



Technical Bulletin

DX1999 Textured Finish Repair System

ABT1999

AQUABASE® Plus textured finish is designed to provide a simple refinishing process for textured plastics. The textured finish system is a combination of components from the VIBRANCE COLLECTION® along with engine bay ancillaries products. Once mixed, *Aquabase* Plus textured finish is capable of providing an accurately matched finish on textured plastic body parts.

PREPARATION OF SUBSTRATE



Before and after any sanding operation, the substrate must be thoroughly cleaned and degreased by using SWX350 H₂O-SO-CLEAN™ Waterborne Pre-Cleaner. Apply liberally with a clean cloth and wipe dry with another. Be sure to wipe the cleaner off completely and do not let it dry on the surface. If it dries prior to removal, re-wet the surface again and dry off completely.



Textured *Aquabase* Plus system may be applied over most automotive plastics after proper preparation and cleaning. Bare plastics must be cleaned with the ONECHOICE® Plastic Prep system and primed or sealed before application of the Textured *Aquabase* Plus. Painted surfaces must be lightly abraded with a fine gray scuff pad followed by a final cleaning with SWX350.

MIXING – Aquabase Plus Textured System

Making Textured System Ready to Spray

VWM5556 Waterborne Mid Coat	70 % by weight
P935-1135 Engine Bay Basic	30 % by weight
DX1999 Texture Additive	10 % by weight

Stir Well Before Activating and Thinning

P210-9120 Activator	15 % by weight
P980-5000 Thinner	10 % by weight

Stir Well After Activating and Thinning

Mix Table for Aquabase Plus Textured System

The Parts (Grams) are CUMULATIVE . DO NOT TARE / ZERO OUT THE SCALE BETWEEN ADDITIONS.						
VWM5556 Waterborne Mid Coat	P935-1135 Convertor	DX1999 Texture Additive	STIR WELL	P210-9120 Activator	P980-5000 Thinner	Approximate Ready to Spray
Parts (Grams)	Parts (Grams)	Parts (Grams)		Parts (Grams)	Parts (Grams)	oz.
69.0 (61.3)	98.7 (87.6)	107.6 (95.5)		123.3 (109.4)	133.1 (118.2)	4 oz.
138.0 (122.5)	197.4 (175.2)	215.2 (191.0)		246.5 (218.9)	266.2 (236.3)	8 oz.
207.1 (183.8)	296.1 (262.9)	322.8 (286.5)		369.8 (328.3)	399.4 (354.5)	12 oz
276.1 (245.1)	394.8 (350.5)	430.4 (382.0)		493.1 (437.7)	532.5 (472.7)	16 oz
414.1 (367.6)	592.2 (525.7)	645.5 (573.0)		739.6 (656.6)	798.7 (709.0)	24 oz
552.1 (490.1)	789.6 (700.9)	860.7 (764.1)		986.2 (875.4)	1065.0 (945.4)	32 oz

Note: Do Not strain the textured mixture before application. If using a disposable paint cup systems, be sure to remove all strainers.

POTLIFE AND VISCOSITY

<i>Potlife:</i>	1 hour at 70°F / 20°C
<i>Spray viscosity:</i>	24 - 30 seconds, DIN4 70°F / 21°C

APPLICATION:

<i>HVLP/ Compliant Spraygun:</i>	1.2 - 1.4 mm
<i>Spray pressure:</i>	Refer to manufacturer's recommendation for inlet air pressure.
<i>Application:</i>	Apply two to three single light coats to achieve the desired appearance. Total film thickness of 0.5 - 1.0 mils

FLASH OFF:

For optimum process times, blow dry between coats.

RECOAT:

After the final coat of textured finish has been applied and flashed off, apply the un-textured waterborne basecoat color and clear coat to complete the repair.

TECHNICAL DATA:

RTS Combinations

VWM5556 : P935-1135 : DX1999 :
P210-9120 : P980-5000

Applicable Use Category	Other
Wt. Ratio:	70 : 30: 10 : 15 : 10
Density (g/L)	997
Density (lbs/gal)	8.32
VOC Actual (g/L)	85
VOC Actual (lbs/gal)	0.70
VOC Regulatory (g/L)	228
VOC Regulatory (lbs/gal)	1.90
Volatiles wt. %	72.5
Water wt. %	63.4
Exempt wt. %	0.0
Water vol. %	63.3
Exempt vol. %	0.0
Volume solids %	27.5
Sq. Ft. Coverage 100% Transfer Efficiency @ 1 mil	441

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