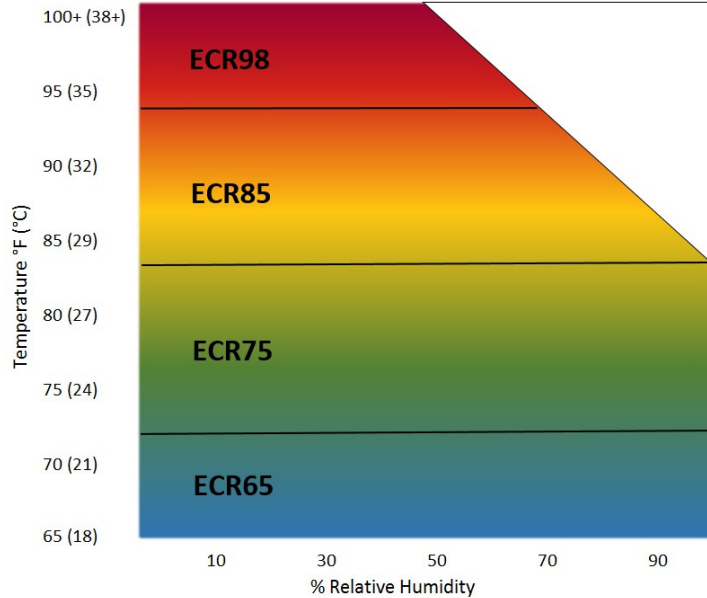
EC550 En-V Ultra Gloss Clearcoat Reducer Selection Guide

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Higher Air Movement
Temperature and Humidity
(Larger)

Average Air Flow & Humidity
12,000-24,000 CFM - 30%-90% RH

Lower Air Movement
Temperature and Humidity
(Smaller)



Temperature, Air Flow, Humidity and Size of the Repair will affect Reducer selection

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.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- 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.
- 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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