
Product Information

Interior Color Repair System

Product Description

ENVIROBASE® High Performance Interior Color System is designed to provide a simple refinishing process for interior plastics. Dedicated interior colors are provided as part of the PPG PAINTMANAGER™ software or by accessing the PPG On-Line Color System.

Envirobase High Performance Interior Color System colors are formulated with the same mixing tinters used for external basecoat colors. Once converted, activated and thinned, *Envirobase* High Performance Interior Color is capable of providing an accurately matched finish to the OE finish on interior 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.



Envirobase High Performance Interior color may be applied over most automotive interior plastics after cleaning with SWX350 H₂O-So-Clean and lightly abrading with a fine gray scuff pad followed by a final cleaning with SWX350 H₂O-So-Clean.

APPLICATION GUIDE:

Mixing - Internal Color (formulas containing T511 Converter)

Making Ready to Spray

Interior Color 100 parts
Stir before activating and thinning

T584 Activator 15 parts
T494 Thinner 15-20 parts

Sprayable viscosity should be between 18-21 seconds, Din 4 cup. If necessary, a small amount of additional thinner (less than 5%) may be added to improve sprayability.

**Mixing - Un-Thinned Pre Mixed Interior Color
(formulas not containing T511 Converter)**

Making Color Ready to Spray From Pre Mixed Color

Basecoat Color 70 parts/grams
T511 Converter 30 parts/grams

Stir before activating and thinning

Making Ready to Spray

Activate and thin color with T584 @ 15% by weight and reduce with T494 @ 20% by weight.

Converted Interior Color 100 parts/grams
T584 Activator 15 parts/grams (15% by weight)
T494 Thinner 20 parts/grams (20% by weight)

The parts are **CUMULATIVE**.

DO NOT TARE/ZERO OUT THE SCALE BETWEEN ADDITIONS.

Mixed Color	T511 Converter		T584 Activator	T494 Thinner	Approx. RTS Volume
Parts	Parts	STIR WELL	Parts	Parts	Oz.
70	100		115	135	4 oz.
140	200		230	270	8 oz.
280	400		460	540	16 oz.
420	600		690	810	24 oz.
560	800		920	1080	32 oz.
700	1000		1150	1350	40 oz.
840	1200		1380	1620	48 oz.

Sprayable viscosity should be between 18-21 seconds, Din 4 cup. If necessary, a small amount of additional thinner (less than 5%) may be added to improve sprayability.

MIXED PRODUCT DETAILS



Pot Life: 1 hour at 70°F (21°C)



Spray Viscosity: 18-21 seconds DIN4 70°F (21°C)

APPLICATION



HVLP Spraygun: 1.2 - 1.4 mm
Refer to manufacturer's recommendation for inlet air pressure.



Application: Apply 2-3 single coats to give a dry film thickness of 0.5 - 1.0 mils.

FLASH OFF



Blow dry between coats for optimum process times. After the final coat, allow 15-20 minutes at 70°F (21°C) before handling

TECHNICAL DATA

RTS Combinations	Internal Color	Interior Color : T584 : T494	Interior Color : T584 : T494
Applicable Use Category	Single Stage Coating	Single Stage Coating	Single Stage Coating
Weight Ratio:	Packaged	100 : 15 : 15	100 : 15 : 20
Density (g/L)	997-1153	1005-1124	1006-1120
Density (lbs./gal.)	8.31-9.61	8.38-9.37	8.38-9.33
VOC Actual (g/L)	84-101	100-113	96-109
VOC Actual (lbs./gal.)	0.70-0.84	0.83-0.94	0.80-0.91
VOC Regulatory (g/L)	265-346	281-335	282-336
VOC Regulatory (lbs./gal.)	2.21-2.88	2.34-2.79	2.35-2.80
Volatiles wt. %	63.57-82.30	63.61-78.05	64.96-78.86
Water wt. %	55.20-73.93	53.77-68.17	55.41-69.20
Exempt wt. %	0	0	0
Water vol. %	63.68-73.73	60.47-68.62	62.02-69.64
Exempt vol. %	0	0	0

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.
- 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 waterborne Interior Color System with T581 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. T581 activator handled alone should be disposed of in the solvent borne waste stream.
- 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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