

Product Data Sheet

May 2009

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V1450V

Waterborne Basecoats for Commercial Transport P961-Line

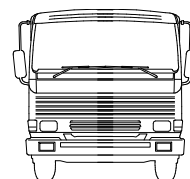
<i>Product</i>	<i>Description</i>
<i>P961Lline</i>	<i>CT Waterborne Basecoat Ready Mix</i>
<i>P935-3006</i>	<i>Waterborne Basecoat Activator</i>
<i>P980-5000</i>	<i>Waterborne Thinner</i>
<i>P980-5050</i>	<i>Hi Temp Waterborne Thinner</i>
<i>P980-6050</i>	<i>Waterborne Precleaner</i>

Product Description

Waterborne Commercial Transport (P961-Line) is a ready mixed range of solid colour, metallic and pearlescent basecoats specifically designed to meet the requirements of the Commercial Refinish Market.

The product has been developed in accordance with European legislation and delivers a VOC of below 420g/l.

When used in conjunction with the relevant Nexa Autocolor compliant Clearcoat, this waterborne system delivers excellent gloss, appearance and durability.



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PROCESS

	<p>Ready-Mix P935-3006 Thinner</p>	<p>Standard</p> <p>3 parts by volume 1 part by volume 0-30% by volume</p> <p>Notes: Shake 3006 before use Activate shortly before use</p>	<p>Large Area</p> <p>6 parts by volume 1 part by volume 0-30% by volume</p>
	<p>22-26 secs DIN 4 cup (at 20°C).</p> <p>Viscosity may be adjusted by addition of P980-5000 or 5050 thinner</p>		
	<p>Pot-life at 20°C Activated – 48 Hours Unactivated – 28 Days</p>		
	<p>Compliant HVLP</p> <p>Gravity -: 1.4 mm Suction -: 1.8-2.0mm Pressure -: 1.0-1.2mm Fluid delivery 280-320 cc/min</p> <p>Air Cap Pressure 0.675 Bar (10 psi.) max</p>		
	<p>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 thinner P980-5000 and ensure that the gun is fully dry before storing or further use.</p>		
	<p>2-3 single coats plus 1 control coat for metallics and micas.</p>		
	<p>Flash off between coats (20°C / 60% Humidity) -: 20-30 mins. or until uniformly dry.</p> <p>DRYING TIME CAN BE GREATLY REDUCED WITH THE USE OF AIRBLOWERS AND / OR FORCE DRY</p>		
	<p>Wait until uniformly dry before clearcoating.</p> <p>For multi-stripping work, it's recommended to force dry prior to masking up.</p> <p>Metal Temperature -: 45°C - 30 mins 60°C - 20 mins</p>		
	<p>If necessary, may be hand denibbed with P1200 wet/dry paper. Ensure basecoat is fully dry and apply minimum pressure whilst denibbing.</p> <p>Recoat times (20°C)-:</p> <p>Minimum - 20 mins</p> <p>Maximum – 72 hours (after which 1 coat of basecoat has to be applied prior to clearcoating)</p>		
<p>Clearcoat</p>	<p>Waterborne Basecoats may be overcoated with Autocolor clearcoats, P190-6690. P190-1250 etc. Refer to relevant PDS for details.</p> <p>Waterborne basecoats can be overcoated up to 48 hours after application.</p> <p>For optimum final appearance tack the basecoat prior to clearcoating.</p>		

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General Process Notes

SUBSTRATES AND PREPARATION

Clean all surfaces with **P980-6050**. Wet flat with P800 or finer, dry machine sand with P360 or finer. Wash off residues and dry thoroughly before re-cleaning with **P980-6050** using one rag for application and another rag for wiping off. The use of a Tack rag is strongly recommended as a final stage.

Apply over the following Nexa Autocolor primer systems-:

P980-6501/2 - Waterborne Epoxies
P580-2920 - High Build Epoxy
P580-350X - Chromate Free Epoxies
P565-1027/8 - 2K Primer Surfacer
P565-755 - Transparent Sealer

Ensure all primers are used as per the relevant TDS.

Nexa Autocolor Commercial Transport Waterborne Basecoat should **never** be used over -:

Wash Primers
Etch Primers
Chromated Epoxy Primers
Acrylic Thermoplastic Finishes

STORAGE AND HANDLING

Nexa Autocolor Commercial Transport Waterborne Basecoat mixed colours, activator, thinners and cleaner should be stored in a cool, dry place away from sources of heat. During storage and transportation, temperatures must be maintained at a minimum of +5C and a maximum of +35C.

Waterborne Basecoat should always be mixed in clean, dry containers and used in clean, dry equipment.

Do not use in mixing vessels or spray equipment that contain solvent residues.

Mixing vessels should ideally be plastic; If metallic they should have an anti-corrosion lining

PERFORMANCE AND LIMITS

Dry film build should be between 15 and 25 microns.

EQUIPMENT CLEANING

After use, clean all equipment thoroughly using a dedicated waterborne cleaner or cleaning equipment.

Ensure all equipment is clean and dry before storage or use.



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: http://www.ppg.com/Autocolor_MSDS

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.

For further information please contact:

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