

Technical Data Sheet

1K RTS (READY-TO-SPRAY) SEALERS

DESCRIPTION:

ARC 1K RTS Sealers are a 1K (single component) non-sanding, low build primer sealer. Available in White, Black, Gray, and Red, colors. Providing excellent adhesion to fully cured substrates. Very good durability and corrosion resistance. Fast dry time. Assist in coverage with translucent colors.

*SHAKE WELL PRIOR TO USING

PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
1K RTS White Sealer	31905/31906	Quart/Gallon
1K RTS Black Sealer	31908/31909	Quart/Gallon
1K RTS Gray Sealer	31911/31912	Quart/Gallon
1K RTS Red Sealer	31914/31915	Quart/Gallon

COMPATIBLE SUBSTRATES:

- * Properly prepared aluminum and steel
- * Properly prepared OEM finishes
- * Properly prepared previously painted or primed surfaces
- * Fully cured painted surfaces

SAFETY ASPECTS:



Users should review the Safety Data Sheet (SDS) and product label for the material to be used to determine possible health hazards, appropriate engineering controls and precautions to be observed in the use of the material. Copies of the SDS and product label are available upon request.

MIXING RATIOS:

MIX
RTS = Ready-To-Spray

GUN SETUP:



TYPE	FLUID TIP	SPRAYING PRESSURE
Conventional Mini-Jet	1.0 mm – 1.3 mm	20 – 28 psi @ gun
HVLP Mini-Jet Gravity	1.2 mm – 1.3 mm	10 psi @ cap
Conventional Gravity	1.2 mm – 1.3 mm	30 – 40 psi @ gun
Siphon Feed Gun	1.3 mm – 1.4 mm	30 – 45 psi @ gun

NUMBER OF COATS:

- * Apply one (1) to two (2) medium wet coats allowing 5 – 15 minutes flash between coats
- * Allow final coat to flash 30 – 60 minutes, flash dull, prior to top coating.
- * DO NOT spray when surface temperature is below 50F (10C)

FLASH TIMES:

5 to 15 minutes between coats



ADVANCED REFINISH COMPONENTS

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FINAL FLASH TIME: 30 to 60 minutes.

FLASH TIMES:



METAL TEMP	FLASH TIME	FINAL FLASH
68°F/24°C	5 to 15 minutes	30 to 60 min.
	Between coats	Before top coat

RECOATABILITY: **1K RTS Sealers** *must be top coated* after sufficient flash times. If more than 4 hours pass after initial application, it is recommended to lightly sand with 600 wet prior to top coat application.

FILM THICKNESS: Approximately 0.5 – 1.0 mils per single coat.
Recommended Film Thickness: 1.0 to 2.0 mils

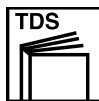
CLEANING EQUIPMENT Clean equipment immediately with lacquer thinner.



ADVANCED REFINISH COMPONENTS

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TECHNICAL DATA:


Colors	White / Black / Gray / Red
Activator/Hardener	N/A
Mix Ratio	RTS = Ready-To-Spray
Reducer	N/A
Additives	N/A
Number of Coats	1 to 2 medium wet coats
Flash Time	5 to 15 minutes
Final Flash Time	30 to 60 minutes
Dry Time	Topcoat after final flash
Gun Set-Up	Refer to Table on Page 1
Air Pressure @ Gun	Refer to Table on Page 1
V.O.C. Limit	4.6 lbs/gal
Sprayable V.O.C.	4.2 lbs/gal @gun
% Solids Sprayable by Weight	36%
Package Size	Quarts & Gallons
Shelf Life	12 months unopened

All data given below are MAXIMUM THEORETICAL VALUES based on the product AS CURRENTLY FORMULATED. Variations may occur on individual batches due to adjustments made during production.

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