



November 2024

TCB105V

# TCB105V Technical Colour Bulletin

AquaMax Extra Waterborne Basecoat 3CT Colour Toners

## PRODUCTS

1.590.0096 Arancione Organico

1.590.0080 Midcoat Base Incoloure

## PRODUCTS DESCRIPTION

The 1.590.0096 AquaMax Extra is a particularly brilliant and deep orange colour toner, 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 1.590.0080 The Midcoat Base Incoloure is a transparent toner to support the mid layer.

1.590.0080 is a product similar to 1.500.0081, but clearer/water white.

\*1.590.0080 is Not a blender to be used as a wet bed doing blend process.



*We make your job easier.*

Specialist since 1895

## PREPARATION OF SUBSTRATE

Degrease all surfaces to be painted with appropriate MaxMeyer waterborne substrate cleaner before wet sanding with P800 grade paper or dry sanding with P400-500 grade paper.



Wash off residues and dry thoroughly before re-cleaning with appropriate waterborne MaxMeyer pre-cleaner.

The use of a tack-rag is recommended.

Apply over original sanded and clean 2K finishes, or a range of MaxMeyer primers - refer to primer TDS for specific recommendations. The use of Multi Grey primers is recommended for optimum results.

Wash off residues and dry thoroughly before re-cleaning with appropriate waterborne pre-cleaner.

## PRE-APPLICATION

Mixed AquaMax Extra RFU colour should be thoroughly hand-stirred before application. If not used immediately it should be hand-stirred again before use.

Use nylon paint filters specially designed for use with waterborne paint materials.

A 125 micron mesh is recommended.

## Process

---

### 1. REPAIR AND PREPARATION OF SUBSTRATE

1.1 Prepare the damaged body parts with the appropriate MaxMeyer Refinish products. Please observe the information in the Technical Data Sheets of the respective product systems.

Use Multi Grey according to the colour shade. Multi Grey M4 is required for this colour.

---

### 2. GROUNDCOAT AND PREPARATION OF SUBSTRATE

2.1 When preparing the substrate as recommended below, suitable colour panels should be prepared alongside for use when checking the colour/effect of the basecoat.

To produce the colour panels, use the full panel application process described below.

In order to define how many coats of step two are needed to achieve best possible colour match, it is recommended to produce several spray out cards.

2.2 For the current available colour formulations, a M4 groundcoat colour is used.

The M4 shade gives the best guide as to when full coverage is achieved.



## AQUAMAX EXTRA - SET UP & PROCESSES

### Mixing Ratios with AquaMax Extra Standard (3CT colours).

| Step   | Volume / Parts            | Metallic Colours | Solid Colours |
|--------|---------------------------|------------------|---------------|
| Step 1 | <i>AquaMax Extra</i>      | 100              | 100           |
|        | 1.911.9910/1.911.9940     | 20               | 10-20         |
| Step 2 | 1.590.0080 + Mica / Solid | 100              | 100           |
|        | 1.911.9910 / 1.911.9940   | 30               | 30            |

#### Optional Mix Ratios using hardener/1.960.0300 in Step 1 RFU:

Metallic/Solid Colours: 100:10:5:5  
 (AquaMax+1.978.0092+1.911.9910/1.911.9940+1.960.0300)



Spray gun setup:

Conventional/RP STD Temp: 1,2mm  
 Conventional/RP High Temp: 1,3mm

HVLP STD Temp: 1,3mm  
 HVLP High Temp: 1,4mm

Spray pressure:

AquaMax STD: 2.0 bar – Light control coat: 1.2-1.5 bar

Number of coats:

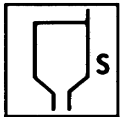
**AquaMax STD:** Express or Single coat (See TDS: 340V AquaMax Extra)

Flash-off time:

Fast dry or comparable flash-off systems  
 The basecoat must be completely flash-off matt.  
 Alternatively 40° for 8 min.

## Mixing Ratios with Blending Adjuster

|                              | Volume / Parts |
|------------------------------|----------------|
| 1.500.0081 Blending Adjuster | 100            |
| 1.911.9910/1.911.9940        | 20             |



Viscosity will vary pending the colour/toner combinations and mix ratio.  
 (If needed viscosity can be adjusted accordingly using 1.911.9910 or 1.911.9940)  
 Potlife RFU: 1 month. Stir well before use

### NOTE!

Please check the colour 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 coat.

Details on the processing of the colour for coating complete vehicle parts as well as the blending process are described below.

## AQUAMAX EXTRA - APPLICATION PROCESSES

### Application of the basic tone (Step one) in Aquamax (Full Panel Application)

Number of coats: **AquaMax STD:** Express(Cascade) or Single coat (See TDS 340V)

Flash-off time: Fast dry or comparable flash-off systems  
 The basecoat must be completely flash-off matt.  
 Alternatively 40° for 8 min.

Step 1: Final appearance (Renault EQB)



## APPLICATION OF THE SECOND LAYER (STEP TWO) IN AQUAMAX EXTRA (FULL PANEL APPLICATION)

First coat Step two: After Flash off.



Step 2: Final basecoat appearance (wet)



Clearcoat Application:

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

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

## FINAL APPEARANCE 1.590.0096



## 3-COAT COLOUR – BLEND PROCESS



Preparation of the substrate in Multi Grey M4

Mix and process the primer materials according to above or the technical data sheet of the respective product.

## BLEND PROCESS STEP 1:

1. Wet bed step 1:

Apply the 1.978.0093 Blender Performante RFU in the area to be blended. The Blender Performante need to be applied as a wet layer to enable the pigments/RFU colour to get the correct lay-down and metallic orientation. **(Green ring marked in photo)**

2. Apply 1 coat one thin coat of Step 1 RFU colour 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 Colour must be focused as limited as possible into the adjacent panel

3. End Step 1 RFU colour process with a light control coat in the blend area.

(If the blend looks smooth, control coat is not needed.)



## APPLICATION OF THE SECOND LAYER (STEP TWO) IN AQUAMAX EXTRA (BLEND)

### 3CT Step 2:

Apply the 1.978.0093 Blender Performante RFU on the adjacent panel or only in the area to be blended. The Blender Performante has to be applied as a wet layer to enable the pigments/RFU colour to get the correct lay-down and metallic orientation.

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

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



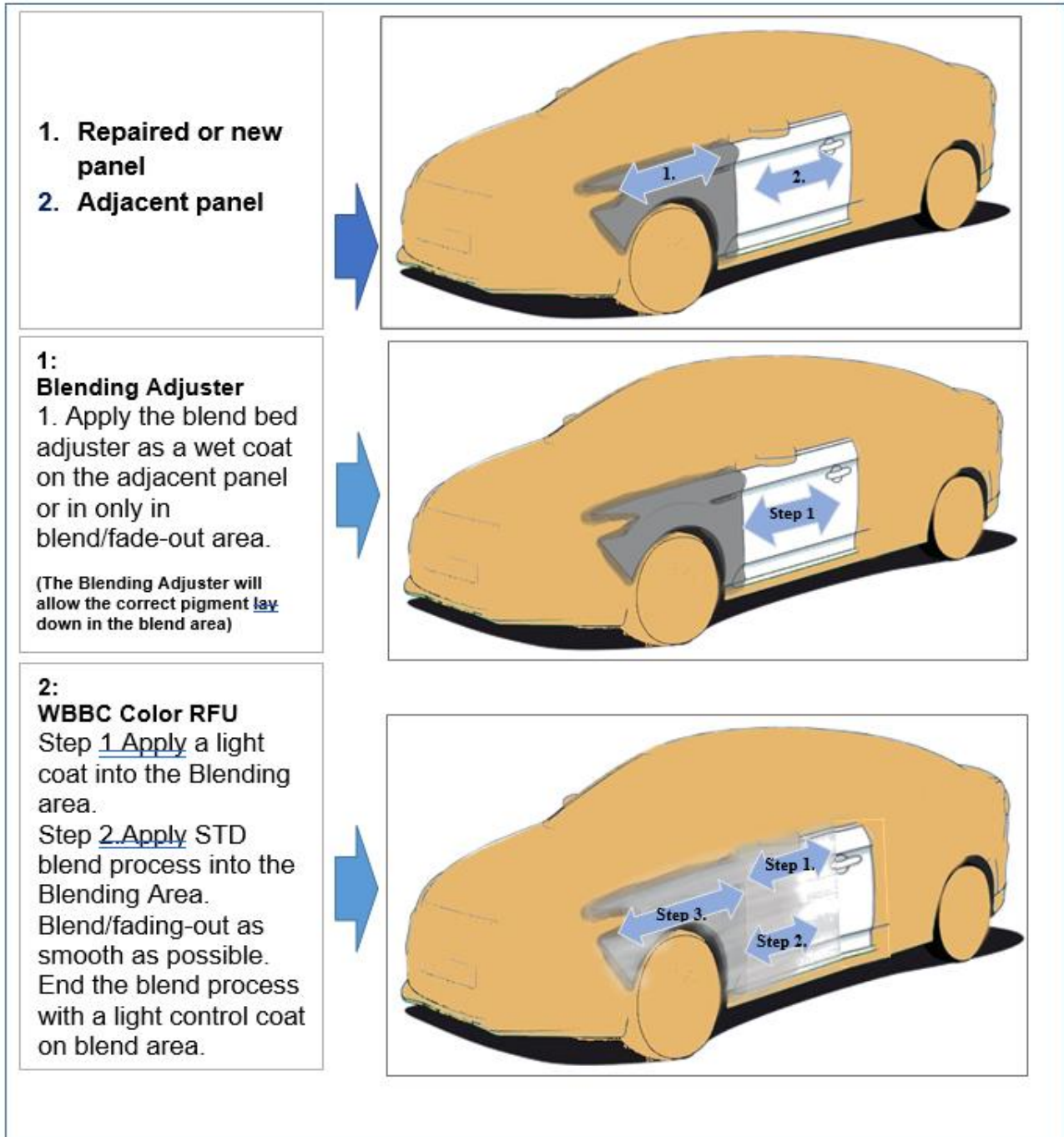
**NOTE:** Try to let the layers flow out over a wide area, otherwise there is a risk that this will become Streaky/colourful, or visible at certain angles



**STEP 2: FINAL APPEARANCE PRIOR CLEARCOAT PROCESS.**



**ANIMATED OVERVIEW:**



## CLEARCOAT APPLICATION:

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

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



## REPAIR AND RECOATING



Overcoating:

*AquaMax Extra* ready-for-use mix can be overcoated with a MaxMeyer clearcoat after flash off till mat.



De-nib:

It is possible to de-nib *AquaMax Extra* after flash off, with fine sanding paper – P1000-1500 (dry paper) using air blowing and a tack rag to remove sanding dust and followed by a spot repair (see FADING-OUT section) prior to the clearcoat application.

## EQUIPMENT CLEANING

- Clean all mixing equipment immediately after use, preferably using a dedicated waterborne equipment cleaning machine.
- Use tap water, with a final rinse using deionized water or an alcohol-based cleaner.
- Ensure all equipment is completely dry before storage or use.

## STORAGE & HANDLING



AquaMax tinters & mixed colour 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 +5°C and a maximum of +35°C. Avoid exposure to frost or freezing conditions.

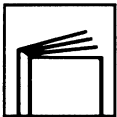


AquaMax should be mixed in clean, dry containers and equipment. Do not use mixing vessels or spray equipment that contains solvent residues. Mixing vessels should ideally be plastic - if metallic they should have an internal anti-corrosion coating.

## 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.

## WASTE HANDLING & DISPOSAL / HEALTH & SAFETY



**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.ppgrefinish.com](http://www.ppgrefinish.com)

Store waterborne & solventborne wastes separately. All wastes must be handled by a competent agent with appropriate certification. Waste **must** not be disposed of into drains or watercourses.

## VOC INFORMATION

If you have any questions, please contact PPG Customer Services.

Tel: +44 (0) 1449 771775 or Email: [ukenquiries@ppg.com](mailto:ukenquiries@ppg.com)