

4:1 2K Sealer

Technical Data Sheet #55,65,75



Components

55 4:1 2K Sealer Black
65 4:1 2K Sealer Gray
75 4:1 2K Sealer White
605 4:1 2K Sealer Activator

Mix by Volume

- 4 Parts 55, 65, 75 4:1 2K Sealer
- 1 Part 605 4:1 2K Sealer Activator

Pot Life

- 1 hours @ 75°F (Note: Extremely warm temperatures will shorten pot life)
- Accelerator, reducer and temperature will affect pot life.

Shading

- 55, 65, 75 4:1 2K Sealers can be blended together to achieve various shades of the gray scale.
- No other tints or toners may be added. Do not mix with paint.
- See chart below for shading recommendations depending upon color family of the topcoat.



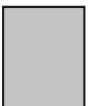




Equipment Setup

Gun Type	Fluid Tip	Air Pressure
HVLP Gravity	1.3–1.4mm	8–10 PSI at cap
High Efficiency	1.3–1.4mm	27–32 (PSI) Inlet Pressure

Note: These are starting points for spray gun recommendations. Refer to spray gun manufacturers recommendations for proper setup and operation. Additional adjustments may be necessary

Application

- 55, 65, 75 4:1 2K sealers are designed for spot, panel and overall repairs.
- Apply 1 single, even wet coat of properly mixed sealer to create a uniform base.
- If desired, apply a second coat after a 15-minute flash. Extend dry time in temperatures below 75°F before applying topcoats. Multiple coats will require a longer flash time.
- Apply topcoats within 12 hours of sealer application. After 12 hours, scuff using a gray scuff pad or P800–P1000 grit sandpaper. Re-clean and apply topcoat.
- Applying topcoat after 12 hours without properly scuffing the sealer may result in adhesion failure.

75	75 & 65 MIX 2:1	75 & 65 MIX 1:2	65	65 & 55 MIX 2:1	65 & 55 MIX 1:2	55
						
Light Colors VERY LT COLORS Light Yellows Whites Sivers	Pastel Green Med. Yellow Light Tan Med. Silver Pastel Blue	Green Dark Silver Med. Light Tan Med. Light Red Med. Light Blue	Med. Red Med. Brown Med. Green Med. Blue Med. Gray	Dark Red Dark Brown Dark Blue Dark Green Med. Dark Gray	Dark Green Dark Blue Dark Brown Dark Red Dark Gray	Deep Dk Red Deep Dk Brown Deep Dk Green Deep Dk Blue Black

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TIME TO SAND

- Sealer does not require sanding if topcoated within 12 hours.
- If necessary, Air Dry: 30–45 minutes at 75°F to remove debris.

Time to Topcoat

- 15–20 minutes at 75°F prior to topcoating for a single coat.

Performance Tips

- Shop and surface temperatures should be maintained at or above 75°F prior to work.
- Ensure proper metal conditioning and preparation procedures are followed.
- Follow proper flash times, dry times, sanding procedures, and all directions for topcoats.
- Ensure accurate measuring is followed during mixing.

Clean-up

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner.

Disposal

Dispose of all paint and paint related materials in accordance with state and local regulations.

Safety & Health

Read and follow all technical product information, labels, and SDS prior to application. Keep product out of reach of children and animals. Always wear proper safety equipment (respirator, gloves, eye, and clothing protection) when using this product.

Refer to all labels on products and information sheets for hazards and proper handling procedures for each component. Read the Safety Data Sheets (SDS) supplied with the materials.

KEEP OUT OF REACH OF CHILDREN