
Product Information

CT Waterborne Basecoats

PRODUCT

CT Waterborne Basecoat Ready Mix Colour	
High Performance Additive	T492
Waterborne Thinner	T494
Waterborne Slow Thinner	T495

PRODUCT DESCRIPTION

CT Waterborne basecoat offer is a Ready Mix range of waterborne basecoat colours that significantly reduce solvent emissions into the environment and comply with all current and future legislative requirements.

Applied as a part of a two-stage basecoat paint system, CT Waterborne basecoats reproduce original solid, metallic or mica paint finishes, giving excellent covering power and fade out capability. In conjunction with high quality PPG Delfleet Clearcoats and Primers, the CT Waterborne basecoat system delivers excellent gloss and durability. Easy to use, this is a simple and flexible system capable of high quality vehicle repairs.

CT WATERBORNE BASECOAT EXPRESS



This is the system to use where high productivity is required. It incorporates accelerated, warm air movement over the surface of the paint film during the flash off periods.

The system raises the booth temperature to between 40 - 45°C during the CT Waterborne Basecoat flash-off period, thereby reducing humidity by about 50%.

This process / system has a different application process to the normal CT Waterborne Basecoat application.

By using the CT Waterborne Basecoat Express system, application & drying times can be dramatically reduced, giving quicker process times.

SUBSTRATE PRE-TREATMENT

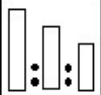



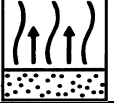

	<p>Prepare the substrate as follows:</p> <p>Product can be used over the following -: Delfleet Epoxy Primers Delfleet 2K Primers Delfleet Wet On Wet Undercoats</p> <p>Please check relevant data sheets for primer preparation</p>	<p>CLEANING</p> <p>The substrate to be painted must be dry, clean, and free of corrosion, grease & mould release agents.</p> <p>Substrates need to be thoroughly prepared using a combination of D845 Degreaser & D837 Spirit Wipe (or D842 low V.O.C. cleaner)</p>
	<p>Sound aged paint surfaces –: P360 dry flat Sound fresh paint surfaces –: Fine / Ultrafine Scotch-Brite</p> <p>Do not use WB Basecoats directly over -: Wash Primers Etch Primers Acrylic Thermoplastic Finishes</p>	

PRE - APPLICATION

Hand Shake cans of CT Waterborne Basecoat Ready Mix colour for a few seconds before use. Do Not shake vigorously.

Use nylon paint filters specially recommended for use with waterborne paint materials. A 125 micron mesh is recommended. 190 micron is the maximum.

PREPARATION AND APPLICATION – STANDARD PROCESS

	<p>Mixing Ratios with CT Waterborne Basecoat Ready Mix Colour Note: Hand shake T492 Activator before use.</p> <p style="text-align: center;"><u>Large Areas – By Volume</u></p> <p>Mixing Ratios with CT Waterborne Basecoat Colour</p> <table style="width: 100%; border: none;"> <tr> <td></td> <td style="text-align: right;">By Volume</td> </tr> <tr> <td>WBBC Metallic Colours (greater than 70% Aluminium)</td> <td style="text-align: right;">10</td> </tr> <tr> <td>High Performance Additive T492</td> <td style="text-align: right;">1</td> </tr> <tr> <td>Thinner T494/T495</td> <td style="text-align: right;">1,5</td> </tr> <tr> <td> </td> <td></td> </tr> <tr> <td>WBBC other colours (any other colour)</td> <td style="text-align: right;">10</td> </tr> <tr> <td>High Performance Additive T492</td> <td style="text-align: right;">1</td> </tr> <tr> <td>Thinner T494/T495</td> <td style="text-align: right;">1</td> </tr> </table> <p>Thinner selection Below 35°C T494 Above 35°C T495</p> <p>At high temperatures, (above 30°C), 20% parts of thinner may be used to help application, lay down and overspray absorption.</p> <p>Note: If the 10 parts thinner addition is used, then it is very important to strictly observe the flash off times between coats and before the application of Clearcoat.</p>				By Volume	WBBC Metallic Colours (greater than 70% Aluminium)	10	High Performance Additive T492	1	Thinner T494/T495	1,5	 		WBBC other colours (any other colour)	10	High Performance Additive T492	1	Thinner T494/T495	1
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<p>Potlife at 20°C -: Activated -: 48 hours Unactivated -: 28 days</p>																			
	<p>Viscosity: Viscosity will vary with the thinner level chosen</p>	<p>HVLP 22 - 26 sec. DIN4/20°C</p>	<p>PRESSURE 22 - 26 sec. DIN4/20°C</p>																
	<p>Gun set-up:</p>	<p>1.2-1.4 mm. 2 Bar Inlet</p>	<p>0.85 -1.0 mm. 2 Bar Inlet Fluid 280-320 cc/min</p>																
	<p>Number of coats:</p>	<p>Apply 2 – 3 single coats until opacity is obtained. Flash off thoroughly between coats. Air movers can be used to accelerate drying.</p>	<p>Apply 2 – 3 single coats until opacity is obtained. Flash off thoroughly between coats. Air movers can be used to accelerate drying.</p>																
	<p>20°C Flash off: Between coats</p>	<p>Flash off until matt between coats.</p>	<p>Flash off until matt between coats.</p>																
	<p>Control Coat</p>	<p>For Metallic and Mica colours, apply a light control coat onto the dry film for even flake appearance</p>	<p>For Metallic and Mica colours, apply a light control coat onto the dry film for even flake appearance</p>																
<p>Drying time:</p> 	<p>20°C : Minimum recoat time Maximum recoat time</p>	<p>HVLP Basecoats should be uniformly matt and dry before Clearcoat application 72 Hours</p>	<p>PRESSURE Basecoats should be uniformly matt and dry before Clearcoat application 72 hours.</p>																
	<p>Total dry film build</p>	<p>10 - 20 µm</p>	<p>10 - 20 µm</p>																

REPAIR AND RECOATING

OVERCOATING	CT Waterborne Basecoat Ready Mix must be over coated with a Delfleet UHS Clearcoat after the minimum flash times.
RECOATING TIMES	The maximum recoat time is 72 hours. After 72 hours, 1 coat of CT Waterborne Basecoat Ready Mix has to be applied prior to the Clearcoat application.
De - Nib	It is possible to de-nib CT Waterborne Basecoat Ready Mix, after 20 minutes flash off, with fine sanding paper – P1500 (wet/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.
Multi – colour work	It is recommended to Force dry the basecoat prior to masking.
OVERCOAT WITH	Delfleet UHS Clearcoats. (See Clearcoat Technical Data Sheets for information)

FADE – OUT TECHNIQUE

Fading-out CT Waterborne Basecoat Ready Mix is necessary for spot repair and advised when metallic or mica colours have to be repaired.

Apply basecoat to the prepared area to obliterate the primed area.

Reduce the pressure at the spraygun and fade into the surrounding area.

Flash off until uniformly matt, for larger areas apply final control coat (metallics and micas) before applying clear.

Alternatively use T490 as follows:

Prepare colour as specified in the datasheet.

Using light inward strokes reach coverage on the repaired area.

Thin one part of the ready for use colour with one part of T490 ready to use

Use this mixture to fade the repair edges spraying from the outside to the inside the repair area.

Repeat the last step until the potential colour difference has been lost.

Allow the repair become uniformly matt and dry before clearcoating.

PERFORMANCE AND LIMITATIONS

Do not exceed maximum film build recommendations.

Do not use spraygun as an air blower.

Most basecoats will have high opacity but the coverage of some may be assisted by the use of an appropriately tinted Delfleet primer or GreyMatic primer.

If left overnight, surface must be tacked-off prior to clearcoating.

STORAGE & HANDLING



CT Waterborne Basecoat Ready Mix colour & T494 thinner 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.



CT Waterborne Basecoat Ready Mix 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.

EQUIPMENT CLEANING

Clean all mixing equipment immediately after use, preferably using a dedicated waterborne equipment cleaning machine.

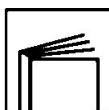
Ensure all equipment is completely dry before storage or use.

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: http://www.ppg.com/PPG_MSDS

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.

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