



PDS N4.13C
January 2007

P565-3121 White, 3125 Grey & 3127 Dark Grey

HS Plus Wet-on-Wet Sealers

PRODUCT DESCRIPTION

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 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

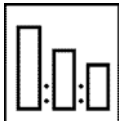
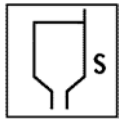


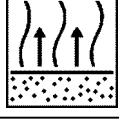
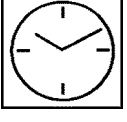

HS PLUS WET-ON-WET SEALERS

PRODUCTS

<i>P565-3121</i>	<i>HS Plus Wet-on-Wet Sealer - White</i>
<i>P565-3125</i>	<i>HS Plus Wet-on-Wet Sealer - Grey</i>
<i>P565-3127</i>	<i>HS Plus Wet-on-Wet Sealer - Dk. Grey</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

MIX RATIO	HS PLUS WET- ON- WET SEALERS						
	<table border="0"> <tr> <td>P565-312X</td> <td>3</td> </tr> <tr> <td>P210-5475</td> <td>1</td> </tr> <tr> <td>P850-1775</td> <td>1</td> </tr> </table> <p>Note: Only P210-5475 hardener can be used in HS Plus Wet-on-Wet Sealer P565-312X.</p>	P565-312X	3	P210-5475	1	P850-1775	1
P565-312X	3						
P210-5475	1						
P850-1775	1						
VISCOSITY & POTLIFE 	<p>Viscosity: 15-17 seconds Din #4 @ 70°F (21°C)</p> <p>Pot Life: 60 minutes at 70°F (21°C)</p>						
SPRAYGUN & AIR PRESSURE 	<p>HVLP: 1.4 -1.6mm Max 10 psi cap press. 3-8 fluid pressure (pressurized cup)</p> <p>(HVLP: Refer to gun manufacturer's recommendations for required inlet pressure.)</p>						
APPLICATION 	<p>1 - 2 coats (approx. 1.0-2.0 mils)</p> <p>Note: Film build will depend on fluid tip selection.</p>						
FLASH TIME 	<p>5 -10 minutes between coats</p>						
DRY TIMES 	<p>Air-dry times at 70°F (21°C) 15 - 30 minutes 1 coat : 15 minutes @ 70°F / 21°C 2 coats : 30 minutes @ 70°F / 21°C</p> <p>Infra-Red (short wave) 8-12 minutes after 5 minute flash</p>						
TOPCOAT 	<p>1 coat: 15 minutes @ 70°F / 21°C 2 coats : 30 minutes @ 70°F / 21°C</p>						

HS PLUS WET-ON-WET SEALERS

SPECTRAL GREYS

MIX RATIO BY VOLUME			MIX RATIO BY WEIGHT Cumulative Weight in Grams			
		Ratio	Quart	Pint	½ Pint	¼ Pint
SG01 Sealer	P565-3121	3	834	417	207	104
	P210-5475	1	1070	535	266	134
	P850-1775	1	1324	662	329	166
SG02 Sealer	P565-3121 (95%)	3	792	396	196	98
	P565-3125 (5%)		834	417	206	103
	P210-5475	1	1070	535	265	133
	P850-1775	1	1324	662	328	165
SG03 Sealer	P565-3121 (70%)	3	556	278	138	69
	P565-3125 (30%)		831	415	206	103
	P210-5475	1	1068	533	265	132
	P850-1775	1	1322	660	328	163
SG04 Sealer	P565-3121 (33%)	3	278	139	69	35
	P565-3125 (67%)		827	413	205	103
	P210-5475	1	1064	531	264	132
	P850-1775	1	1318	658	327	163
SG05 Sealer	P565-3125	3	824	412	204	102
	P210-5475	1	1060	530	263	131
	P850-1775	1	1314	657	326	162
SG06 Sealer	P565-3125 (70%)	3	555	275	136	68
	P565-3127 (30%)		822	411	204	102
	P210-5475	1	1058	529	263	131
	P850-1775	1	1312	656	326	162
SG07 Sealer	P565-3127	3	818	409	203	101
	P210-5475	1	1054	527	262	130
	P850-1775	1	1308	654	325	161

PLASTICS USAGE

		Flexible	Very Flexible
P565-312X	HS Plus Wet on Wet Sealer	5	2
P100-2020	Flexible Additive for Plastics	1	1

Note: This mixture should then be activated and thinned as normal, 3:1:1.
More detail on refinishing plastics can be found in PDS N7.1C.

HS PLUS WET-ON-WET SEALERS

SUBSTRATES

HS Plus Wet-on-Wet Sealers 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 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 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 Sealers on plastics, they must be flexed at a 5:1 (20%) ratio with P100-2020 Flexible Additive prior to activating and thinning.

RECOATABILITY

HS Plus Wet-on-Wet Sealer 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 SEALERS

EQUIPMENT CLEANING

Approved Cleaning Solvent

PERFORMANCE SPECIFICATIONS

RTS Combinations:	3121:5475:177	3125:5475:1775	3127:5475:1775
	5		
Applicable Use Category	Primer Sealer	Primer Sealer	Primer Sealer
Ratio:	3:1:1	3:1:1	3:1:1
Density (g/L)	1400	1388	1383
Density (lbs/gal)	11.68	11.58	11.54
VOC Actual (g/L)	179	183	185
VOC Actual (lbs/gal)	1.50	1.53	1.55
VOC Regulatory (g/L)	328	332	332
VOC Regulatory (lbs/gal)	2.74	2.77	2.77
Volatiles wt. %	55.4	55.8	55.5
Water wt. %	0.0	0.0	0.0
Exempt wt. %	42.5	42.6	42.1
Water vol. %	0.0	0.0	0.0
Exempt vol. %	45.3	44.9	44.3

For further information please contact:

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