

# TECHNICAL DATASHEET

October 2023

I0601V



## AQUABASE® PLUS ONE VISIT CONVERTER

Products	Description
P989-line	Mixed Basecoat Colours
P990/991/992/993/994 995/996/998/999-lines	<i>Aquabase Plus Mixing Basics</i>
P950-9000	<i>Aquabase Plus One Visit Converter ST</i>
P950-9100	<i>Aquabase Plus One Visit Converter HD</i>
P935-1451	<i>Performance Blender</i>
P980-5000	<i>Aquabase Plus Thinner</i>
P980-5050	<i>Aquabase Plus High Temperature Thinner</i>
P210-9115	Activator

### PRODUCT DESCRIPTION

The *One Visit Converter P950-9000* and *P950-9100* allows for One Visit in the spray booth, when applying *Aquabase Plus* basecoat.

The process is simple. Apply the first full coat of basecoat to opacity, followed by final control coat into the wet film to achieve a uniform final finish.

*P935-1451 Performance Blender* is a new developed product to be used for blending process applied as a wet full coat in the blend area.

Coupled with high quality *Nexa Autocolor* clearcoats and primers, the *Aquabase Plus* system delivers excellent gloss, appearance and durability.

Easy to apply, this simple and flexible product system is capable of being used across a wide range of ambient conditions.

## SUBSTRATES AND PREPARATION

P989-line should only be applied over:

- *Nexa Autocolor* 2-pack flattable primers/undercoats
- *Nexa Autocolor* 2-pack Wet-on-wet primers.

**NOTE:** On new panels coated in works primer/electrocoat it is recommended that a *Nexa Autocolor* 2-pack primer be applied.

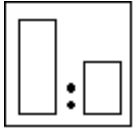

Do not apply over 1K or 2K Wash Etch Primers.

Prepared existing paintwork in sound condition:

- Existing paintwork should first be flatted/abraded.
- Flat with P800 or finer grade dry paper or when dry sanding use P400 or finer.

OR: Pre-sanding Excenter/Da Sander grit P500 followed by Excenter foam disc grit P800.


Plastics: Use the recommended *Nexa Autocolor* system for painting plastics.

<b>PROCESS</b>			
<b>BASECOAT PROCESS</b>			
	<b>2-stage Metallic Pearlescent/Special Effect Colors</b>	<b>2-stage Metallic stage High Chroma Colors(*)</b>	<b>Solid &amp; White Mica/Metallic(*) Colors</b>
	AQ+: 100 parts OVC: 20 parts	AQ+: 100 parts OVC: 15 parts  (*) High chroma color is clean blue, green, and red metallic/mica colors.	AQ+: 100 parts OVC: 5 parts Thinner: 15 parts  (*) Colors with high P990-8900 content. (+50%)
	<b>Optional Mix Ratios for 2CT using hardener/ P210-9115: For the 3CT process, the use of P210-9115 in the following ratios is RECOMMENDED;</b>		
	AQ+: 100 parts Activator P210-9115 : 5 parts Well stirred! OVC: 20 parts Thinner: 5 parts - All parts refer to main material 100 parts!	AQ+: 100 parts Activator: 5 parts Well stirred! OVC: 10 parts Thinner: 5 parts - All parts refer to main material 100 parts!	
	<b>Pot life when using hardener P210-9115 max. 30 min. - After that, formation of flocks starts.</b>		
	<b>P935-1451 Performance Blender</b>  Performance Blender: 100 parts OVC: 20 parts		
	Always filter using nylon filters. (125 microns is recommended)  Pot life of thinned colour: 1 months		
	Conventional/RP STD Temp: 1,2mm Conventional/RP High Temp: 1,3mm  HVLP STD Temp: 1,3mm HVLP High Temp: 1,4mm		

# PROCESS

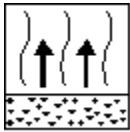
## BASECOAT PROCESS (Continued)

### Metallic and 2-stage Pearlescent/Special Effect Basecoats & Solid Colour Basecoats




**Full Panel:**  
 1.8 bar inlet pressure (Full coat and Control coat)  
 Full Trigger (Full wet uniform coat) followed by  
 1¼-1½ turn out (Control coat) with SATA spraygun  
 2 turn out (Control coat) with Anest Iwata spraygun

**Blend In Process/area:**  
 1.5-1.8 bar inlet pressure  
 Trigger 1¼ turn out through the blend process –  
 1¼ turn out (Control coat)  
 Use reverse technique (spray the adjacent fade-out area first and then the actual repair area afterwards).  
**\*See Blend Process Best Practice Section\***



- Raise temperature to 40°C – 50°C till matt
- Leave it to flash in ambient spray booth temperature and air flow.
- Air assisted low flow blowers mounted in booth in combination with 40°C – 50°C till matt.
- Air assisted low flow blowers mounted in booth at ambient spray booth temperature.

\*NOTE: For all processes using hand or standing blowers, maintain a distance of 1 metre from the panel with a maximum inlet pressure of 2 bar. In case of higher inlet pressure allow a flash-off time of 5-10 minutes before using the Blowers.



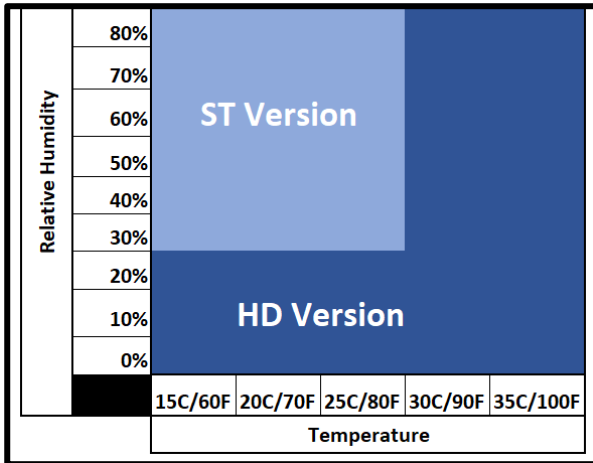
Drying time with IR equipment will vary pending on color as they have different wave length reflections.

## PROCESS

3-STAGE PEARL/SPECIAL EFFECT PROCESS		
	Step 1: P989- Groundcoat	Step 2: P989- Solid/Pearlcoat/Special Effect Colour
	<p>Solid Color: (Step 1)                      AQ+: 100 parts  <u>Optional</u> use Activator P210-9115: 5 parts                      Well stirred!                      OVC: 5 parts                      Thinner: 10 parts</p> <p>Metallic Color: (Step 1)                      AQ+: 100 parts  <u>Optional</u> Use Activator P210-9115: 5 parts                      Well stirred!                      OVC: 20 parts</p>	<p>AQ+: 100 parts                      Thinner: 20 parts</p> <p>RFU hardener ratios can be used optional.</p>
	<p>Conventional/RP STD Temp: 1,2mm                      Conventional/RP High Temp: 1,3mm</p> <p>HVLP STD Temp: 1,3mm                      HVLP High Temp: 1,4mm</p>	
	<p>Apply single coats to opacity.</p> <p>Avoid heavy application and excessive film builds.</p>	<p>Apply single coats based on colour check panels. This product is not designed to give opacity.</p> <p>Flash off thoroughly between coats.</p>
	<p>Flash off until uniformly matt.</p> <p>Use air movement equipment to accelerate drying as necessary, for example Fast Aquadry, floor stands or handguns. Choice of drying method will depend upon repair size and type.</p>	<p>Flash off until uniformly matt.</p> <p>Use air movement equipment to accelerate drying as necessary, for example Fast Aquadry, floor stands or handguns. Choice of drying method will depend upon repair size and type.</p>
	<p>Wait until uniformly dry before applying pearlcoat</p>	<p>Wait until uniformly dry before applying clearcoat.</p>

## GENERAL PROCESS NOTES

### TEMPERATURE AND HUMIDITY RECOMMENDATION CHART:



## BLEND IN TECHNIQUE

When performing a blend process, Performance Blender is needed for most “Critical Colors” like – Silver Metallic and Light Metallic colors

### APPLICATION PROCESS 2CT:

1. Prepare P935-1451 Performance Blender RFU in a separate spray gun or any dispenser system.
2. Apply the Performance Blender on adjacent panel or only in the area to be blended. The Performance Blender need to be applied as a wet uniform layer to enable the pigments/RFU color to get the correct lay-down and metallic orientation.
3. Apply 1 coat one thin coat of RFU color in the repair area, followed by reverse blend in process to opacity. **Avoid heavy layers.** Try to stay away from the panel/car part-edge when applying the blender in the component. A good fade-out of the blender will optimise the result. Blend the fading-out area as smooth as possible using reverse technique.
4. End the process with a light control coat in the blend area.
5. Apply hereafter full panel application process with RFU color on new/repaired panel.

## APPLICATION PROCESS 3CT:

1. Only needed for light metallic colors in step 1: Apply the P935-1451 Performance Blender RFU in the area to be blended. The Performance Blender need to be applied as a wet layer to enable the pigments/RFU color to get the correct lay-down and metallic orientation.

### 2. 3CT Step 1:

3. Apply 1 coat one thin coat of Step 1 RFU color in the repair area, followed by reverse blend in process to opacity. Avoid heavy layers. Blend the fading-out area as smooth as possible using reverse technique.

\*NOTE\* Step 1 RFU Color need to be focused as limited as possible into the adjacent panel

4. End Step 1 RFU color process with a light control coat in the blend area.(If the blend looks smooth, control coat is not needed.)

### 5. 3CT Step 2:

6. Apply the P935-1451 Performance Blender RFU on the adjacent panel or only in the area to be blended. The Performance Blender need to be applied as a wet layer to enable the pigments/RFU color to get the correct lay-down and metallic orientation.

7. Apply 1 coat one thin coat of Step 2 RFU color in the repair area extending blend area over step 1, here after followed by reverse blend in process to correct appearance. Avoid heavy layers. Blend the fading-out area as smooth as possible using reverse technique.

8. End the process with a light control coat in the blend area.

9. Apply hereafter full panel application process on new/repared panel.

<p><b>1. Repaired or new panel</b> <b>2. Adjacent panel</b></p>	
<p><b>1: Blending Adjuster</b> Step 1. Apply the blend bed adjuster as a wet coat on the adjacent panel or in only in blend/fade-out area.  (The Blending Adjuster will allow the correct pigment lay down in the blend area)</p>	
<p><b>2: WBBC Color RFU</b> Step 1. Apply a light coat into the Blending area. Step 2. Apply STD blend process into the Blending Area. Blend/fading-out as smooth as possible. End the blend process with a light control coat on blend area. Step 3. Apply WBBC color on repaired panel to opacity.</p>	



## SPECTRAL GREYS

Use of the specified Spectral Grey will ensure that the minimum volume of basecoat colour is used and that the basecoat process time is optimised. The recommendation for which Spectral Grey to use can be found on our colour communication systems (microfiche, e-fiche, On-Line Colour formulations and electronic balances). Where there is no Spectral Grey specified then SG05 should always be selected.

## PREPARATION OF SUBSTRATE

Dry sanding use P400 or finer.

For the removal of water soluble salts and flattening residues produced by wet and dry flattening, use P980-8252 waterborne pre-cleaner.

P980-8252 application:

Use one clean cloth for application and one clean cloth for wiping off contaminants.

## BASECOAT MIXING

Mix paint only in plastic containers. DO NOT use metal cans.

Gently invert cans twice before dosing.

Stir immediately after weighing all the ingredients specified.

DO NOT SHAKE. Cover container if left for any length of time before use.

## EQUIPMENT CLEANING

### Manual

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.

### AUTOMATIC GUN CLEANING MACHINE (AQUABASE PLUS GUN WASH P980-8212)

Dis-assemble gun and place in waterborne gun cleaning machine as per manufacturer's instructions. After the cleaning cycle, clean off the gun parts and rinse with water. Assemble gun and spray through with Aquabase thinner P980-5000. Ensure gun is fully dry before storing or further use.

For the treatment and disposal of wastewater from the gun cleaning process refer to the appropriate PDS.

## RECTIFICATION

Visible defects, e.g. dirt, are readily removed provided the basecoat is fully dry and the defect is dry denibbed using minimal pressure with P1500 wet/dry paper. It is preferable to remove defects before clearcoating. Once clearcoated, defects can only be removed when into-service times have been reached.

An alternative method is to use very fine grade fibre sanding pads e.g. Abralon 4000 either dry, or in combination with a small amount of Spirit Wipe (P850-14 or P850-1402) as a lubricant.

The sanded surface should then be coated with reduced pressure at 1.4 bar to avoid unnecessary overspray.

## STORAGE

Store free from frost, above 4°C

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](http://www.nexaautocolor.com)

### FOR FURTHER INFORMATION PLEASE CONTACT:

Customer Service Sales Group  
PPG Industries (UK) Ltd  
Needham Road  
Stowmarket  
Suffolk. IP14 2AD  
**Tel: 01449 771771**  
**Fax: 01449 773472**