



GLOBAL REFINISH  
SYSTEM



January 2008

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# Product Information



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## **ENVIROBASE**

*Envirobase Waterborne Basecoat colour T4xx*

*Envirobase Thinner T494*

*Envirobase Slow Thinner T495*

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## **PRODUCTS**

Envirobase is waterborne basecoat colour for use in the repair of basecoat clear systems.

Applied as a part of a two-stage or multi-stage basecoat paint system, mixed Envirobase colour reproduces original solid, metallic or mica paint finishes.

Envirobase is a waterborne product, containing considerably less volatile organic compound (VOC) than conventional solventborne basecoat. This makes Envirobase particularly suitable for use in areas where VOC emissions or product VOC content are subject to legal restriction.

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## **ENVIROBASE 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 Envirobase flash-off period, thereby reducing humidity by about 50%.

This process / system has a different application process to the normal Envirobase application.

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

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## PREPARATION OF SUBSTRATE

Apply over original stoved 2K finishes or PPG GRS Deltron primers except: D836 / D838 Koba, D831 Universel, D855 2+1.



Degrease all surfaces to be painted with appropriate PPG substrate cleaner before wet sanding with P800 grade paper or dry sanding with P500 grade paper.



Wash off residues and dry thoroughly before re-cleaning with appropriate PPG substrate cleaner. See Technical Data Sheet **Deltron Cleaners RLD63V**. The use of a tack-rag is recommended.

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## PRE-APPLICATION

Hand-shake bottles of Envirobase tinter for a few seconds before use.

Mixed Envirobase 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. Recommended mesh size is 125 – 190 microns..

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## THINNER SELECTION

Temperature	Thinner	
Below 35°C	10-30 Vol	T494 - Thinner
Above 35°C	10-30 Vol	T495 - Thinner

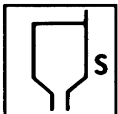
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## MIXING RATIOS

Mixing Ratios with Envirobase Colour

	<u>By Volume</u>
Envirobase Colour	100 Vol
Thinner T494/495	10 – 30 Vol

Note: If the 10% thinner addition is used, then it is very important to strictly observe the flash off times between coats and before the application of clearcoat.



Spray viscosity                      Viscosity will vary with thinner level chosen, but optimum application viscosity is 22-26 seconds DIN4 at 20°C

Potlife:                                      3 months. Stir well before use



## ENVIROBASE STANDARD PROCESS

### APPLICATION, FLASH-OFF AND DRYING



*Spraygun set-up:*

#### Small Surfaces

#### Large Surfaces

1.2 - 1.3 mm

*Number of coats:*

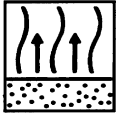
3 - 4 light coats

2 - 3 medium coats

*Control coat*

For flake colours, apply a light control coat onto dry film for even flake appearance.

For optimum flake laydown, apply control coat at 1.2 - 1.5 bar inlet pressure.



*Flash-off at 20°C  
60% relative humidity:*

- between coats
- before clearcoat

Use an airblower until the surface is touch dry

1 - 2 minutes

3 - 4 minutes

Minimum 15 minutes

*Total dry film build:*

10 - 20 µm

## ENVIROBASE EXPRESS PROCESS

### APPLICATION, FLASH-OFF AND DRYING

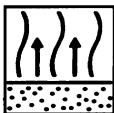


*Spraygun set-up:* 1.2 - 1.3 mm

*Number of coats:*

**Wet-On-Wet**

1 light coat, 2-3 medium coats



*Flash off:*

**Use the Envirobase Express Blowing and Heating for 6 - 7 minutes.**

- *Control coat*

For flake colours, apply a light control coat onto dry film for even flake appearance.

For optimum flake laydown, apply control coat at 1.2 - 1.5 bar inlet pressure.

- *Before clearcoat:*

Minimum 10 minutes

*Total dry film build:* 10 - 20 µm



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## REPAIR AND RECOATING



*Overcoat*

Envirobase must be overcoated with a GRS Deltron clearcoat after the minimum flash times

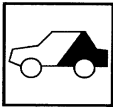
*Recoat time:*

After 24 hours, 1 coat of Envirobase has to be applied prior to the clearcoat application.

The maximum recoat time is 48 hours.

*De-nib:*

It is possible to de-nib Envirobase, after 20 minutes flash off, with fine sanding paper – P1200/P1500 (dry) 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.



*Overcoat with:*

A wide range of Deltron Clearcoats.  
(See Clearcoat Technical Data Sheets for information)

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## FADE-OUT TECHNIQUE

Fading-out Envirobase is necessary for spot repair and advised when metallic or mica colours have to be repaired.

Use T490 as follows :

- Prepare Envirobase colour as specified in the datasheet.
- Using light inward strokes reach coverage on the repaired area.
- Thin one part of the ready for use Envirobase 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 a 15 minutes flash off before clearcoating

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## 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 deionised water or an alcohol-based cleaner such as D846.

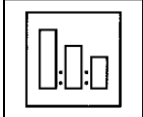
Ensure all equipment is completely dry before storage or use.



# Global at a Glance

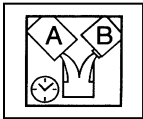
# Envirobase

## Envirobase Waterborne Basecoat Topcoat Envirobase Express Process



### Mixing by volume

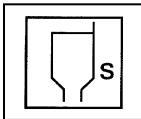
With Thinner T494/T495 100 Vols : 10 - 30 Vols



Pot Life at 20°C 3 months. Stir well before use.

### Thinner Selection

Below 35°C	10 – 30 Vol T494
Above 35°C	10 - 30 Vol T495



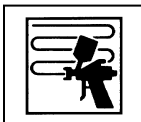
### Application viscosity

18 - 22 seconds DIN4



### Spraygun Size

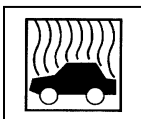
1.2 - 1.3 mm fluid tip



### Number of Coats

**Standard Process** 3 - 4 Light coats or 2 - 3 medium coats.  
A control coat is recommended for flake colours

**Express Process** 1 Light coat plus 2-3 medium coats wet-on-wet.  
A control coat is recommended for flake colours



### Drying Times

**Standard Process:** Use an air blower until surface is touch dry.  
Minimum - 15 minutes at 20°C before the application of Clearcoat  
Maximum 48 hours at 20°C before application of Clearcoat  
15 - 20 minutes at 20°C before taping

**Express Process:** Use an **Envirobase Express** system for drying  
Minimum - 10 minutes at 20°C before the application of Clearcoat  
Maximum 48 hours at 20°C before application of Clearcoat  
15 - 20 minutes at 20°C before taping

### Overcoating

Envirobase Basecoat colours can be overcoated with a wide range of

These products are for professional use only

RLD125V



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## PERFORMANCE AND LIMITATIONS



**DO NOT** use the spraygun as an airblower.

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## STORAGE AND HANDLING



Envirobase tinters, Envirobase mixed 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.



Envirobase 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.

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## VOC INFORMATION

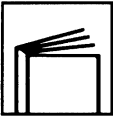
The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC.

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.

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## 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](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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