

Process Data Sheet

September 2023

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY



TCB105 - Aquabase Plus 3-coat Color Renault EQB «Orange Valencia»

<i>Product</i>	<i>Description</i>
WB-RENEQB	Valencia Orange
FAG4/184	Transparent Blender
<i>Process also requires</i>	
P980-5000	Aquabase Plus Thinner
P980-5050	Aquabase Plus Thinner Slow
P935-1250	High performance Additive
P210-9115	Aquabase Plus activator for Engine Bay Basic
P990-8999	Aqua Base Plus Clear Adjuster

Process Description

The colour EQB Orange Valencia is a particularly brilliant and deep orange color, which has extremely clear light reflections and a particularly high depth effect.
This striking colour tone effect is created by a 3-layer paint process using special pigments and toners.
The color has already been developed and is available in Aquabase Plus
However, the previous versions of the Standard formulation and the variants can only be implemented to a limited extent.

Process

1. Repair And Preparation of Substrate

- 1.1 The damaged body work of the vehicle should be repaired using a NEXA AUTOCOLOR® repair and undercoating system for the substrate of the body panels being repaired (Aluminium, Steel, Plastic etc.)
- 1.2 Finish the repair with the recommended SG Spectral Grey Primer shade for the specific colour to be applied This color requires SG 05.
- 1.3 When preparing the substrate suitable colour panels should be prepared alongside for use when checking the colour/effect.

2. Orange Valencia – CHECKING COLOUR MATCH

Please check the color before application. The layer thickness and number of spray coats of the effect / second layer, significantly affect the colour match to the standard paint.

It is *not* recommended to apply more than 3 coats of effect/second layer.

The color formulation Renault EQB Orange Valencia is designed for full panel application but can be used for blending following the special procedure for colour blending.

Details on the processing of the color for full panel application as well as the blending process are described below.

3. Mixing the first and second Base Coat layer

EQB Main Layer:

P998-8993	70 Parts by weight
WB-RENEQB	30 Parts by weight
P992-8964	6 Parts by weight
P998-8991	2 Parts by weight

EQB Second layer / Effect layer

FAG4/184	90 Parts by weight
WB-RENEQB	30 Parts by weight



Process – Weight Chart

Step 1:

MIXING BY WEIGHT:

The weights are cumulative - please do NOT tare the balance between additions.

Total Volume Required ML	P998-8993	WB-RENEQB	P992-8964	P998-8991
100,0	65,5	94,0	99,7	101,6
200,0	130,9	188,0	199,4	203,3
250,0	163,7	235,0	249,2	254,1
300,0	196,4	282,1	299,1	304,9
350,0	229,1	329,1	348,9	355,7
400,0	261,9	376,1	398,7	406,5
450,0	294,6	423,1	448,6	457,3
500,0	327,3	470,1	498,4	508,1
550,0	360,0	517,1	548,3	559,0
600,0	392,8	564,1	598,1	609,8
650,0	425,5	611,1	648,0	660,6
700,0	458,2	658,1	697,8	711,4
750,0	491,0	705,1	747,6	762,2
800,0	523,7	752,1	797,5	813,0
850,0	556,4	799,2	847,3	863,9
900,0	589,2	846,2	897,2	914,7
950,0	621,9	893,2	947,0	965,5
1000,0	654,6	940,2	996,9	1016,3



Process – Weight Chart

Step 2:

MIXING BY WEIGHT:		
The weights are cumulative - please do NOT tare the balance between additions.		
Total Volume Required ML	WB-RENEQB	FAG4/184
100	77,1	102,3
200	154,2	204,5
250	192,8	255,6
300	231,3	306,8
350	269,9	357,9
400	308,4	409,0
450	347,0	460,1
500	385,5	511,3
550	424,1	562,4
600	462,6	613,5
650	501,2	664,6
700	539,7	715,8
750	578,3	766,9
800	616,8	818,0
850	655,4	869,1
900	693,9	920,3
950	732,5	971,4
1000	771,0	1022,5



Process

1. Application of the Main Layer (Step one) in Auqabase Plus
(Full Panel Application)

Mixing ratio:	100 : 10 : 5 parts by weight with P935-1250 and P980-5000 / 5050 + 5% P210-9115
Spray gun setup:	HVLP technology with 1.3 mm nozzle
Spray pressure:	1.7 bar for the application of normal coats
Number of coats:	2 coats until the substrate is completely covered
Flash-off time:	Fastdry or comparable flash-off systems The basecoat must be completely flash-off matt. Alternatively 40° for 8 min.
Effect/Light coat:	1 light/effect coat with 1.2 bar
Flash-off before 2. layer:	5 - 10 minutes at 20 - 23 °C / The basecoat must be completely matt and dried.



PROCESS

2. Application of the second layer (Step two) in Aquabase Plus (Full panel application)

Mixing ratio:	100 : 10 : 15 parts by weight with P935-1250 and P980-5000 /-5050
Spray gun set up:	HVLP technology with 1.3 mm nozzle
Spray pressure:	1.7 bar for the application of normal coats
Number of coats:	2 coats wet-on-wet + light/effect coat in the wet film. Number of spraying coats adapted to the previous test
Flash-off time:	Fast dry or comparable flash-off systems The basecoat must flash off completely matt. Alternatively 40° for 8 min.
Effect/Light coat:	1 lightcoat on top after drying if necessary.



PROCESS

3. Clearcoat application:

Any conventionally drying PPG UHS clearcoat can be used for the final coating.

Please observe the information in the Technical Data Sheets of the respective clearcoat.



PROCESS

Preparation for blending:

Preparation of the substrate in Greymatic G5

Mix and process the primer materials according to the technical data sheets of the respective product



Application of the main layer (Step one) in Aquabase plus (blend)

Mixing ratio:	100 : 10 : 5 parts by weight with P935-1250 and P980-5000 / 5050 + 5% P210-9115
Spray gun setup:	HVLP technology with 1.3 mm nozzle
Spray pressure:	1.7 bar for the application of normal coats
Number of coats:	2 coats until the substrate is completely covered
Flash-off time:	Fastdry or comparable flash-off systems The basecoat must be completely flash-off matt. Alternatively 40° for 8 min.
Effect/Light coat:	1 light/effect coat with 1.2 bar
Flash-off before 2. layer:	5 - 10 minutes at 20 - 23 °C / The basecoat must be completely matt and dried.



Application of the blend with T490 in Aquabase Plus:

Mixing ratio:	100 : 10 : 15 parts by weight with P935-1250 and P980-5000 / 5050
Spray gun setup:	HVLP technology with 1.3 mm
Spray pressure:	1.7 bar for the application
Number of coats:	1 full coat in the blend zone



Application of the second layer (Step two) in Aquabase Plus (Blend)

Mixing ratio:	100 : 10 : 15 parts by weight with P935-1250 and P980-5000 / P980-5050
Spray gun set up:	HVLP technology with 1.3 mm
Spray pressure:	1.7 bar for the application of normal coats
Number of coats:	2 coats wet-on-wet + light/effect coat in the wet film. Number of spraying coats adapted to the previous test
Flash-off time:	Fastdry or comparable flash-off systems The basecoat must flash off completely matt. Alternatively 40° for 8 min.
Effect/Light coat:	1 light fade out coat on top after drying if necessary



INFO:

Try to let the layers flow out over a wide area, otherwise there is a risk that this will become streaky, or visible at certain angles.

Clearcoat application:

Any conventionally drying PPG UHS clearcoat can be used for the final coating.

Please observe the information in the Technical Data Sheets of the respective clearcoat.



VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC.
The VOC content of this product in ready to use form is max. 420g/litre.
Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: www.nexaautocolor.com

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