



**CARE SEAL™ HS**  
**CLEAR POST-CATALYZED SEALER**  
 FF5320000

**DESCRIPTION:**

Care Seal™ HS Clear Post-Catalyzed Sealer is a high volume solids, VHAPS free, two component, solvent borne sealer for interior woodwork. This fast drying sealer has excellent sandability, good build and excellent hang on vertical surfaces with very good light stability. It is an excellent sealer for recommended AcromaPro acid cure, clear topcoats.

**PRODUCT DATA:**

<b>Color:</b>	<b>Wet:</b> Clear <b>Dry:</b> Clear	<b>VOC (as packaged, maximum, less exempt solvents):</b>	5.11 lbs/gal or 612 g/l
<b>Solids % by Vol.:</b>	29 % (Theoretical)	<b>VOC (emitted):</b>	5.11 lbs/gal or 612 g/l
<b>Solids % by Wt.:</b>	37 % (Theoretical)	<b>Lbs. VHAPs / Lbs. Solids:</b>	0 before catalyzed
<b>Weight / Gal.:</b>	8.10 lb	<b>Flash Point (PMCC):</b>	-4° C / 24.8° F
<b>Viscosity 23°C / 73°F:</b>	<b>#4 Ford:</b> 27-32 Sec.	<b>Photo Chemically Reactive:</b>	No
<b>Viscosity 23°C / 73°F:</b>	<b>DIN 4:</b> 20-24 Sec.	<b>Shelf Life:</b>	1 year (at 15-25° C / 59°-77° F)
<b>Viscosity 23°C / 73°F:</b>	<b>Zahn #2 sig.:</b> 20-26 Sec.	<b>Theo. Coverage@1mil dry</b>	465 Sq. Ft./Gal. 100% Efficiency

**MIXING / APPLICATION:**

**Working Temp:** >18° C, 65° F substrate, coating and air  
**Hardener:** 10% by volume using either Catalyst 2750 (standard), Catalyst 494 (slow), or Catalyst 309 (VHAPS free, fast).  
**Pot Life:** 8 hrs. (23° C / 73° F)  
**Mixing:** Mix thoroughly to ensure uniform consistency mixing before and after adding hardener. Avoid over mixing which may introduce air into the product.  
**Reducer:** Thinner 219 (Regular), Thinner OC 140 (Fast), Thinner 309 (Fast, VHAPS free), Thinner 419 (Slow, VHAPS free).  
**Application:** 80 - 100 (g/m<sup>2</sup>) Approx. 3-4 wet mils; Min 3 mil wet –Max 5 mil wet @ 60%RH  
**Surface Prep:** Substrate should be clean and free of grease and oil. Moisture content of the wood should be between 6%-8%. 150 grit on open grain and 180 grit on closed grain wood. Always sand the sealer-coat within 8 hours prior to top-coating to improve adhesion.  
**Use Directions:** For interior use only. Add hardener and mix thoroughly before application. Stack only when the surface temperature is below 35°C / 95 ° F. Dry time can be directly impacted by many factors, including film thickness. Users are urged to test the system under shop conditions.  
**App. Equip.:** Conventional & HVLP Siphon Feed, Gravity Feed and Pressure Pot Systems and Airless Air Assist Equipment.  
**Tinting:** Can be used with Chroma Chem 844 colorants. Do not exceed 5% by weight black or blue. All other colors can be used to a maximum of 10% by weight. Do not exceed 10% by weight maximum total colorant. Prior to application test a sample piece to ensure proper color match.  
**Ind. Standards:** This product meets the quality standard Catalyzed Vinyl Transparent for AWI. It also meets KCMA and CKCA standards.

**DRYING TIMES TO SAND:**

Method	Drying Temp.	Drying Time (@ 60 % RH and thickness @ 1 mil dry)
<b>Air Drying</b>	20° C / 68° F	30-40 min. dry to <b>sand</b>
<b>*Forced Drying</b>	70° C / 158° F	5-10 min. dry to <b>sand</b>

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**APPLICATION RECOMMENDATIONS:**

**APPLICATION EQUIPMENT SETTINGS**

Method of Application	Wet Film		Dry Film	
	Mils	g/m <sup>2</sup>	Mils	Microns
Conventional – Siphon Fed	3 – 5 mils	75-125 g/m <sup>2</sup>	0.9-1.5 mils	22.5-37.5 microns
Conventional – Pressure Pot	3 – 5 mils	75-125 g/m <sup>2</sup>	0.9-1.5 mils	22.5-37.5 microns
Airless Air Assist	3 – 5 mils	75-125 g/m <sup>2</sup>	0.9-1.5 mils	22.5-37.5 microns
HVLP - Siphon Fed	3 – 5 mils	75-125 g/m <sup>2</sup>	0.9-1.5 mils	22.5-37.5 microns
HVLP - Pressure Pot	3 – 5 mils	75-125 g/m <sup>2</sup>	0.9-1.5 mils	22.5-37.5 microns

All measurements and application equipment settings are based on application at a temperature of 68°F. Viscosity will vary depending on the temperature of the liquid. The application equipment setting recommendations are guidelines only. The settings are starting point recommendations and adjustments to the equipment settings and equipment may be needed to obtain the desired results. Please refer to your specific equipment manufacturer's recommendations for equipment set-up.

**REDUCTION – TIP SIZE – PSI SETTINGS**

**Conventional Equipment Siphon Feed:**

Reduce to 18-21 seconds #4 ford viscosity cup, nozzle size 0.070 inches (1.8mm) – 0.079 inches (2.0 mm), atomizing air 30 psi (2.8bar)–50 psi (3.5 bar).

**Conventional Equipment Pressure Pot:**

Reduce to 18-21 seconds #4 ford viscosity cup, nozzle size 0.472 inches (1.2mm) – 0.055 inches (1.4 mm), atomizing air 40 psi(2.8 bar)–50 psi (3.5 bar), Pot pressure 7 psi (0.48 bar) to 15 psi (0.68 bar)

**Airless Air Assist Equipment:**

Reduce to 18-25 seconds #4 ford viscosity cup, tip size.011inches (0.28mm) - .013 inches (0.33mm), fluid pressure 290 psi (20 bar) – 580psi(40 bar), atomizing air 11psi (0.8 bar) to 17psi (1.2 bar).

**HVLP Equipment Siphon Feed:**

Reduce to 17-21 seconds #4 ford viscosity cup,.061inch (1.5mm) -.072inch ( 1.8MM) nozzle, atomizing air 35psi (2.4bar) -45 psi (3.1bar).

**HVLP Equipment Pressure Pot:**

Reduce to 17-21 seconds #4 ford viscosity cup,0.472 inches (1.2mm) – 0.055 inches (1.4 mm) nozzle, atomizing air 20psi (1.37 bar) -25 psi (1.72 bar). Pot pressure 7 psi (0.48 bar) to 15 psi (0.68 bar)

**PRODUCT NOTES**

- Excellent sealer for use under recommended AcromaPro acid cure clear topcoats. Please consult your AcromaPro representative for system recommendations.
- Over catalyzing may result in blooming, cracking and poor adhesion.
- Maximum recommended dry film thickness for total coating system is dependent on the topcoats used.
- To avoid material build up in automated line applications, users are urged to clean and flush lines daily.

**CONTACTS:**

PH: AcromaPro USA and Canada / 1-888-277-1448

[www.AcromaPro.com](http://www.AcromaPro.com)



**TESTING:** Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

**FOR INDUSTRIAL SHOP APPLICATION:** Thoroughly review Material Safety Data Sheet (MSDS) for safety information and cautions prior to using this product. For Regulatory compliance data (i.e. VOC, HAPS, etc.), obtain an Environmental Data Sheet (EDS) prior to using the product. A MSDS and/or EDS is available from your local distributor or representative. Please direct any questions or comments to 1-800-524-5979.

**NOTE:** Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, AcromaPro cannot make any warranties as to the end result.