

VERSASEAL 2.1

PRODUCT FEATURES

- Compatible with a wide range of topcoats including waterborne basecoats
- Can be used as a barrier coat sealer.
- Non-sanding
- Tintable



AVAILABILITY

VERSASEAL 2.1 (Part A)		Unit	Per Case	Catalyst (Part B)		Unit	Per Case
APR-1376-1	Gray	GL	2	BPR-1370-4	Normal Catalyst	QT	4
APR-1376-4	Gray	QT	6	BPR-1370-6	Normal Catalyst	HP	6
APR-1378-1	Tintable	GL	2	BPR-1372-4	Hot Weather Catalyst	QT	4
				BPR-1372-6	Hot Weather Catalyst	HP	6

PHYSICAL PROPERTIES

Pot Life	90 minutes	EPA VOC (RTS)	≤2.1(lb./gal)
Flash Point	30° F	Humidity Resistant	Excellent
Dry Film Build	1.2 to 1.6 mils/coat	Color Holdout	Excellent
Recommended Build As a Wet on Wet Sealer	1.5 to 2.0 mils	Inter Coat Adhesion	Excellent
Recommended Build As a Barrier Sealer	2.0 to 2.5 mils		
Sprayable Viscosity (RTS)	16" to 19" #2 Zahn Cup		
Weight Solids (RTS)		Theoretical Coverage @ 1 mil (A+B)	
Gray	44.2 to 44.8%	Gray	533.7 sq ft
Tintable	46.6 to 47.4%	Tintable	590 to 599 sq ft

SUBSTRATES

Properly sanded and treated:

- Steel
- Aluminum
- OEM Finishes
- Fiberglass
- Body Filler

DRY TIMES @ 70°F

Air Dry

Flash 10 to 15 minutes

WHEN USED AS A "WET ON WET" SEALER

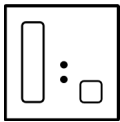
Allow sealer to dry 30 minutes before topcoating.

WHEN USED AS A "BARRIER COAT" SEALER

Allow sealer to dry 1 ½ hours before topcoating.

NOTE If sealer is allowed to dry over 48 hours it must be sanded or scuffed with a 600P grit or finer sandpaper for proper adhesion.

MIX RATIO



4 Parts VersaSeal 2.1
1 Part Catalyst

NOTES

1. Up to 5% of ALR-065 series "0" VOC Urethane Reducer can be added as needed to improve flow.
2. Tintable VersaSeal 2.1 must be mixed with TINT-A-PRIME color prior to mixing it with the catalyst. Formulas for mixing the sealer with the TINT-A-PRIME color can be found in the Color Genie software.

SPRAY GUN SETUP



Gravity or Siphon Feed HVLP	1.3 to 1.5 mm	7 to 10 PSI
Conventional	1.4 to 1.5 mm	45 to 55 PSI

COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure. One-half (½) fluid ounces of AXIS 2K PERFORMANCE ACCELERATOR per mixed quart may be added to improve cure response in adverse facility conditions.

SPRAY GUN ADJUSTMENT

- Adjust the material flow according to product viscosity.
- Fully close the material flow knob then turn knob counter clockwise two full turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut.

Note: Proper spray gun adjustment will determine the final finish, improper adjustment may cause orange peel, runs, poor drying and poor adhesion just to name a few defects .

SURFACE PREPARATION

- Wash surfaces with a mild detergent in warm water. Rinse well and wipe dry with a clean dry cloth, then clean with AXIS PRE-CLEAN, using generous amounts and changing rags frequently prior to painting.
- Sand area as necessary to remove any rust or corrosion, and then repair all body damage.
- Dry sand old finishes by hand or machine with 320P to 400P grit paper or wet sand using 400P grit paper.
- Prime exposed metal with AXIS 1:1 WC PRE-TREATMENT.
- After allowing the WC PRE-TREATMENT to dry thoroughly, scuff sand if necessary to remove dust.
- Re-wipe vehicle with AXIS WC PRE-CLEAN.

APPLICATION**WHEN USED AS A “WET ON WET” SEALER**

- Apply 1 medium wet coat allowing 30 minutes before topcoating.

WHEN USED AS A “BARRIER COAT” SEALER

- Apply 2 medium wet coats allowing 15 minutes flash time between coats. Allow sealer to dry for 1½ hours before topcoating.

EQUIPMENT CLEANING

Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

PRODUCT SAFETY INFORMATION

Before using any AXIS Product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT MATERIAL SAFETY DATA SHEET.