TECHNICAL DATA SHEET

FS510 – 4.6 VOC Enamel Sealer Black **FS512 –** 4.6 VOC Enamel Sealer Gray
FS514 – 4.6 VOC Enamel Sealer White

DESCRIPTION

FINISH 1™ 4.6 Enamel Sealers are designed to create a solid foundation and uniform color. FINISH 1™ Sealers have both one component and two component capabilities and can be recoated "wet-on-wet". These sealers can also be mixed together at any ratio to create a "Grayscale" offering.

PHYSICAL DATA

	1K	2K
Pot Life:	None	1 hour @ 70°F
VOC Ready to Spray:	4.6 lbs/gal	4.2 lbs/gal

SUBSTRATES

Properly prepared and etched bare metal or prepainted substrates.

MIXING

FS510 Black, FS512 Gray, and FS514 White can be used as packaged color sealers or can be mixed together at varying rations to create a variety of color sealer options within the "Grayscale" spectrum.

1K Option

4 Finish 1™ Sealer + **1 FT210 or FT215 Reducer**

- Stir or shake primer thoroughly before mixing.
- FT210 should be used for temperatures up to 85°F and FT215 should be used for temperatures 85°F or greater.
- Stir thoroughly or strain before using.
- **Pot life**: No pot life

2K Option

4 Finish 1™ Sealer + **1 FH612 or FH613 Hardener**

- Stir or shake primer thoroughly before mixing.
- FH612 should be used for temperatures up to 85°F and FH613 should be used for temperatures 85°F or greater.
- Stir thoroughly or strain before using.
- **Pot life**: 1 hour at 70°F, 45 minutes at 80°F, 30 minutes at 90°F.

APPLICATION

- Adjust air pressure to 8-10 psi for HVLP gun, or 45-55 psi for conventional gun.
- **WET-on-WET Application**: Apply 1 full even wet coat to complete panels to achieve 0.8 to 1.2 mils at a gun distance of 4-7".
- **Barrier Coat Application (2K ONLY)**: Apply 2-3 medium coats, allowing each coat to flash handslick between coats, to achieve 2.0 mils. Apply to complete panels only.

RECOATING

- **As a Wet-on Wet Sealer**: Allow to dry handslick before topcoating (usually 5-30 minutes depending on temperature and film build).
- **As a Barrier Coat Sealer (2K ONLY)**: Allow to air dry 12 hours at 80°F. Then scuff sand with 600 grit or finer sandpaper prior to topcoating. (Resealing is not necessary).

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