ENVIROBASE®
HIGH PERFORMANCE

Product Information

EC800 Ultra Fast 2.1 Clearcoat

Product Description

ENVIROBASE® High Performance EC800 is an ultra fast, high gloss 2.1 VOC highly productive clearcoat designed specifically for use with *Envirobase* High Performance basecoats. This clearcoat, with its no bake requirement and zero flash between coats, dramatically reduces cycle times while maintaining the quality and appearance required by high production shops. From an environmental standpoint, the low 2.1 VOC of EC800 Clearcoat along with the high solids resin also decreases clearcoat material usage and therefore greatly reduces the overall VOC emissions.

Preparation of Substrate

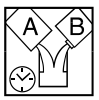


- In all cases, wash all surfaces to be painted with soap and water, then apply the appropriate ONECHOICE® cleaner. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.
- Wet sand with US 500-600 / European P800-P1200 grade paper or dry sanding with US 400-500 / European P600-P800 grade paper.
- Wash off residue and dry thoroughly before re-cleaning with appropriate *OneChoice* substrate cleaner. The use of a tack rag is recommended.

APPLICATION GUIDE:

Mixing Ratio for EC800

EC800: **4 vols**
ECH8075/ECH8095: **1 vol**
ECA83/D87xx/DT18xx/SLV898: **1 vol**



Refer to PAINTMANAGER® formula software for exact mix by weight volumes.

Pot Life at 70°F (21°C): with ECA83 Reducers 1-1.5 hours
with D87xx/DT18xx/SLV898 Reducers: 2 hours

Hardener:
ECH8075 Clearcoat Hardener
ECH8095 Clearcoat Hardener - Slow

Accelerated Reducer:
ECA83 Normal 70-85°F (21-29°C)

Thinner:
D8764 Fast Compliant Thinner 60-70°F (16-21°C)
D8774 Medium Compliant Thinner 70-77°F (21-25°C)
D8767 Slow Compliant Thinner 77-95°F (25-35°C)
DT1845 Compliant Reducer Normal 60-70°F (21-25°C)
DT1850 Compliant Reducer Medium 70-77°F (21-25°C)
DT1855 Compliant Reducer Slow 77-95°F (25-35°C)
SLV898 Low VOC Retarder*

* Thinner selection may be dependent on temperature and or size of repair. For use in extreme temperatures +95°F/+35°C, SLV898 may be used as a replacement up to one full part for D8767 or DT1855 thinners. For VOC data and additional information, see *OneChoice* product bulletin OC-17.

Optional Additives:

SLV814 Universal Flexibilizer: add 10% to RTS volume
SLV73 Fisheye Eliminator: add 1 oz. to RTS quart

When used on plastic parts, EC800 does not require the use of SLV814 Universal Flexibilizer. However, for very flexible or leading edge parts such as bumper covers and fascias, the addition of SLV814 will improve overall flexibility.
Note: For flattening recommendations, see *OneChoice* bulleting OC-7.

Spraygun Set-up and Pressure:

HVLP: 10 maximum psi at the cap
Fluid Tip: 1.3-1.5 mm
Spray Viscosity: 12-14 seconds DIN 4 at 70°F (21°C)

Note: For best overall results, refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.

Application:

Apply: 2 medium wet coats.

Film Build:

Minimum Dry: 2.0 mils
Maximum Dry: 3.0 mils
Recommended film build per coat wet: 2.0-2.5 mils
Recommended film build per coat dry: 1.0-1.5 mils

Flash Off at 70°F (21°C):

No flash required

Drying Times:

Dust-free: 10-15 minutes at 70°F (21°C)

Air Dry to Re-assemble: 1 hour at 70°F (21°C)

Force Dry: 10 minutes at 120°F (49°C) (add 3-5 minutes for ECH8095)

Tape Time: 1 hour at 70°F (21°C)

IR (Infrared): N/A

All force dry times are quoted for surface temperature. Additional time must be allowed during force dry to allow surface to reach recommended temperature.

Overcoat / Recoat / Polishing:

Overcoat/Recoat Time: 2-3 hours at 70°F (21°C) air dry or after force dry for 10 minutes at 120°F (49°C) metal temperature and cool down for one hour. EC80 must be sanded before recoating with primer, color or clear.

Grade wet: US 500-600 / European P800-P1200
Grade dry: US 400-500 / European P600-P800

Overcoat with: *Envirobase* High Performance Basecoat, primer, color or clear

Polishing: 30-45 minutes. Polishing is not normally required. If, however, polishing is required to remove minor dirt nibs, wet sand with P1500 wet and follow normal polishing procedures.

Performance Guidelines:

- Allow basecoat to flash off for 15 minutes (but no longer than 24 hours) before applying EC800, If the basecoat dries longer than 24 hours, additional basecoat must be applied before clearcoating. The timing will depend on thickness and temperature.

Fading Out EC800
After spot repairing. Use *OneChoice* SXA840 blending solvent and apply starting from the outside of the repair moving towards the center of the repaired are to lose the clearcoat blend edge.

Technical Data:

RTS Combinations	EC800 : ECH80xx : ECA83	EC800 : ECH80xx : D87xx / DT18xx	EC800 : ECH80xx : ECA83 +SLV814	EC800 : ECH80xx : D87xx/ DT18xx + SLV814
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating (Flexed)	Clear Coating (Flexed)
Weight Ratio:	4 : 1 : 1	4 : 1 : 1	4 : 1 : 1 +10%	4 : 1 : 1 +10%
VOC Actual (g/L)	118	101-105	111	96-101
VOC Actual (lbs./ US gal.)	0.99	0.84-0.88	0.93	0.80-0.84
VOC Regulatory (less water, less exempt (g/L)	230-249	210-228	223-240	203-219
VOC Regulatory (less water, less exempt (lbs./ US gal.)	1.92-2.08	1.75-1.90	1.86-2.00	1.69-1.83
Density (g/L)	1073-1093	1059-1119	1087-1105	1075-1129
Density (lbs./ US gal)	8.95-9.12	8.84-9.34	9.07-9.22	8.97-9.42
Volatiles wt.%	61.5-65.2	62.3-66.1	62.8-66.1	63.6-66.9
Water wt.%	0.1	0.1	0.1	0.1
Exempt wt.%	50.4-54.4	52.7-56.8	52.4-56.0	54.6-58.1
Water vol.%	0.1	0.1	0.1	0.1
Exempt vol.%	48.6-52.9	50.0-54.4	50.0-53.9	51.3-55.3
RTS Solids vol.%	33.6-37.5	33.5-37.4	33.4-36.9	33.3-36.9
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	539-602	538-600	535-592	534-592

HEALTH AND SAFETY

See Material 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 MSDS of all the components, since the mixture will have the hazards of all 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 MSDS 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 MSDS.
- 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.
- 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 general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning systems listed on label. Statements 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, result, 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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PPG Automotive Refinish
19699 Progress Drive
Strongsville, OH 44149
800.647.6050

Follow us online:

www.ppgrefinish.com

PPG Canada Inc.
2301 Royal Windsor Drive, Unit #6
Mississauga, Ontario L5J 1K5
888.310.4762

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