

# 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 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  
EH391 Hardener: 1 Vol

#### Primer Surfacer

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

#### Accelerated Primer Surfacer

ECP1x Surfacer: 4 Vols  
EH391 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
<b>ECP1x</b>	132 (117)	264 (234)	528 (468)	1055 (936)
<b>EH391</b>	157 (140)	315 (279)	630 (558)	1258 (1116)
<b>D8764 or DT1845</b>	179 (159)	358 (317)	716 (634)	1430 (1269)
<b>SL93LV</b>	195 (173)	390 (346)	781 (692)	1560 (1384)

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

### Thinner Selection

D8764 Fast Thinner  
D8774 Medium Thinner  
D8767 Slow Thinner

DT1845 Cool Temperature  
DT1850 Medium Temperature  
DT1855 Hot Temperature

### 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

### Spraygun set up



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:  
Film build per wet coat  
Dried film build per coat

Max of 4 wet coats  
5.0 mils  
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  
Force Dry

5-10 minutes  
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 Primer Surfacer</u>
	Dry to Topcoat 70°F (21°C) 140°F (60°C)	6 hours after sanding N/A	1½ hours after sanding 30 minutes after sanding	30 minutes after sanding N/A
	Grade wet 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</i> High Performance Basecoat		

## 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
% solids by volume RTS	40.55	33.79	33.79
Theoretical coverage*	Approx. 650 sq. ft.	Approx. 542 sq. ft.	Approx. 542 sq. ft.

\*Theoretical coverage in sq. ft./ US gallon ready-to-spray (RTS), 1.0 mil dry film thickness

**Technical Data (Cont'd)**

	Primer Filler	Primer Surfacer	Accelerated Primer Surfacer	Flexible Primer Surfacer
	<b>ECP1x : EH391</b>	<b>ECP1x : EH391 : D87xx/DT18xx</b>	<b>ECP1x : EH391 : D8764/DT1845 + SL93LV</b>	<b>ECP1x : EH391 : D87xx/DT18xx + SLV814</b>
<b>RTS Combinations</b>	4 : 1	4 : 1 : 1	4 : 1 : 1+10%	4 : 1 : 1+10%
Applicable Use Category	Primer	Primer	Primer	Primer
VOC Actual (g/L)	137-142	114-119	102-108	108-111
VOC Actual (lbs./ US gal.)	1.15-1.19	0.96-0.99	0.85-0.90	0.89-0.92
VOC Regulatory (g/L) (less water less exempt)	240-249	240-249	237-249	230-240
VOC Regulatory (lbs./ US gal.) (less water less exempt)	2.0-2.08	2.0-2.08	1.97-2.08	1.92-2.00
Density (g/L)	1505-1556	1455-1497	1424-1466	1414-1493
Density (lbs./ US gal.)	12.56-12.98	12.14-12.49	11.88-12.23	11.80-12.46
Volatiles wt. %	45.9-48.1	53.2-55.2	56.3-59.5	54.0-57.3
Water wt. %	0.0	0.0	0.0-0.2	0.0
Exempt wt. %	37.1-38.6	45.6-47.1	46.4	46.7-49.6
Water vol. %	0.0	0.0	0.0-0.2	0.0
Exempt vol. %	43.0-43.3	52.5-52.8	49.2-52.1	53.6-53.8

## AChromatic Gray Mixing Chart

## AChromatic 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							
Mix Ratio			Grams				Parts			
			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

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## HEALTH AND SAFETY

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See 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 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.

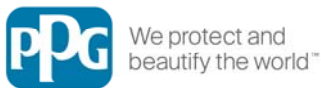
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### Emergency Medical or Spill Control Information: (412) 434-4515; In Canada (514) 645-1320

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