PPG AUTO REFINISH

ENVIROBASE® HIGH PERFORMANCE PPG AUTOMOTIVE FINISHES

Product Information

Envirobase
High Performance

Envirobase Mixed Colour
Tinter Line Number – T4XX

PRODUCTS

Envirobase High Performance Tinters	T4XX, T4XXX
Envirobase Thinners	T494

PRODUCT DESCRIPTION

Envirobase High Performance is an anti settle, waterborne basecoat mixing scheme that significantly reduces spraybooth cycle times due to it's superior properties of rapid drying, excellent coverage, and easy blending capability.

Applied as part of a two-stage or multi-stage basecoat paint system, Envirobase HP reproduces original solid, metallic, mica or special effect paint finishes.

In conjunction with selected PPG Clearcoats and Primers, the Envirobase High Performance system delivers excellent gloss and durability.

Envirobase HP meets or exceeds the performance requirements of motor manufacturer paint system warranties and, therefore, carries a large number of OEM approvals

Envirobase HP reduces solvent emissions into the environment and complies with all current and future legislative requirements.

PREPARATION OF SUBSTRATE

SUBSTRATE	PREPARATION
Selected PPG Global primers*	P500 - dry

**Envirobase HP should <u>not</u> be used directly over D831/D847 or areas of bare metal*

Electrocoat	Pre-prime - Do not topcoat direct
Sound 2K finishes	P500 - dry

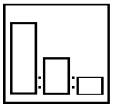
Before and after any sanding operation, the substrate must be thoroughly cleaned initially using SWX250. Use SWX250 followed by D837, prior to painting.

Application Guide

PRE-APPLICATION

Gently Hand-agitate bottles of Envirobase High Performance tinter for a few seconds before use. Do not shake vigorously as foaming will occur.
Mixed Envirobase High Performance colour should be thoroughly hand-stirred before application. If not used immediately it should be hand-stirred again before use.
Use nylon paint filters specially designed for use with waterborne paint materials.
A 125 micron mesh is essential . SATA RPS plastic mixing cups or similar are recommended.

Mixing Ratio



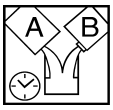
Envirobase solid colour and 2-stage Pearl	Envirobase T494	100 Parts 10 - 15 %
Envirobase Metallic colours	Envirobase T494	100 Parts 12 - 15 %
Envirobase 3-Layer Transparent coat	Envirobase T494	100 Parts 15 - 20%

NOTE - RFU mix ratios available on paint manager

Choose Thinner according to application temperature and repair area size
(see product manual section 3 general information)

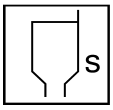
	Thinner
Normal spray temperature	T494

Potlife



3 months thinned and stored in appropriate air tight plastic container at the recommended temperature of between 5℃ - 35℃

Spray Viscosity



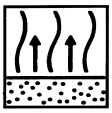
Viscosity will vary with the thinner level chosen, but the ideal application viscosity is 22 - 26 seconds / DIN4 / 20℃

Spraygun Setup

Gun set up	For optimum results use SATA HVLP WSB
Air Pressure	Opacity coats - 1.2 – 1.5 bar
Air Pressure	Control coat – 1.1 bar

ENVIROBASE HIGH PERFORMANCE APPLICATION PROCESS
FLASH-OFF AND DRYING

Application:	Apply as light even double coats until opacity is obtained. Heavy application must be avoided, or aeration/popping may result.
Tech tip: SATA HVLP WSB	Suggested material feed – Two turns out from closed Fan – ¾ to fully open.
Flash off:Until matt	Use Air movers to accelerate drying – SATA Dry jet
Control coat	For optimum metallic/mica control, apply control coat at a spraygun inlet pressure of 1.1 bar with the fan fully open onto a dry film



Before clearcoat:	Basecoats should be uniformly matt and dry before clearcoat application
Note: Spray booth cycle time reduction	PPG Suggests the clearcoat is mixed at the same time the basecoat is mixed and taken into the spraybooth at the same time

REPAIR AND RECOATING

De-nib:	It is possible to de-nib Envirobase, after it is uniformly matt, with fine abrasive –P2000 Abralon dry. Tack rag to remove sanding dust and recoat effected area (see FADE-OUT section) prior to the clearcoat application.

Recoat time:	After 24 hours, 1 coat of Envirobase or T490 must be applied prior to the clearcoat application. The maximum recoat time is 48 hours. After this time it should be thoroughly sanded, blown off and recoated.
Overcoat with:	Envirobase High Performance must be overcoated with a recommended PPG Global clearcoat after the minimum flash times. (See Clearcoat Technical Data Sheets for information)

FADE-OUT TECHNIQUE

Basecoat- Blend- out Technique

Blending out Envirobase High Performance is advisable when metallic or mica colours have to be repaired.

Apply basecoat to the prepared area until opacity is gained using 1.2 – 1.5 bar.
Reduce the pressure at the spraygun to1.1 bar and fade into the surrounding area.
Flash off until uniformly matt, for larger areas apply final control coat (metallics and micas) before applying clear.

Preparing the blend area

Ensure the whole area to be painted has been thoroughly cleaned using SWX250 Water-Methylated spirits cleaner and D837 Spirit Wipe.
Thoroughly flatten the area using Mirka P800 disc Dry followed by Grey Mirlon disc dry or Abralon P1000 damp. The blend area should have a uniform matt appearance.
Clean panel thoroughly using SWX250 Water-Methylated spirits cleaner followed by D837 Spirit Wipe prior to applying paint.

Tip*:* PPG recommend sealing the whole panel by applying the first coat of clear 50mm from the adjoining panel followed by a second coat of clear over the entire panel. This process will assist in reducing the darkening of panels particularly in lighter colours.

EQUIPMENT CLEANING

Clean all mixing equipment immediately after use, using a dedicated waterborne equipment cleaning machine, with a final rinse using T497 WB Gun Cleaner or an alcohol-based cleaner such as SWX250.
Ensure all equipment is completely dry before storage or use.

PERFORMANCE & LIMITATIONS

DO NOT use the spraygun as an airblower

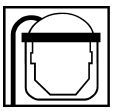
STORAGE & HANDLING

Envirobase High Performance tinters, mixed colour & T494 thinner should be stored in a cool, dry place away from sources of heat. During storage and transportation temperatures must be maintained at a minimum of +5°C and a maximum of +35°C. Avoid exposure to frost or freezing conditions.

Envirobase should be mixed in clean, dry containers and equipment. Do not use mixing vessels or spray equipment that contains solvent residues. Mixing vessels should ideally be plastic - if metallic they should have an internal anti-corrosion coating.

Shelf life

- *Shelf Life of correctly stored unopened tinter – 4 years*
- *Shelf life of correctly stored open tinter- 12 months*
- *Shelf life of correctly stored thinned colour – 3 months*



Health and Safety

Please refer to Material Safety Data Sheets for full Health and Safety details.

- Global Hardeners and activated Envirobase HP BC and PPG 2K Clearcoats contain isocyanate and therefore particular safety precautions must be taken.
- Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.
- Good ventilation and extraction must be provided in the working environment.
- Wear suitable protective equipment to prevent skin contact with this material.
- When spraying this product the operator (and persons in vicinity) must wear suitable breathing apparatus.
- Do not smoke whilst using this material.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.

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