# 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™ 4.6 Enamel Sealers are designed to create a solid foundation and uniform color. FINISH™ 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

<table>
<thead>
<tr>
<th></th>
<th>1K</th>
<th>2K</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Pot Life:</strong></td>
<td>None</td>
<td>1 hour @ 70°F</td>
</tr>
<tr>
<td><strong>VOC Ready to Spray:</strong></td>
<td>4.6 lbs/gal</td>
<td>4.2 lbs/gal</td>
</tr>
</tbody>
</table>

## 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 ratios to create a variety of color sealer options within the “Grayscale” spectrum.

<table>
<thead>
<tr>
<th>1K Option</th>
<th>2K Option</th>
</tr>
</thead>
<tbody>
<tr>
<td><img src="image" alt="Mixing Instructions" /></td>
<td><img src="image" alt="Mixing Instructions" /></td>
</tr>
<tr>
<td><strong>4 Finish 1™ Sealer</strong></td>
<td><strong>4 Finish 1™ Sealer</strong></td>
</tr>
<tr>
<td><strong>1 FT210 or FT215 Reducer</strong></td>
<td><strong>1 FH612 or FH613 Hardener</strong></td>
</tr>
</tbody>
</table>

- 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
- 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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