

PDS N5.2.1

March 2016

AQUABASE® *Plus* ***Engine Bay Color System***

PRODUCT DESCRIPTION

Aquabase Plus Engine Bay Color System is designed to provide a simple process for repairs involving a specific underhood color or where the internal area is a low gloss version of the exterior color.

Aquabase Plus Engine Bay Color may be applied directly to electrocoat panels which accurately reproduces the original finish on internal parts. At the same time it provides a colored wet on wet layer that can be topcoated to reproduce the original external finish, thereby removing the need for undercoating.

Engine Bay Repair system has two modes of use. Engine Bay Color formulas matched to dedicated OE internal colors are provided as part of the color retrieval system. Alternatively any waterborne color can be converted to an Engine Bay Color for use in many repairs where internal colors are low gloss versions of external colors.

- Excellent Coverage = Less coats, materials savings
- Fast Dry = Improved process times
- Easy Application = Consistent results
- Excellent Color Match = Customer satisfaction

AQUABASE PLUS ENGINE BAY COLOR

PRODUCTS





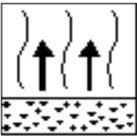



P989-XXXX AQUABASE PLUS ENGINE BAY COLOR

P980-5000 AQUABASE PLUS THINNER

P210-9120 ACTIVATOR FOR WB ENGINE BAY BASIC

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

	<p>P989- Engine Bay Color 100 parts P210-9120 Activator 15 parts P980-5000 Thinner 15 - 20 parts</p>
	<p>Application Viscosity: 18 – 21 secs. DIN4 Pot-life: 1 hour at 70°F / 21°C</p>
	<p>Fluid Tip: Gravity Fed: 1.2 - 1.4 mm Inlet Pressure: As recommended by spray gun manufacturer.</p>
	<p>Apply one light coat over internal edge areas to maximize coverage, then Apply one double coat or two single coats to give a film thickness of 0.4-0.8 mils</p>
	<p>5 minutes flash-off between coats if using single coats.</p>
	<p>Air-dry at 70°F / 21°C before topcoating: Flash-off until matt. This will take approximately 15 - 20 minutes at 70°F / 21°C before overcoating. Flash off can be assisted by use of air blowers.</p>
	<p>Normally the Engine Bay System does not require flatting. If some dirt inclusion occurs, light dry de-nibbing can be carried out after 20-30 minutes using P1200 or finer flatting paper.</p>
	<p>Areas requiring topcoat can be directly topcoated with <i>Aquabase</i> Plus basecoat.</p>

ENGINE BAY COLOR

PREPARATION

Prior to the application of Engine Bay Color and for maximum performance, it is recommended that e-coat panels be lightly abraded and cleaned. If cut-throughs appear, apply a light coat of P965-908X Aerosol Etch Primer before over coating.

For larger areas of bare metal, apply P565-9880 Etch Primer followed by either a primer surfacer or a wet-on-wet sealer. Engine Bay color should not be directly applied over etch primer.

PROCESS STEPS - DEDICATED ENGINE BAY COLOR

For an Engine Bay Color taken from the color system that includes the Engine Bay Additive.

1. Select the Engine Bay color using PAINTMANAGER®, the engine bay color directory or engine bay color chips.
2. Using the normal color retrieval system, mix the *Aquabase Plus Engine Bay Color*, which includes the addition of P935-1135 Engine Bay Basic.
3. Any rub through areas to bare metal should first be primed using P965-908X Aerosol Etch Primer.
4. Apply a light coat of Engine Bay color to internal edges to maximize coverage. Flash off using air blowers.
5. Apply additional coats of Engine Bay color 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 until film is fully matt.
7. If topcoating, apply the basecoat after 15 - 20 minutes. Flash off using air blowers until engine bay color is fully matt. Normally this Engine bay system does not require flattening. If some dirt inclusions occur, then light flattening / de-nibbing can be carried out after 20 minutes using P1200 or finer flattening paper (dry).
8. Stir color thoroughly before adding activator and thinner.

PROCESS STEPS - CONVERTING AN EXISTING COLOR

For an Aquabase Plus color that needs converting to an Engine Bay color.

1. Select the color using the *Aquabase Plus Color Directory* or Color Swatch.
2. Using the normal color retrieval system, mix the *Aquabase Plus Color*, and stir thoroughly.
3. Referring to the table below, add the Engine bay basic and stir thoroughly.
4. Continue to activate and thin the Engine Bay Color, as recommended below.
5. Any rub through areas to bare metal should first be primed using P565-908X aerosol etch primer.
6. Apply a light coat of Engine Bay color to internal edges to maximize coverage. Flash off using air blowers.
7. Apply coats of Engine Bay color 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.
8. Flash off using air blowers until film is fully matt.
9. Apply the basecoat after 15 - 20 minutes. Flash off using air blowers until film is fully matt.
10. Normally this Engine bay system does not require flattening and should be directly topcoated. If some dirt inclusions occur, then light flattening / de-nibbing can be carried out after 20 minutes using P1200 or finer flattening paper (dry).

The grams are **CUMULATIVE**.

DO NOT TARE / ZERO OUT THE SCALE BETWEEN ADDITIONS.

<i>Aquabase Plus Mixed Color</i>	<i>Engine Bay Basic P935-1135</i>		<i>Engine Bay Activator P210-9120</i>	<i>Thinner P980-5000</i>	<i>Approx. final Volume</i>
Grams (parts)	Grams (parts)		Grams (parts)	Grams (parts)	Oz.
124 (140)	177 (200)	STIR WELL	204 (230)	239 (270)	8
248 (280)	355 (400)		408 (460)	479 (540)	16
372 (420)	532 (600)		612 (690)	718 (810)	24
497 (560)	709 (800)		816 (920)	958 (1080)	32
621 (700)	887 (1000)		1020 (1150)	1197 (1350)	40
745 (840)	1064 (1200)		1224 (1380)	1437 (1620)	48
869 (980)	1241 (1400)		1428 (1610)	1676 (1890)	56

ENGINE BAY COLOR

PHYSICAL PROPERTIES

RTS Combinations:	P989-	P989 : P210-9120 : P980-5000	P989 : P210-9120 : P980-5000
Applicable Use Category	Underbody Coating	Underbody Coating	Underbody Coating
Wt. Ratio:	Packaged	100 : 15 : 15	100 : 15 : 20
Density (g/L)	996 - 1134	1003 - 1106	1002 - 1103
Density (lbs/gal)	8.31 – 9.46	8.37 - 9.23	8.36 - 9.20
VOC Actual (g/L)	91 - 111	113 - 128	109 - 125
VOC Actual (lbs/gal)	0.76 - .93	0.94 – 1.07	0.91 – 1.04
VOC Regulatory (g/L)	290 - 395	315 – 369	316 - 370
VOC Regulatory (lbs/gal)	2.42 - 3.07	2.63 - 3.08	2.64 - 3.09
Volatiles wt. %	64.83 – 81.38	65.34 - 78.07	66.62 – 78.88
Water wt. % Exempt wt. %	55.29 – 71.83 0	53.84 – 66.56 0	55.47 – 67.73 0
Water vol. %	62.77 – 72.30	59.68 – 67.31	61.23 – 68.46
Exempt vol. %	0	0	0

EQUIPMENT CLEANING

Clean the gun using water in a suitable gun-cleaning machine. For gravity feed guns unscrew the paint cup (and filter if fitted) and rinse separately. Rinse gun through with clean water. Finally, spray through with clean *Aquabase* Plus thinner P980-5000 and ensure that the gun is fully dry before storing or further use. If using an Automatic Gun Cleaning Machine with *Aquabase* Plus Gun Wash P980-8212, dis-assemble gun and place in waterborne gun cleaning machine as per manufacturer's instructions. After the cleaning cycle, clean off the gun parts and rinse with water. Assemble gun and spray through with *Aquabase* Plus thinner P980-5000. Ensure gun is fully dry before storing or further use

WASTE DISPOSAL

Store waterborne and solvent borne waste separately. A competent agent with appropriate certification must handle all waterborne wastes. Wastes must be disposed in accordance with all Federal, State, Provincial and local laws and regulations. Blended to spray *Aquabase* Plus Basecoat with P210-9120 activator has a flash point above 200°F and may be disposed in the waterborne waste stream intended for waterborne basecoat. The waste disposal facility should be informed that the waste stream contains isocyanates. P210-9120 activator handled alone should be disposed in the solvent borne waste stream.

For further information please contact:

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