



2K SEALER

**#37001 (2K Sealer Gray - Gallon) • #37004 (2K Sealer Gray - Quart)
#37104 (2K Sealer Medium Activator - Quart) • #37116 (2K Sealer Medium Activator - 1/2 Pint)**



Excel 2K Sealer is a two-component acrylic urethane primer sealer formulated to be applied as a low build non-sanding sealer. #37001 offer excellent filling properties with minimal coats, fast dry, excellent adhesion, easy sanding and superior color holdout. #37001 does not shrink and can be tinted with basecoat tints.

Surface Preparation, Bare Substrates

Solvent wash surface with a good grade wax and grease remover such as Excel 91001 and wipe dry with a clean cloth. Apply three single wet coats of Excel 32001 Series Epoxy Primer according to instructions on data sheet.

Surface Preparation, Prepainted Substrates

Wash surfaces with a mild detergent and hot water. Rinse with clean water and wipe dry with a clean cloth. Solvent clean with Excel 91001. Wipe dry with a clean cloth. Sand original paint and repair damaged areas with a good quality non-staining body filler. For spot repairs, scuff sand area where primer will be applied. For overall refinishing, scuff sand the entire car with 320 grit sandpaper or fine scuff pad.

Mixing Directions, Sealer

4 Parts #37001	2K Sealer
1 Part #37104, #37116	Activator Series

Application, High Build and Normal Build

Adjust air pressure at the gun to 30-45 psi for siphon feed guns. Use less pressure to minimize over spray on small jobs. Apply 2-3 medium wet coats at a gun distance of 8-12 inches as needed to fill voids and block sand with 180 to 280 grit treated sandpaper. Allow 10 to 20 minutes flash time between coats. Recoat times will vary with temperature, air movement and film thickness. Insufficient flash time will promote slow hardness development of the topcoat system. Finish sand repaired area with 320 grit sandpaper using a DA Sander or hand sander.

Application, Sealer

Adjust air pressure at the gun to 30-45 psi for siphon feed gun. Use less pressure to minimize over spray on small jobs. Apply 1 or 2 wet coats at a gun distance of 8-12 inches. Allow 30 minutes flash time before top coating. Recoat time will vary with temperature, air movements and film thickness. Insufficient flash time will promote slow hardness development of the topcoat system.



Drying Schedule

Dry times are based on recommended film thickness and are dependent on ambient temperature. Excessive film thicknesses, low temperature and poor air movement will retard dry times.

<u>Air Dry</u>	<u>High Build</u>	<u>Normal Build</u>	<u>Sealer</u>
Dust Free	15-20 min.	10-15 min.	5-15 min.
Tack Free	25-30 min.	15-20 min.	15-20 min.
To Topcoat	60 min.	45-60 min.	30 min.

Technical Data

<u>Weight Solids</u>		<u>Mixing Ratio, High Build</u>	4:1
Package	64%	<u>Mixing Ratio, Normal Build</u>	4:1
Ready to Spray, High Build	57.3%	<u>Pot Life</u>	3 to 5 Hours
Ready To Spray, Normal Build	49.7%	<u>Viscosity @ Gun</u>	20-40 #2 Zahn
<u>Volume Solids</u>		<u>Recommended Film Thickness</u>	2.5 mil
Package	40%	<u>Flash Point</u>	72 FTCC
Ready to spray, High Build	36.2%	<u>Coverage, High Build</u>	648 sq ft/gal
Ready to spray, Normal Build	32.1%	<u>Coverage, Normal Build</u>	535 sq/ft
<u>Gallon</u>		<u>Air Pressure @ Gun</u>	45-50 psi
VOC @ Gun, High Build	4.3 lbs/gal	<u>Gloss</u>	Flat
VOC @ Gun, Normal Build	4.5 lbs/gal		

Performance Data

Flexibility	Excellent	Direct Impact	Excellent	Chip Resistance	Excellent
Salt Resistance	Excellent	Humidity Resistance	Excellent	Hardness	3H
Color Holdout	Excellent	Settling Resistance	Excellent	Water Resistance	Excellent