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# Product Information

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## ECP11 White, ECP15 Gray, ECP17 Black A-Chromatic Surfacer

### Product Description

A-Chromatic Surfacers ECP11 White, ECP15 Gray, 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 intermixing 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.

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### 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 / U.S. 240 grit discs (dry) or European P360 / U.S. 320 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 / U.S. 180 to European P280 / U.S. 240 grit paper and primed with SX1071 OneChoice Etch Primer after sanding.

Polyester Body Fillers should be dry sanded with European P180 / U.S. 180 followed by European P280 / U.S. 240 grit paper.



Fiber Glass and SMC should be dry sanded using European P280 / U.S. 240 grit paper.

Plastic should be dry sanded with European P600 / U.S. 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  
**Compliant Thinner :** 1 Vol

### Compliant Thinner Selection

D8764 : Fast Compliant Thinner  
 D8774 : Medium Compliant Thinner  
 D8767 : Slow Compliant Thinner

### Potlife



When sprayed as a...  
 Spray Filler  
 Primer Surfacer

30 minutes @ 70°F (21°C)  
 1 hour @ 70°F (21°C)

### Additives



SLV814  
 Universal  
 Flexibilizer

**Ready-to-spray ECP1X :** 10 Vols  
**SLV814 :** 1 Vol

### Spraygun set up



When Sprayed as a...  
 Spray Filler  
 Primer Surfacer

1.7 - 2.0 mm or equivalent  
 1.6 - 1.8 mm or equivalent

### Spray pressure

HVLP at air cap  
 Conventional at spray gun

0.7 bar / 10 PSI  
 3 bar / 45 PSI

### Number of coats



When Sprayed as a...

Apply  
 Film build per wet coat  
 Dried film build per coat

#### Spray Filler

Up to a maximum of 4 wet coats  
 5.0 mils  
 2.0 mils

#### Primer Surfacer

2 to 3 wet coats  
 4.0 mils  
 1.5 mils

### Flash off at 20°C / 68°F



Between coats  
 Before stoving

**Spray Filler**  
 5 - 10 minutes  
 N/A

**Primer Surfacer**  
 5 - 10 minutes  
 10 minutes

### Drying times



Dust-free  
 20°C / 68°F

#### Spray Filler

15 Minutes

#### Primer Surfacer

15 Minutes



Dry to handle  
 20°C / 68°F

60 Minutes

60 Minutes

## APPLICATION GUIDE (Cont.)

### Drying times



*Dry to Sand*  
20°C / 68°F  
60°C / 140°F

**Spray Filler**  
6 hour dry, preferably overnight  
Do not force dry

**Primer Surfacer**  
1½ Hours  
30 Minutes\*



*Tape Time*  
20°C / 68°F  
60°C / 140°F

N/A  
N/A

N/A  
N/A



*IR (Infrared)*  
Medium Wave  
Short Wave

Do Not Force Dry

20 Minutes  
10 Minutes

\* Stoving times are for quoted metal temperature. Additional time should be allowed in the force-drying schedule to allow metal to reach recommended temperature.

### Overcoat /Recoat



*Dry to Topcoat*  
20°C / 68°F  
60°C / 140°F

**Spray Filler**  
6 hours (after sanding)  
N/A

**Primer Surfacer**  
1½ Hours (or after sanding)  
30 minutes (or after sanding)



*Grade wet*  
*Grade dry*

European P600 / U.S. 400 followed by European P1200 / U.S. 600  
European P360 / U.S. 320 followed by European P1000 / U.S. 500



*Overcoat with*

Envirobase 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 equipment used.

When **Spot Priming** A-Chromatic Surfacer as a Primer Surfacer, 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 normal, 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
<b>Total dry film build:</b>		
Minimum after sanding	50µ / 2.0 mils	50µ / 2.0 mils
Maximum after sanding	250µ / 10. mils	150µ / 6.0 mils
Film build per wet coat	125µ / 5.0 mils	100µ / 4.0 mils
Dried film build per coat	50µ / 2.0. mils	37µ / 1.5. mils
<b>% solids by volume RTS</b>	40.55	33.79
<b>Theoretical coverage</b>	Approx. 650 sq.ft. / US Gal	Approx. 542 sq.ft. / US Gal

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

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**Technical Data (Cont.)**

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<b>RTS Combinations:</b>	<b>ECP1X : EH391</b>	<b>ECP1X : EH391: D8764/74/67</b>	<b>ECP1X : EH391: D8764/74/67 + SLV814</b>
Volume Ratio:	4 : 1	4 : 1 : 1	4 : 1 : 1 + 10%
Applicable Use Category	Primer	Primer	Primer
VOC Actual (g/L)	137 - 142	114 - 119	108 - 111
VOC Actual (lbs/gal)	1.15 - 1.19	0.96 - 0.99	0.89 - 0.92
VOC Regulatory (less water less exempt) (g/L)	240 - 249	240 - 249	230 - 240
VOC Regulatory (less water less exempt) (lbs/gal)	2.0 - 2.08	2.0 - 2.08	1.92 - 2.00
Density (g/L)	1505 - 1556	1455 - 1497	1414 - 1493
Density (lbs/gal)	12.56 - 12.98	12.14 - 12.49	11.80 - 12.46
Volatiles wt. %	45.9 - 48.1	53.2 - 55.2	54.0 - 57.3
Water wt. %	0.0	0.0	0.0
Exempt wt. %	37.1 - 38.6	45.6 - 47.1	46.7 - 49.6
Water vol. %	0.0	0.0	0.0
Exempt vol. %	43.0 - 43.3	52.5 - 52.8	53.6 - 53.8

**A-Chromatic Gray Mixing Chart**

**A-Chromatic Surfacers**

*This chart can be used to mix the A-Chromatic Surfacers. The G1 - G7 ratios will help to achieve better hiding when used as a guide for mixing the A-Chromatic Surfacers.*

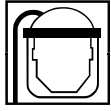
Mix Ratio By Volume			Mix Ratio By Cumulative Weight							
			Grams				Parts			
Mix Ratio			¼ Pint	½ Pint	Pint	Quart	¼ Pint	½ Pint	Pint	Quart
G1	ECP11	4	128	257	513	1025	145	289	578	1156
	EH391	1	153	306	612	1224	172	345	690	1380
	D87XX	1	177	354	707	1414	200	399	796	1593
G2	ECP11	Mix By Weight Only	120	240	484	977	136	271	547	1104
	ECP15		126	252	509	1026	142	285	575	1159
	EH391		150	301	599	1224	169	340	677	1383
	D87XX		177	354	705	1438	200	400	797	1625
G3	ECP11	3	96	192	385	769	108	217	434	867
	ECP15	1	128	257	514	1027	145	289	579	1157
	EH391	1	153	306	613	1225	173	345	690	1381
	D87XX	1	177	354	708	1416	200	399	797	1595
G4	ECP11	Mix By Weight Only	42	84	169	342	47	95	191	386
	ECP15		126	253	510	1029	142	286	576	1163
	EH391		151	302	608	1228	171	341	687	1388
	D87XX		177	355	714	1441	200	401	807	1628
G5	ECP15	4	129	257	515	1030	145	290	581	1161
	EH391	1	154	307	614	1229	173	346	692	1384
	D87XX	1	177	355	709	1419	200	400	799	1598
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		174	348	703	1413	197	393	794	1597
G7	ECP17	4	124	248	495	990	140	279	558	1116
	EH391	1	149	297	595	1189	167	335	670	1340
	D87XX	1	172	345	690	1379	195	388	779	1553

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## Health and Safety

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See Material 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 MSDS 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 MSDS 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 MSDS.
- 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, results, 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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PPG Industries  
19699 Progress Drive  
Strongsville, OH 44149  
1-800-647-6050

PPG Canada Inc.  
2301 Royal Windsor Drive Unit #6  
Mississauga, Ontario L5J 1K5  
1-888-310-4767