Product Data Sheet

December 2016

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H1500V

Aquabase® Plus Engine Bay Repair Process

Product	*Description*
P935-1135	WB Engine Bay Basic
P210-9115	Activator for WB Engine Bay Basic
P980-5000	Aquabase® Plus Thinner
P980-5050	Aquabase® Plus Slow Thinner

Product Description

P935-1135 & P210-9115 form part of the new Waterborne Engine Bay Repair Process, designed to simplify repairs to cars where the finish in the Engine Bay area is different to the external finish of the car. The new process delivers considerable time savings, whilst being very simple to use.

For cars where the Engine Bay area is finished in a different colour to the external panels, new Engine Bay colour formulations mixed from the Aquabase Plus mixing basics can be found on colour IT systems. These colours automatically include the addition of P935-1135 WB Engine Bay Basic.

For Engine bay areas finished in a matt version of the glossy external colour, normal Aquabase Plus colours can be converted to an Engine Bay product by adding the WB Engine Bay Basic, stirring and activating with the Activator.

Once activated and thinned the resultant mix is capable of providing an accurately matched finish for engine bay (and other internal) areas, and a recoatable wet-on-wet layer to all external panels that need to be topcoated. This removes the need to undercoat and colour the internal area, and allows internal and external areas to be coated in one step, thus saving time.

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Substrates and Preparation

For maximum durability, with new panels in good quality Electrocoat, it is recommended that the Electrocoat is sanded using Red Scotch-Brite™, leaving it as intact as possible, prior to application of the Engine Bay Colour.

Rub through areas should be coated with Aerosol Rub through primers.

For structural areas of bare metal, it is recommended that either an Etch primer followed by a wet on wet primer - P565-3030, or an Epoxy Primer, be used, prior to the application of Engine Bay colour.

Good preparation is vital in order to obtain the best results from these products

Engine Bay Repair System should **not** be applied directly over Etch Primers P565-713 or P565-9850.

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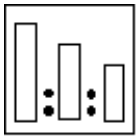
Process for Engine Bay Colours

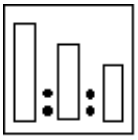


Dedicated Engine Bay colours

Mix the P935-line Engine Bay internal colour in accordance with the colour information on IT systems and stir thoroughly.
Then:-

P935-Engine Bay colour	100 parts
P210-9115	15 parts
Thinner*	15 - 20 parts for solid colours 20 parts for Flake colours

*Choose Thinner according to application temperature and size of repair, 10 parts thinner may be used for double coating:



Conversion of existing colours

Mix the P989-line Aquabase Plus colour in accordance with the colour information on IT systems and stir thoroughly.
Then:-

P989- Aquabase Plus	70 parts
P935-1135	30 parts and stir,
P210-9115	15 parts
Thinner*	15 - 20 parts for solid colours

*Choose Thinner according to application temperature and size of repair, 10 parts thinner may be used for double coating:

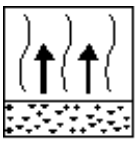
Application Viscosity	18 - 21secs. DIN4
Pot-life	1 hour at 20°C

Fluid Tip:

Gravity Fed:	1.3 - 1.4 mm
Inlet Pressure:	As recommended by spraygun manufacturer. (Normally 2 bar or 30 psi).

Apply one light coat over seam sealer areas - to achieve maximum opacity

Apply 1 double coat or two single coats to give a film thickness of 10-25 microns



5 minutes flash-off between coats if using single coats.

Air-dry at 20°C before topcoating :

Flash-off until fully matt. This will take approx 15 minutes at 20^{O}C before overcoating. Flash off can be assisted by use of air blowers or heat - Fast Aquadry system

Normally P935-line colour does not require flatting and should be directly topcoated. If some dirt inclusion occurs, light dry denibbing can be carried out after 20 minutes using P1200 or finer flatting paper.

TOPCOAT

Areas requiring topcoat can be directly topcoated with Aquabase Plus basecoat + Clearcoat or 2K HS Plus Topcoat (P471).

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GENERAL PROCESS NOTES

PROCESS STEPS - DEDICATED ENGINE BAY COLOUR

For an Engine Bay colour taken from the colour system that includes the Engine Bay Additive.

1. Select the Engine Bay colour using the Engine Bay Colour Directory or Colour Swatch.
2. Using the normal colour retrieval system, mix the Aquabase Plus Engine Bay Colour, which includes the addition of P935-1135 WB Engine Bay Basic.
3. Stir colour thoroughly before activation - see below.
4. Any rub through areas to bare metal should first be primed using P965-908 Rub Through Primer.
5. Apply a light coat of Engine Bay colour to internal edges and sealer areas to maximize coverage. Flash off using air blowers or Aquadry systems.
6. Apply coats of Engine Bay colour to internal areas and any external panels that need a wet on wet surface for topcoat. Use double coats (single coats can be applied if preferred) to reach coverage.
7. Flash off using air blowers or Aquadry systems, until film is fully matt - approx 15 minutes.
8. Apply the topcoat, to external panels as necessary and bake. Engine Bay colours can be overcoated with Aquabase Plus + Clearcoat or 2K HS Plus Topcoat (P471) colour.
9. Normally this Engine Bay system does not require flatting and should be directly topcoated. If some dirt inclusions occur, then light flatting / denibbing can be carried out after 20 minutes using P1200 or finer flatting paper (dry).

The weight of P935-1135, activator and thinner required by certain volumes of mixed colour to produce ready-for-use paint is detailed below. The weights correspond to the mixing ratio: 100 parts Aquabase Plus Engine Bay colour: 15 parts Engine Bay Activator: 15 - 20 parts thinner.
Add suitable stirring stick to container, before taring the scale.
Stir colour thoroughly, do not tare, before adding Activator and thinner. The weights of activator and thinner are **CUMULATIVE –** DO NOT TARE THE SCALE BETWEEN ADDITIONS.

Volume of Engine Bay colour mix	Final ready-for-use volume		Weight of P210-9115 Activator	Weight of Thinner	
Litres	Litres		Grams	Grams to 15 parts	Grams to 20 parts
0.10	0.14	S	116	131	137
0.25	0.35	T	291	320	342
0.40	0.55	I	466	519	547
0.50	0.68	R	582	659	684
0.75	1.02		874	978	1026
1.00	1.37	W	1165	1317	1368
1.50	2.05	E	1747	1976	2052
2.00	2.74	L	2330	2634	2736
2.50	3.42	L	2912	3293	3420

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GENERAL PROCESS NOTES

PROCESS STEPS - CONVERTING AN EXISITING COLOUR

For an Aquabase Plus colour that needs converting to an Engine Bay colour.

1. Select the colour using the Aquabase Plus Colour Directory or Colour Swatch.
2. Using the normal colour retrieval system, mix the Aquabase Plus Colour, and stir thoroughly.
3. Referring to the table below, add the Engine bay basic and stir thoroughly.
4. Continue to activate and thin the Engine Bay Colour, as recommended below.
5. Any rub through areas to bare metal should first be primed using P565-908 Rub Through Primer.
6. Apply a light coat of Engine Bay colour to internal edges and sealer areas to maximize coverage. Flash off using air blowers or Aquadry systems.
7. Apply coats of Engine Bay colour to internal areas and any external panels that need a wet on wet surface for topcoat. Use double coats (single coats can be applied if preferred) to reach coverage.
8. Flash off using air blowers or Aquadry systems until film is fully matt - approx 15 minutes.
9. Apply the topcoat, to external panels as necessary and bake. Engine Bay colours can be overcoated with Aquabase Plus & Clearcoat or 2K HS Plus (P471) colour.
10. Normally this Engine Bay system does not require flatting and should be directly topcoated. If some dirt inclusions occur, then light flatting / denibbing can be carried out after 20 minutes using P1200 or finer flatting paper (dry).

The weight of the activator and thinner required by certain volumes of mixed colour to produce ready-for-use paint is detailed below. The weights correspond to the mixing ratio: 70 parts Aquabase Plus Engine Bay colour: 30 parts Engine Bay Basic: 15 parts Activator: 15 - 20 parts thinner.
Add suitable stirring stick to container, before taring the scale.
Stir colour thoroughly before adding Activator and thinner. The weights of activator and thinner are **CUMULATIVE –** DO NOT TARE THE SCALE BETWEEN ADDITIONS.

Approx Final ready-for-use volume	Weight of Aquabase Plus Colour Mix	Weight of P935-1135		Weight of P210-9115 Activator	Weight of Thinner	
Litre	Grams	Grams		Grams	Grams to 15 parts	Grams to 20 parts
0.10	50	73	S	84	94	98
0.25	125	182	T	209	236	245
0.40	200	291	I	334	377	392
0.50	250	364	R	418	472	491
0.75	375	545		627	707	736
1.00	500	727	W	836	943	981
1.50	750	1091	E	1254	1415	1472
2.00	1000	1454	L	1672	1886	1962
2.50	1250	1818	L	2090	2358	2453

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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 Heath and Safety information please refer to the material Safety Data Sheet, also available at:
http://www.ppg.com/Autocolor_MSDS

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