



PDS N5.3.2

October 2021

AQUABASE[®] PLUS

P989- Waterborne Basecoat

PRODUCT DESCRIPTION

AQUABASE[®] Plus Waterborne Basecoat is a high performance waterborne basecoat mixing scheme that significantly reduces solvent emissions into the environment and complies with all current legislative requirements.

Aquabase Plus is part of a complete product system offering comprehensive basecoat color matching (metallic, pearls, solid color basecoat and special effect finishes), it has excellent coverage and fade-out capability, maintaining bodyshop productivity and profitability.

Coupled with the high quality of the NEXA AUTOCOLOR[®] brand, the *Aquabase Plus* system delivers excellent gloss, appearance and durability. Easy to apply, this simple and flexible system is capable of being used across a wide range of ambient conditions.

Aquabase Plus waterborne color system is also capable of producing engine bay color as well as interior color. For additional information, see *Aquabase Plus* product bulletins PDS N5.2.1 for engine bay color and PDS N6.16C for interior color.

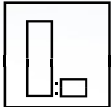
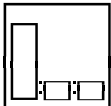
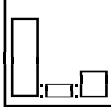
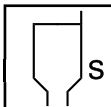
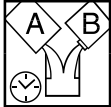

- **Excellent Coverage = less coats, materials savings**
- **Easy Application = consistent results**
- **Fast Dry = improved process times**
- **Excellent Color Match = customer satisfaction**

Products	
P989-xxxx	<i>Aquabase Plus</i> Basecoat Color
P980-5000	<i>Aquabase Plus</i> Thinner
P980-5085	High Temp / Low Humidity Thinner
P935-1250	Adjuster
P935-1255	Modifier
SWX350	H ₂ O-SO-CLEAN [®] Waterborne Pre-Cleaner

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY

Aquabase Plus Basecoat


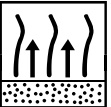
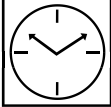
PROCESS

MIX RATIO   	<table border="1"> <tr> <td> P989-xxxx Basecoat Color P980-5000/5085 Thinner* </td><td> 1 part 10% by volume for solid color 20% by volume for metallic / pearl color 30% by volume for tinted mid-coat color </td></tr> <tr> <td> P989-xxxx Basecoat Color P935-1250 Adjuster†) P935-1255 Modifier‡ (optional) </td><td> 1 part 10% by volume for solid color 5% by volume </td></tr> <tr> <td> P989-xxxx Basecoat Color P935-1250 Adjuster† P935-1255 Modifier‡ (optional) P980-5000/5085 Thinner* </td><td> 1 part 10% by volume for metallic/pearl color 5% by volume + 10% by volume for metallic/pearl color </td></tr> <tr> <td> P989-xxxx Basecoat Color P935-1250 Adjuster† P935-1255 Modifier‡ (optional) P980-5000/5085 Thinner* </td><td> 1 part 10% by volume for tinted mid coat color 5% by volume + 20% by volume for tinted mid coat color </td></tr> </table> <p>*P980-5085 is for use in high heat, low humidity conditions only.</p> <p>†P935-1250 Adjuster has been developed to enhance the <i>Aquabase Plus</i> system for leading edge parts such as bumpers and fascias. It does not affect color or potlife. Do Not add more than 10% of this additive. Reduce with P980-5000 as needed to obtain 23-28 seconds DIN4. Final reduction with P980-5000 may vary from 0 - 30%.</p> <p>‡P935-1255 Modifier is designed to be used with P935-1250 Adjuster. When used together this system will provide <i>Aquabase Plus</i> with the best protection against stone chipping. It is recommended for vehicles that are exposed to extreme driving conditions such as gravel roads. It Does not affect color, however potlife is reduced to approximately 1 hour. Do Not add more than 5% of P935-1255 to basecoat color. Reduce with P980-5000 as needed to obtain 23 - 28 seconds DIN4. P980-5000 may vary from 10% -40%.</p>	P989-xxxx Basecoat Color P980-5000/5085 Thinner*	1 part 10% by volume for solid color 20% by volume for metallic / pearl color 30% by volume for tinted mid-coat color	P989-xxxx Basecoat Color P935-1250 Adjuster†) P935-1255 Modifier‡ (optional)	1 part 10% by volume for solid color 5% by volume	P989-xxxx Basecoat Color P935-1250 Adjuster† P935-1255 Modifier‡ (optional) P980-5000/5085 Thinner*	1 part 10% by volume for metallic/pearl color 5% by volume + 10% by volume for metallic/pearl color	P989-xxxx Basecoat Color P935-1250 Adjuster† P935-1255 Modifier‡ (optional) P980-5000/5085 Thinner*	1 part 10% by volume for tinted mid coat color 5% by volume + 20% by volume for tinted mid coat color
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POTLIFE & VISCOSITY  	<p>Viscosity: 23 - 28 seconds DIN4 at 70°F (21°C)</p> <p>Optional Activator: After activation, additional thinner may be required to bring the color into the 23 - 28 second sprayable viscosity range.</p> <table border="1"> <tr> <td> Solid Colors: Most solid colors give the best balance of application, opacity and drying when reduced at 10% with thinner. At high temperatures above 95°F (35°C) an additional 5 - 10% thinner may be added to help with application and overspray absorption. </td><td> Metallic Colors: Most metallic colors will give the best balance of application, opacity and drying when reduced at 20% with thinner. At temperatures above 95°F (35°C), an additional 10 - 15% thinner may be added to help with application, metallic orientation and overspray absorption. </td></tr> </table> <p>Pot Life: Activated, 1 hours Un-Activated, 90 days stored in sealed plastic containers.</p> <p>Always strain before use (nylon 125 micron is recommended).</p>	Solid Colors: Most solid colors give the best balance of application, opacity and drying when reduced at 10% with thinner. At high temperatures above 95°F (35°C) an additional 5 - 10% thinner may be added to help with application and overspray absorption.	Metallic Colors: Most metallic colors will give the best balance of application, opacity and drying when reduced at 20% with thinner. At temperatures above 95°F (35°C), an additional 10 - 15% thinner may be added to help with application, metallic orientation and overspray absorption.						
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SPRAYGUN & AIR PRESSURE 	<p>Fluid Tip: 1.2 - 1.4 mm HVLP: 10 PSI cap pressure Compliant: 29 - 40 PSI at the gun</p> <p>For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures.</p> <p>See spray gun setup chart RMABP440 on ppgrefinish.com <i>Aquabase Plus</i> / Technical Data sheets & SDS Index tab for manufacturer's pressure information.</p>								

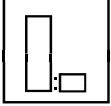
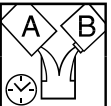

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Aquabase Plus Basecoat

PROCESS

APPLICATION 	Solid Colors: <p>Apply single coats until opacity is achieved</p> <p>Flash off thoroughly between coats</p> <p>A control coat is not required for solid color basecoats.</p>	Metallic Colors: <p>Apply single coats until opacity is achieved.</p> <p>Horizontal Surfaces Apply light control coat(s) onto dry film for even metallic appearance.</p> <p>Vertical Surfaces Apply a single light control coat onto dry film for even metallic appearance. Flash off thoroughly between coats.</p>
FLASH TIME 	Flash off until uniformly matte in appearance Use air movement equipment to accelerate drying as necessary. Choice of drying methods will depend upon the type and size of the repair.	
DRY TIMES 	Wait at least 15 minutes or until uniformly air dry before applying clearcoat or Infrared for 2 - 4 minutes at half power or until matte appearance after final coat. Allow 5 minutes for panel to cool before applying clearcoat.	


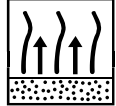

3 STAGE PEARL / SPECIAL EFFECTS PROCESS

MIX RATIO	Groundcoat	Pearlcoat
	P989-xxxx Color 1 part P935-1250 Adjuster† (optional) 10% P935-1255 Modifier‡ (optional) 5% P980-5000/5085* Thinner 10%	P989-xxxx Color 1 part P935-1250 Adjuster† (optional) 10% P935-1255 Modifier‡ (optional) 5% P980-5000/5085* Thinner 20%
*P980-5085 is for use in high heat, low humidity conditions only.		
†P935-1250 Adjuster has been developed to enhance the Aquabase Plus system for leading edge parts such as bumpers and fascias. It does not affect color or potlife. Do Not add more than 10% of this additive. Reduce with P980-5000 as needed to obtain 23-28 seconds DIN4. Final reduction with P980-5000 may vary from 0 - 30%.		
‡P935-1255 Modifier is designed to be used with P935-1250 Adjuster. When used together this system will provide Aquabase Plus with the best protection against stone chipping. It is recommended for vehicles that are exposed to extreme driving conditions such as gravel roads. It Does not affect color, however potlife is reduced to approximately 1 hour. Do Not add more than 5% of P935-1255 to basecoat color. Reduce with P980-5000 as needed to obtain 23 - 28 seconds DIN4. P980-5000 may vary from 10% -40%.		
VISCOSITY & POT LIFE 	Viscosity: 23 - 28 seconds DIN4 at 70°F (21°C) Pot Life: 90 days stored in sealed plastic containers Always strain before use (nylon 125 micron is recommended)	
SPRAYGUN & AIR PRESSURE 	Fluid Tip: 1.2 - 1.4 mm HVLP: 10 PSI cap pressure Compliant: 29 - 40 PSI at the gun For best overall results, refer to the spray gun manufacturer's recommendation for optimum inlet air pressures. See spray gun setup chart RMABP440 on ppgrefinish.com Aquabase Plus / Technical Data sheets & SDS Index tab for manufacturer's pressure information.	

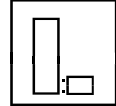
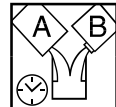

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Aquabase Plus Basecoat

3 STAGE PEARL / SPECIAL EFFECTS PROCESS

APPLICATION	Metallic Ground Coat	Tinted Mid Coat
	<p>Apply single coats to opacity. Flash off thoroughly between coats. Avoid heavy application and excessive film builds. Use air movement equipment to accelerate drying as necessary. Choice of drying methods will depend upon the type and size of the repair. A control coat is not required for solid color basecoats.</p>	<p>Horizontal Surfaces Apply light coats based on color check panels. Flash off thoroughly between coats.</p> <p>Vertical Surfaces Apply single light coats based on color check panels. Flash off thoroughly between coats. The pearl color layer is not designed to give opacity.</p>
FLASH TIME	Flash off until uniformly matt in appearance	
		
DRY TIMES	Metallic Ground Coat	Tinted Mid Coat
	Wait until ground coat is uniformly dry before applying pearlcoat.	Wait until pearl coat is uniformly dry before applying clearcoat. Approximately 15 minutes


3 STAGE TINTED MID COAT PROCESS

FLASH TIME	Metallic Ground Coat	Tinted Mid Coat
	<p>P989-xxxx Color 1 part P935-1250 Adjuster† (optional) 10% P935-1255 Modifier‡ (optional) 5% P980-5000/5085* Thinner 20-30%</p>	<p>P989-xxxx Color 1 part P935-1250 Adjuster† (optional) 10% P935-1255 Modifier‡ (optional) 5% P980-5000/5085* Thinner 20%</p>
<p>*P980-5085 is for use in high heat, low humidity conditions only.</p> <p>†P935-1250 Adjuster has been developed to enhance the <i>Aquabase Plus</i> system for leading edge parts such as bumpers and fascias. It does not affect color or potlife. Do Not add more than 10% of this additive. Reduce with P980-5000 as needed to obtain 23-28 seconds DIN4. Final reduction with P980-5000 may vary from 0 - 30%.</p> <p>‡P935-1255 Modifier is designed to be used with P935-1250 Adjuster. When used together this system will provide <i>Aquabase Plus</i> with the best protection against stone chipping. It is recommended for vehicles that are exposed to extreme driving conditions such as gravel roads. It Does not affect color, however potlife is reduced to approximately 1 hour. Do Not add more than 5% of P935-1255 to basecoat color. Reduce with P980-5000 as needed to obtain 23 - 28 seconds DIN4. P980-5000 may vary from 10% -40%.</p>		
VISCOSITY & POT LIFE	<p>Viscosity: 23 - 28 seconds DIN4 at 70°F (21°C)</p> <p>Pot Life: 90 days stored in sealed plastic containers</p> <p>Always strain before use (nylon 125 micron is recommended)</p>	
		
SPRAYGUN & AIR PRESSURE	<p>Fluid Tip: 1.2 - 1.4 mm</p> <p>HVLP: Maximum of 10 psi cap pressure</p> <p>Compliant: 29 - 40 psi at the gun</p> <p>Refer to gun manufacturer's recommended air pressure. See spray gun setup chart RMABP440 on ppgrefinish.com <i>Aquabase Plus</i> / Technical Data sheets & SDS Index tab for manufacturer's pressure information.</p>	
		

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Aquabase Plus Basecoat

3 STAGE TINTED MID COAT PROCESS

APPLICATION	Metallic Ground Coat	Tinted Mid Coat
	<p>Apply single coats to opacity.</p> <p>Horizontal Surfaces Apply a light control coat onto dry film for even metallic appearance.</p> <p>Vertical Surfaces Apply a single light control coat onto dry film for even metallic appearance. Flash off thoroughly between coats.</p>	<p>Apply single light coats based on color check panels.</p> <p>Flash off thoroughly between coats. The mid coat layer is not designed to give opacity.</p> <p>Flash off the mid coat until it is uniformly dry before applying clearcoat Approximately 15 minutes A control coat is not required for solid color basecoats.</p>

BLENDING / WET BED

MIX RATIO	<p>P990-8999 Clear Adjuster 4 parts</p> <p>P980-5000 / P980-5085 Thinner* 1 part</p>	
	<p>For use as a blending additive: Add up to 1 equal part of the P990-8999 mixture to 1 part of ready to spray color and fade into the prepared blend panel.</p> <p>Or</p> <p>For use as a wet bed: Apply 1 medium light coat of the P990-8999 mixture to the blend panel and/or the entire repair panel and allow to dry. It will be milky blue when wet but will dry translucent. Once dry, apply color. Be sure that wherever the wet bed material has been applied, it is completely covered with either basecoat or clearcoat.</p> <p><small>*P980-5085 is for use in high heat, low humidity conditions only.</small></p>	

METALLIC, 2 STAGE PEARL AND SOLID COLOR BASECOAT FADE OUT PROCESS

Preparation

Prepare the repair area in the appropriate Spectral Grey undercoat (SG01-SG07) as recommended on the color formula. Where no Spectral Grey is specified SG05 should always be selected. Spectral Grey undercoat should be applied and flashed off in accordance with the appropriate PDS.

If the repair area is primed, sand with P800 wet or P600 dry. For rub-throughs to bare metal, apply P565-9081 or 9086 before topcoating. Do not apply directly over etch primer.

Where an overspray edge is created from the use of a wet on wet sealer, the repair area should be de-nibbed to produce a feather edge using P800 wet or dry paper taking care to remove all sealer overspray.

The area into which blending is done should be abraded with a Gold/Ultrafine scuff pad or P800 or finer wet. Clean all sanded areas with ONECHOICE® SWX350 H₂O-So-Clean Waterborne Cleaner.

Complete Panel Repair

Mask out adjacent panel if necessary. Apply basecoat to repair areas as normal. Remove any temporary masking and tack rag off. Fade further onto the adjoining panel. Apply final control coat for metallic or pearl colors as normal. Allow to dry uniformly before applying clearcoat.

Spot Repair

Metallic and 2-Stage Pearlescent Basecoat:

Paint prepared area to cover the primed area. Reduce pressure at gun and fade further into surrounding area. Flash off basecoat until uniformly dry. Apply the final control coat before applying clearcoat. Use air movement equipment to accelerate drying as necessary.

Solid Color Basecoat:

Paint prepared area to obliterate primed area fading each coat further into the surrounding prepared area. Flash-off the basecoat until uniformly dry before applying clearcoat. For compliant guns apply as normal and when fading out, reduce inlet pressure as necessary. The pressure required will depend on the brand of equipment being used.

Aquabase Plus Basecoat

3-STAGE SPECIAL EFFECT COLOR

The transparent nature of 3-Stage colors means that a fade-out process can be more difficult to achieve. Refer to the section below for details on the recommended fade out process. Alternatively, the fade-out process may be avoided either by a complete panel repair, or by using break lines to reduce the size of the area to be painted.

Preparation

Prepare the repair area in the appropriate Spectral Grey undercoat (SG01-SG07) as recommended on the color formula. Where no Spectral Grey is specified then SG05 should always be selected.

The specified Spectral Grey undercoat should be applied and flashed off in accordance with the appropriate PDS.

If the repair area is primed, sand with P800 wet or P600 dry. For rub-throughs to bare metal, apply appropriate etch primer before topcoating. Do not apply directly over Etch Primers.

Where an overspray edge is created, for example from the use of a wet on wet sealer, the repair area should be de-nibbed to produce a feather edge using P800 wet or dry paper taking care to remove all primer overspray.

The area into which blending is done should be abraded with P800 or finer grade wet/dry or an equivalent preparation system. Clean sanded area SWX350 *H₂O-So-Clean*.

Complete Panel Repair

Ensure that a color check has been carried out prior to the repair and that the number of coats required is known.

Groundcoat layer:

Apply groundcoat to the complete panel as normal. Apply to opacity and fade into the adjoining panel as necessary.

Allow to dry uniformly and tack off before applying pearlcoat.

Transparent effect layer:

Apply color to the repair area making sure that the product extends beyond the groundcoat. Each coat should extend further into the repair area to ensure a good fade out edge. Allow to dry uniformly before applying clearcoat.

Spot Repair:

Ensure that a color check has been carried out prior to the repair and that the number of coats required is known.

Groundcoat layer:

Apply groundcoat to obliterate the primed area fading each coat into the surrounding area. Flash off groundcoat until uniformly dry. Tack off before applying transparent effect layer.

Transparent effect layer:

Apply the first coat of color over the groundcoat, extending the repair area beyond the groundcoat edge and further into the surrounding prepared area. Allow the pearl coat to dry naturally. Do not use air movement equipment to accelerate drying.

When applying the remaining coats of color, extend further into the repair area as required. Allow each coat of color to dry fully before further application. Flash-off basecoat until uniformly dry before applying clearcoat.

Aquabase Plus Basecoat

GENERAL PROCESS NOTES

SUBSTRATES

Wet sand with P800 or finer grade wet/dry paper or when dry sanding, use P600 or finer. For the removal of oil and grease, use SXA330 Wax and Grease Remover. For the removal of water soluble salts and sanding residues produced by wet or dry sanding and as a final wipe prior to applying basecoat color, use SWX350 *H₂O-So-Clean*. Do not allow cleaning materials to dry on panel surface.

SPECTRAL GREYS

Use of the specified Spectral Grey will ensure that the minimum volume of basecoat color is used and that the basecoat process time is optimized. The recommendation for which Spectral Grey to use can be found on our color communication systems i.e., e-fiche, Online Color or PAINTMANAGER®. Where there is not Spectral Grey specified, SG05 should always be selected.

BASECOAT MIXING

Mix and store paint in plastic container. **DO NOT** use metal cans. Gently invert cans twice before pouring. Stir immediately after weighing all the ingredients specified. **DO NOT SHAKE**. Cover container if left for any length of time before use.

COLOR IDENTIFICATION AND CHECKING

As with all refinish paint systems, a color check should be carried out before paint application. Ensure mix is thoroughly stirred before carrying out color check. This is particularly important with 3-Stage Pearlescent/Special Effect finishes, because their transparent nature means that a fade-out process can be more difficult.

RECTIFICATION / RECOATABILITY

Visible defects, e.g. dirt, are readily removed provided the basecoat is fully dry and the defect is dry de-nibbed using minimal pressure with P1500 wet/dry paper. It is preferable to remove defects before clearcoating. Once clearcoated, defects can only be removed when into-service times have been reached. See clearcoat data sheet for additional information. An alternative method is to use very fine grade fiber sanding pads either dry, or in combination with a small amount of SXA330 Wax and Grease Remover as a lubricant.

To avoid contamination and to insure maximum adhesion, *Aquabase Plus Basecoat* should be clearcoated after recommended dry times. Note: If basecoat has dried longer than 24 hours, additional basecoat color should be applied before clearcoating.

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 P980-5000 Thinner* and ensure that the gun is fully dry before storing or further use. If using an Automatic Gun Cleaning Machine with SWX100 Waterborne Gun Cleaner, 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 P980-5000 Thinner*. 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 P935-1255 Modifier has a flash point above 200°F (93°C) 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. P935-1255 Modifier when handled alone, should be disposed in the solventborne waste stream.

Aquabase Plus Basecoat

INNOVATING REPAIR SOLUTIONS

RTS Combinations	P989	P989 : P980-5000 / 5085	P989 : P980-5000 / 5085	P989 : P980-5000 / 5085
Volume Ratio	Packaged	1 : 10%	1 : 20%	1 : 30%
Applicable Use Category	Color Coating	Color Coating	Color Coating	Color Coating
VOC Actual (g/L)	53-125	49-114	47-107	46-99
VOC Actual (lbs/Gal)	0.44-1.03	0.41-0.95	0.39-0.89	0.38-0.83
VOC Regulatory (g/L) (less water, less exempts)	257-395	253-399	261-405	266-419
VOC Regulatory (lbs/Gal) (less water, less exempts)	2.11-3.30	2.15-3.33	2.18-3.38	2.22-3.50
Density (g/L)	993-1231	993-1209	993-1191	993-1177
Density (lbs/Gal)	8.29-10.27	8.29-10.09	8.29-9.94	8.29-9.82
Volatiles wt. %	58.5-86.2	61.5-87.5	64.3-88.5	66.6-89.40
Water wt. %	50.7-81.0	54.2-82.5	57.3-83.8	59.9-84.9
Exempt wt. %	0.0	0.0	0.0	0.0
Water vol. %	62.5-81.1	65.7-82.6	68.4-83.9	70.6-85.0
Exempt vol. %	0.0	0.0	0.0	0.0
Solids vol. %	13.1-27.0	11.9-24.5	10.9-22.5	10.1-20.8
Solids wt. %	13.8-41.5	12.5-38.5	11.5-35.7	10.6-33.4
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	n/a	191-393	175-361	162-334

RTS Combinations	P990-8999 : P980-5000 / 5085	P989 : P935-1250 : P935- 1255	P989 : P935-1250 : P980-5000 / 5085 : P935- 1255
Volume Ratio	4 : 1	1 : 10% : 5%	1 : 10% : 10% : 5%
Applicable Use Category	Uniform Finish Coating	Color Coating	Color Coating
VOC Actual (g/L)	90	65-126	61-117
VOC Actual (lbs/Gal)	0.75	0.54-1.05	0.51-0.98
VOC Regulatory (g/L) (less water, less exempts)	379	265-337	268-385
VOC Regulatory (lbs/Gal) (less water, less exempts)	3.16	2.21-2.81	2.24-3.21
Density (g/L)	993	998-1212	998-1188
Density (lbs/Gal)	8.29	8.33-10.05	8.33-9.91
Volatiles wt. %	85.7	59.4-83.6	62.1-84.9
Water wt. %	76.7	50.9-77.1	54.0-78.8
Exempt wt. %	0.0	0.0	0.0
Water vol. %	76.3	61.4-77.6	64.3-79.2
Exempt vol. %	0.0	0.0	0.0
Solids vol. %	13.8	15.3-27.4	14.1-25.2
Solids wt. %	14.3	16.4-40.6	15.1-37.9
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	221	245-439	226-404

Aquabase Plus Basecoat

INNOVATING REPAIR SOLUTIONS

RTS Combinations	P989 : P935-1250 : P980-5000 / 5085 : P935:1255	P989 : P935-1250 : P980-5000 / 5085 : P935:1255	P989 : P935-1250
Volume Ratio	1 : 10% :20% :5%	1 : 10% :30% :5%	1 : 10%
Applicable Use Category	Color Coating	Color Coating	Color Coating
VOC Actual (g/L)	59-110	56-104	52-116
VOC Actual (lbs/Gal)	0.49-0.92	0.47-0.87	0.43-0.97
VOC Regulatory (g/L) (less water, less exempts)	272-388	276-389	252-333
VOC Regulatory (lbs/Gal) (less water, less exempts)	2.27-3.24	2.30-3.25	2.10-2.78
Density (g/L)	998-1173	998-1161	996-1212
Density (lbs/Gal)	8.33-9.79	8.33-9.69	8.31-10.11
Volatiles wt. %	64.5-86.0	66.6-87.0	60.4-86.0
Water wt. %	56.8-80.2	59.2-81.4	52.9-80.9
Exempt wt. %	0.0	0.0	0.0
Water vol. %	66.8-80.6	68.9-81.8	64.2-81.1
Exempt vol. %	0.0	0.0	0.0
Solids vol. %	13.0-23.3	12.1-21.7	13.3-25.9
Solids wt. %	14.0-35.5	13.0-33.4	14.0-39.6
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	208-373	194-348	213-415

RTS Combinations	P989 : P935-1250 : P980-5000 / 5085	P989 : P935-1250 : P980-5000 / 5085	P989 : P935-1250 : P980-5000 / 5085
Volume Ratio	1 : 10% : 10%	1 : 10% : 20%	1 : 10% : 30%
Applicable Use Category	Color Coating	Color Coating	Color Coating
VOC Actual (g/L)	49-108	47-101	44-95
VOC Actual (lbs/Gal)	0.41-0.90	0.39-0.84	0.37-0.79
VOC Regulatory (g/L) (less water, less exempts)	255-388	259-393	262-393
VOC Regulatory (lbs/Gal) (less water, less exempts)	2.13-3.24	2.16-3.28	2.19-3.28
Density (g/L)	996-1194	996-1178	996-1165
Density (lbs/Gal)	8.31-9.96	8.31-9.83	8.31-9.72
Volatiles wt. %	63.2-87.2	65.6-88.1	67.7-89.0
Water wt. %	56.0-82.3	58.8-83.5	61.2-84.5
Exempt wt. %	0.0	0.0	0.0
Water vol. %	67.0-82.5	69.4-83.7	71.4-84.5
Exempt vol. %	0.0	0.0	0.0
Solids vol. %	12.2-23.7	11.2-21.9	10.4-20.3
Solids wt. %	12.8-36.8	11.9-34.4	11.0-32.2
Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency	196-380	180-351	167-326

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VOC COMPLIANCE

To ensure accurate mixing, best performance & VOC compliance:

- Do not add extra hardener, thinner or change the recommended mixing ratio.
- Do not use hardeners or thinners that are not specific in this process summary.

HEALTH AND SAFETY

See Safety Data Sheet and Labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDSs of all the components since the mixture will have the hazards of all of its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statement listed on label. Statement and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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