



### Excel 2K Sealer

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

- #30001 2K Black Sealer - Gallon      #30004 2K Black Sealer - Quart
- #37001 2K Gray Sealer - Gallon      #37004 2K Gray 2K Sealer - Quart
- #39001 2K White Sealer - Gallon      #39004 2K White Sealer - Quart
- #37501 2K Clear Sealer - Gallon      #37504 2K Clear Sealer - Quart

### Application

Surface Preparation Substrates Solvent wash surface with a good grade wax and grease remover such as Excel #91001, #91004 or #91005 and wipe dry with a clean cloth. Apply 1-2 wet coats of Excel #32001 or #32004 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, #91004 or #91005 wax and grease remover. 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 sealer will be applied. For overall refinishing, scuff sand the entire car with 320 grit sandpaper or fine scuff pad.

### Mix Ratio

- 4 Parts                      2K Sealer
- 1 Part                      Activator Series

### Application

Gravity feed	1.3-1.5mm	30 PSI at the spray gun air inlet
Gravity feed HVLP	1.3-1.5mm	10 PSI max at air cap
Siphon feed	1.6-1.8mm	40-50 PSI

### Application

Adjust air pressure at the gun to 30-45 psi for siphon or gravity feed guns. Pressure for HVLP guns should be 6-8 lbs at the aircap. Use less pressure to minimize over spray on small jobs. Apply 1-2 medium wet coats at a gun distance of 8-12 inches as needed to achieve coverage. 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.

### 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.

Air Dry	Sealer
Dust Free	5-15 min
Tack Free	15-20 min
To Topcoat	30 min
Pot Life	2-3 hours



**Drying Schedule**

**Accelerator**

To improve cure and or for faster cure in colder conditions, an accelerator may be added at the rate of 1/2 to 1 oz per catalyzed ready to spray quart. Caution: The addition of cure accelerator can significantly reduce working pot life.

**Technical Data**

Weight Solids	52%	Mixing Ratio	4:1
Ready to Spray	48%	Pot Life	1-2 hours
		Viscosity @ Gun	20-40 #2 Zahn
Volume Solids	34%	Recommended Film Thickness	2.5 mil
		Flash Point	72°F TCC
Ready to spray	32%		
VOC @ Gun	4.5 lbs/gal	Air Pressure @ Gun	30-45 psi

**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