DUPONT Refinish

DuPont™ Velvaseal® 1986S™ Acrylic Sealer

Description

Velvaseal® is a ready-to-spray acrylic sealer with good holdout and adhesion. It is designed for spot and panel repairs, and can also be used over factory primers on replacement parts.

General Information

Components

Velvaseal® 1986S™ - (Gray)

Mix Ratio/Viscosity

Ready-to-spray.

Tips for Success

Hand stir or agitate on a mechanical shaker prior to use.

Pot Life

Indefinite.

Additives

Accelerator:	Not recommended.
Fish Eye Eliminator:	Not required.
Flex Additive:	Not recommended.
Reducer:	Not recommended.
Retarder:	Not recommended.

Topcoats

ChromaBase®
ChromaOne®

Application

Substrates

Fill 'N Sand® 131S™ Acrylic Primer-Surfacer
Properly sanded OEM finishes and OEM replacement parts

Surface Preparation

- For substrates other than unprimed plastic or fiberglass, wipe surface with DuPont™ First Klean™ 3900S™, Prep-Sol® 3919S™ or DuPont™ Kwik Clean™ 3949S™.
- For unprimed plastic or fiberglass, wipe with Plas-Stick® 2320S™ Plastics Cleaner. For flexible fascia, refer to the DuPont plastic refinishing system.
- Sand according to substrate specific recommendations for the primer used.
- Finish sanding substrate with P500 grit paper.
- Remove sanding sludge with DuPont™ Final Klean™ 3901S™, DuPont™ 3939S™ Lacquer and Enamel Cleaner or DuPont™ Low VOC Final Klean™ 3909S™.

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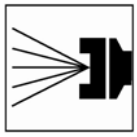
Gun Setups*

Conventional

Siphon Feed:	1.5 mm - 1.8 mm (.059" - .070")
Gravity Feed:	1.5 mm - 1.8 mm (.059" - .070")

HVLP

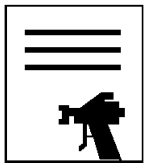
Siphon Feed:	1.4 mm - 1.6 mm (.055" - .063")
Gravity Feed:	1.7 mm (.067")



Air Pressure*

Conventional	Panel	Overall
Siphon Feed:	30 - 40 psi @ the gun.	35 - 45 psi @ the gun.
Gravity Feed:	25 - 35 psi @ the gun.	30 - 40 psi @ the gun.
HVLP	8 - 10 psi @ the gun cap.	8 - 10 psi @ the gun cap.

*The listed setups cover the usual range for various application equipment. For information on specific manufacturers' equipment, see the Appendix section titled "Equipment Information."



Application

Apply 1 medium-wet coat.

Flash/Dry

Air Dry

Dry Time:	20 minutes @ 70°F.
Max. Allowable Dry Time:	72 hours; must lightly sand before topcoating.

Force Dry

Flash before Force Dry:	5 - 10 minutes.
Cycle Time:	15 minutes @ 110°F.
Cool Down:	15 minutes.

Recoatability/Re-repair

Velvaseal® may be recoated at any stage of dry or cure. If allowed to dry 72 hours, Velvaseal® must be lightly sanded before topcoating.

Sanding

No sanding is necessary (unless it is allowed to dry for 72 hours).

Tips for Success

- *If sanding is required to remove imperfections, dry or wet sand with P600 - 1000 grit paper using light hand pressure to avoid any cut-throughs.*
- *Velvaseal® is not recommended over flexible plastic parts.*

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Cleanup

Clean spray equipment as soon as possible with DuPont Lacquer Thinner.

Physical Properties

VOC:	4.6 lbs/gal ready-to-spray.
Theoretical Coverage:	286 sq. ft. per ready-to-spray gallon at 1 mil.
Percent Solids by Weight:	31.2% ready-to-spray.
Percent Solids by Volume:	17.8% ready-to-spray.
Recommended Dry Film Thickness:	0.5 - 1.5 mils in 1 coat.
Flash Point:	See MSDS.

VOC Regulated Areas

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to or use by the general public.
Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Please visit: www.performancecoatings.DuPont™.com to view or print an addition copy of this "Technical Product Data" sheet.

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