



AUTO REFINISH

ENVIROBASE®  
HIGH PERFORMANCE

# Product Information

---

## ENVIROBASE HIGH PERFORMANCE INTERNAL REPAIR SYSTEM

---

### PRODUCTS:

**T510 WB ENGINE BAY CONVERTER**  
**D8260 ACTIVATOR FOR WB ENGINE BAY CONVERTER**  
**T494 THINNER**

---

### PRODUCT DESCRIPTION:

Envirobase High Performance Internal Repair System is designed to provide a simple and efficient process for repairs involving a specific matt interior colour, or low gloss versions of the external colour.

Direct application to electrocoat produces a groundcoat colour to accurately reproduce the original finish on internal parts. At the same time it provides a coloured wet on wet layer that can be topcoated to reproduce the original external finish, thereby removing the need for undercoating.

Envirobase High Performance Internal Repair system has two modes of use. Internal colour formulas matched to dedicated OE internal colours are provided as part of the PPG colour retrieval system. Alternatively any waterborne colour can be converted to Internal Repair mode for use in many repairs where internal colours are low gloss versions of external areas.

### PREPARATION OF SUBSTRATE:



For maximum durability, with new panels in good quality Electrocoat, it is recommended that the Electrocoat is abraded using a Red Mirlon Pad leaving it as intact as possible, prior to application of the Internal Repair Colour.

Rub through areas should be coated with SUA 340 (G3), SUA 440 (G5) or SUA 540 (G7) Aerosol 1K Epoxy primers.



For structural areas of bare metal, it is recommended that either an Etch primer followed by a wet on wet primer such as, D834 or D839, be used, prior to the application of Internal Repair colour.

Good preparation is vital in order to obtain the best results from these products Internal Repair System should **not** be applied directly over Etch Primer D831.

---

## PREPARATION OF WB ENGINE BAY CONVERTER:

Hand-shake bottles of Envirobase Engine Bay Converter and tinters for a few seconds before use to ensure that they are thoroughly homogeneous.

---

## MIXING RATIOS - Dedicated Internal Colour:

**Mix the Internal colour in accordance with the PPG colour retrieval systems.**

This formulation will contain T510 WB Engine Bay Converter:

NOTE: The colour must be stirred thoroughly when the converter is added, *BEFORE* activation and thinning.

### Making ready for use by weight:

Engine Bay Colour	100 parts
D8260 Activator	15 parts
T494*	15 - 20 parts for Solid Colours, 20 parts for Aluminiums / Pearls

To give an application viscosity of 18 - 21 Seconds

*\* 10 parts thinner may be used for double coating:*

---

## MIXING RATIOS - Converting an Existing Colour:

Where the internal area is a matt version of the external colour, mix the Envirobase colour in accordance with the PPG colour retrieval systems.

### Making ready for use by weight:

Envirobase Colour	70 parts
WB Engine Bay Converter T510	30 parts
	<b>Stir thoroughly then add:-</b>
D8260 Activator	15 parts
T494*	15 - 20 parts for solid colours, 20 parts for Aluminiums / Pearls

To give an application viscosity of 18 - 21 Seconds

*\* 10 parts thinner may be used for double coating:*

---

## MIXED PRODUCT DETAILS:

*Potlife* 1 hour at 20°C - when activated

*Spray Viscosity* 18 - 21 secs DIN4 / 20°C

---

---

## **SPRAYGUN SET UP:**

<i>HVLP Spraygun</i>	1.3 - 1.4 mm – SATA WSB Recommended
<i>Spray Pressure</i>	1.3 -1.8 bar
<i>Number of Coats</i>	Apply one double coat or 2 single coats to opacity to give a dry film thickness of 10 - 25 microns.

---

## **FLASH OFF AT 20 °C:**

<i>Between Coats</i>	Ensure that each coat is fully flashed off before overcoating. Blow dry using SATA blower.  5 minutes or until matt appearance between coats if using single coats.  Activated Internal repair basecoat should not be left uncoated on external areas.  If required for external areas: PPG recommend the use of a matted clearcoat to seal the basecoat.
----------------------	--

## PROCESS STEPS - DEDICATED INTERNAL COLOUR:

### For an Internal colour taken from the colour system

(includes the WB Engine Bay Converter)

1. Select the Internal colour using the Engine Bay Colour Directory or Engine Bay Fan Deck.
2. Using the normal colour retrieval system, mix the Envirobase Internal Colour, this includes the addition of T510 WB Engine Bay Converter.
3. Stir the colour thoroughly before activation - see below.

**Note:** Any rub through areas to bare metal should first be primed using SUA 340 (G3), SUA 440 (G5) or SUA 540 (G7) Aerosol 1K Epoxy primers.

4. Apply a light coat of colour to internal edges and sealer areas to maximize coverage. Flash off using air blowers.
5. Apply coats of colour to internal areas and any external panels that need a wet on wet surface for topcoat. Use double coats (single coats can be applied if preferred) to reach coverage.
6. Flash off using air blowers.
7. Apply the topcoat to external panels, as necessary, when fully flashed off, and bake. Internal colours can be overcoated with Envirobase + Clearcoat or Deltron DG colour.

**If some dirt inclusions occur, then light flattening / denibbing can be carried out once the basecoat has achieved a matt appearance. Use Abralon P1000/2000 dry. Alternatively, apply the basecoat colour and if the de-nib is still visible, then de-nib the basecoat.**

The weight of the activator and thinner required by certain weights of mixed colour to produce ready-for-use paint is detailed below. The weights correspond to the mixing ratio: 100 parts Envirobase Internal colour: 15 parts Engine Bay Activator: 15 - 20 parts thinner.

**Add suitable stirring stick to container, before taring the scale.  
Stir colour thoroughly, do not tare, before adding Activator and Thinner.**

The weights of activator and thinner are **CUMULATIVE** – DO NOT TARE THE SCALE BETWEEN ADDITIONS.

Final ready for use volume	Volume of Envirobase Interior colour mix		Weight of D8260 Activator	Weight of Thinner	
				Grams to 15 parts	Grams to 20 parts
Litres	Litres		Grams		
0.14	0.10	S	116	131	137
0.35	0.25	T	291	320	342
0.55	0.40	I	466	519	547
0.50	0.50	R	582	659	684
1.02	0.75		874	978	1026
1.37	1.00	W	1165	1317	1368
2.05	1.50	E	1747	1976	2052
2.74	2.00	L	2330	2634	2736
3.42	2.50	L	2912	3293	3420

## PROCESS STEPS - CONVERTING AN EXISTING COLOUR:

### For an Envirobase colour that needs converting to an Internal colour.

1. Select the colour using the Envirobase Colour Directory or Colour Swatch.
2. Using the normal colour retrieval system, mix the Envirobase colour, and stir thoroughly.
3. Referring to the table below, add the Engine bay additive and stir thoroughly.
4. Continue to activate and thin the Internal colour, as recommended below.

**Note:** Any rub through areas to bare metal should first be primed using SUA 340 (G3), SUA 440 (G5) or SUA 540 (G7) Aerosol 1K Epoxy primers.

5. Apply coats of colour to internal areas and any external panels that need a wet on wet surface for topcoat. Use double coats (single coats can be applied if preferred) to reach coverage.
6. Flash off using Sata air blowers.
7. Apply the topcoat to external panels, as necessary, when fully flashed off, and bake. (Internal colours can be overcoated with Envirobase + Clearcoat or Deltron DG colour.)

**If some dirt inclusions occur, then light flattening / denibbing can be carried out once the basecoat has achieved a matt appearance. Use Abralon P1000/2000 dry. Alternatively, apply the basecoat colour and if the de-nib is still visible, then de-nib the basecoat.**

The weight of the Converter, activator and thinner required by certain weights of mixed colour to produce ready-for-use paint is detailed below. The weights correspond to the mixing ratio: 70 parts Envirobase colour: 30 parts Engine Bay Converter: 15 parts Engine Bay Activator: 15 - 20 parts thinner.

**Add suitable stirring stick to container, before taring the scale.  
Stir colour thoroughly, do not tare, before adding Activator and Thinner.**

The weights of activator and thinner are **CUMULATIVE** – DO NOT TARE THE SCALE BETWEEN ADDITIONS.

**Note: If the mixed colour has already been thinned then disregard the addition of thinner section below.**

Approx Final ready for use volume	Weight of Envirobase HP Colour Mix	Weight of T510 WB Engine Bay Converter		Weight of D8260 Activator	Weight of Thinner	
					Grams to 15 parts	Grams to 20 parts
Litre	Grams	Grams		Grams	Grams to 15 parts	Grams to 20 parts
0.10	50	73	S	84	94	98
0.25	125	182	T	209	236	245
0.40	200	291	I	334	377	392
0.50	250	364	R	418	472	491
0.75	375	545		627	707	736
1.00	500	727	W	836	943	981
1.50	750	1091	E	1254	1415	1472
2.00	1000	1454	L	1672	1886	1962
2.50	1250	1818	L	2090	2358	2453

---

## VOC INFORMATION:

The VOC content of this product in ready to use form is max. 420g/litre.  
Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified.

---

## HEALTH AND SAFETY:



**Please refer to Material Safety Data Sheets for full Health and Safety details and product can labels.**

- Clearcoat hardeners 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 air-fed 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.



**PPG INDUSTRIES AUSTRALIA  
PTY LIMITED**

**McNaughton Road  
Clayton VIC Australia 3168**

**Tel: 13 2424**

**Fax: 1800 800 819**

**PPG INDUSTRIES NEW  
ZEALAND PTY LIMITED  
5 Vestey Drive Mt. Wellington  
Auckland New Zealand**

**Tel: 0800 320 320**

**Fax: 0800 320 322**

