



PDS N4.14C
December 2009

P565-3141 White, 3145 Grey & 3147 Black

HS Plus Wet-on-Wet Sealer LV

PRODUCT DESCRIPTION

HS Plus Wet-on-Wet Sealers LV are acrylic urethane wet on wet 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 Sealer LV are available in white, grey and dark grey and are used to achieve the full range of Spectral Grey shades SG01 through SG07. Each basecoat formula references a specific SG undercoat color. Using Spectral Grey undercoats can reduce the amount of colored topcoat required.

- Fast dry = reduced process time
- Spectral Grey System = reduced color coats
- Excellent holdout = less rework
- Meets VOC compliance

Designed for Use With

Aquabase
PLUS

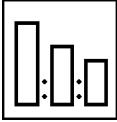
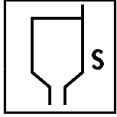


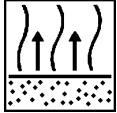


HS PLUS WET-ON-WET SEALER LV

PRODUCTS

<i>P565-3141</i>	<i>HS Plus Wet-on-Wet Sealer - White</i>
<i>P565-3145</i>	<i>HS Plus Wet-on-Wet Sealer - Grey</i>
<i>P565-3147</i>	<i>HS Plus Wet-on-Wet Sealer - Black</i>
<i>P210-5475</i>	<i>Wet-on-Wet Sealer Hardener</i>
<i>P850-1775</i>	<i>HS Plus Mid Temperature Reducer</i>

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

<p>MIX RATIO</p> 	<p align="center">HS PLUS WET- ON - WET SEALER LV</p> <table border="0" style="margin-left: auto; margin-right: auto;"> <tr> <td>P565-314X</td> <td align="right">4</td> </tr> <tr> <td>P210-5475</td> <td align="right">1</td> </tr> <tr> <td>P850-1775</td> <td align="right">1</td> </tr> </table> <p>Note: Only P210-5475 hardener can be used in HS Plus Wet-on-Wet Sealer P565-314X.</p>	P565-314X	4	P210-5475	1	P850-1775	1
P565-314X	4						
P210-5475	1						
P850-1775	1						
<p>VISCOSITY & POTLIFE</p> 	<p align="center">Viscosity: 17-20 seconds Din #4 @ 70°F (21°C)</p> <p align="center">Pot Life: 60 minutes at 70°F (21°C)</p>						
<p>SPRAYGUN & AIR PRESSURE</p> 	<p align="center">HVLP: 1.4 -1.6mm Max 10 psi cap press. 3-8 fluid pressure (pressurized cup)</p> <p align="center">(HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)</p>						
<p>APPLICATION</p> 	<p align="center">1 - 2 medium coats (approx. 1.0-2.0 mils)</p> <p align="center">Note: Film build will depend on fluid tip selection.</p>						
<p>FLASH TIME</p> 	<p align="center">5 -10 minutes between coats</p>						
<p>DRY TIMES</p> 	<p align="center">Air-dry times at 70°F (21°C) 15 - 30 minutes</p> <p align="center">1 coat : 15 minutes @ 70°F / 21°C 2 coats : 30 minutes @ 70°F / 21°C</p> <p align="center">Infra-Red (short wave) 8-12 minutes after 5 minute flash</p>						
<p>TOPCOAT</p> 	<p align="center">1 coat : 15 minutes @ 70°F / 21°C 2 coats : 30 minutes @ 70°F / 21°C</p>						

HS PLUS WET-ON-WET SEALER LV

SPECTRAL GREYS

MIX RATIO BY VOLUME			MIX RATIO BY WEIGHT Cumulative Weight in Grams			
		Ratio	¼ Pint	½ Pint	Pint	Quart
SG01 Sealer	P565-3141	4	118	236	473	945
	P210-5475	1	143	286	572	1144
	P850-1775	1	167	334	667	1334
SG02 Sealer	P565-3141	Mix By Weight Only	110	220	440	880
	P565-3145		116	232	464	928
	P210-5475		141	282	564	1128
	P850-1775		167	334	668	1336
SG03 Sealer	P565-3141	3	89	177	354	709
	P565-3145	1	118	236	472	946
	P210-5475	1	143	286	572	1143
	P850-1775	1	167	333	667	1333
SG04 Sealer	P565-3141	2	59	118	236	473
	P565-3145	2	118	236	472	944
	P210-5475	1	143	286	571	1142
	P850-1775	1	167	333	666	1333
SG05 Sealer	P565-3145	4	118	236	471	942
	P210-5475	1	143	285	570	1141
	P850-1775	1	166	333	666	1331
SG06 Sealer	P565-3145	3	88	177	353	707
	P565-3147	1	118	235	470	940
	P210-5475	1	142	285	569	1139
	P850-1775	1	166	332	665	1329
SG07 Sealer	P565-3147	4	117	233	467	934
	P210-5475	1	142	283	566	1132
	P850-1775	1	165	331	661	1322

PLASTICS USAGE

		Flexible	Very Flexible
P565-314X	HS Plus Wet on Wet Sealer LV	5	2
P100-2021	Flexible Additive for Plastics	1	1

Note: This mixture should then be activated and thinned as normal, 4:1:1.

HS PLUS WET-ON-WET SEALER LV

SUBSTRATES

HS Plus Wet-on-Wet Sealer LV can be applied over:

Factory primer, GRP/Fiberglass, existing finishes in good condition, polyester putties and bare steel, after degreasing and machine sanding with P320-P400 grit dry.

E-Coat - After proper cleaning and degreasing, HS Plus Wet-on-Wet Sealer LV 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 wet-on-wet sealer over bare steel or aluminum, a Nexa Autocolor Etch Primer must first be applied.

Plastics - When using HS Plus Wet-on-Wet Sealer LV on plastics, they must be flexed at a 5:1 (20%) ratio with P100-2021 Flexible Additive prior to activating and thinning.

RECOATABILITY

HS Plus Wet-on-Wet Sealer LV can be directly top coated with Aquabase Plus Waterborne Basecoat after:

1 coat : 15 minutes @ 70°F / 21 °C

2 coats : 30 minutes @ 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.

HS PLUS WET-ON-WET SEALER LV

EQUIPMENT CLEANING

Approved Cleaning Solvent

PERFORMANCE SPECIFICATIONS

	Standard System P565-314X : P210-5475 : P850-1775	Flexible System (Premix P565-314X : P100-2021 at 5 : 1 ratio :) P565-314X : P210-5475 : P850-1775	Very Flexible System (Premix P565-314X : P100-2021 at 2 : 1 ratio :) P565-314X : P210-5475 : P850-1775
RTS Combinations:			
Volume Ratio:	4 : 1 : 1	4 : 1 : 1	4 : 1 : 1
Applicable Use Category	Primer-Sealer	Primer-Sealer	Primer-Sealer
VOC Actual (g/L)	95	90	105
VOC Actual (lbs/gal)	0.80	0.75	0.87
VOC Regulatory (less water less exempt) (g/L)	218	210	236
VOC Regulatory (less water less exempt) (lbs/gal)	1.82	1.75	1.97
Density (g/L)	1372 - 1431	1359 - 1412	1352 - 1405
Density (lbs/gal)	11.45 - 11.94	11.34 - 11.78	11.28 - 11.72
Volatiles wt. %	57.4 - 59.4	58.7 - 60.5	58.6 - 60.4
Water wt. %	0.0	0.0	0.0
Exempt wt. %	50.5 - 52.7	52.1 - 54.1	51.0 - 52.9
Water vol. %	0.0	0.0	0.0
Exempt vol. %	56.6	57.3	55.8

For further information please contact:

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