



GLOBAL REFINISH
SYSTEM



March 2008

Product Information



Internal Repair System WB Engine Bay Converter T510

T510 WB Engine Bay Converter
D8260 Activator
T494 Thinner
T495 Slow Thinner

PRODUCT DESCRIPTION

Envirobase High Performance Internal Repair System is designed to provide a simple and efficient process for repairs involving a specific matt interior colours, or low gloss versions of the external colour.

Direct application to electrocoat produces a groundcoat colour to accurately reproduce the original finish on internal parts. At the same time it provides a coloured wet on wet layer that can be topcoated to reproduce the original external finish, thereby removing the need for undercoating.

Envirobase High Performance Internal Repair system has two modes of use. Internal colour formulas matched to dedicated OE internal colours are provided as part of the PPG colour retrieval system. Alternatively any waterborne colour can be converted to Internal Repair mode for use in many repairs where internal colours are low gloss versions of external areas.

PREPARATION OF SUBSTRATE



For maximum durability, with new panels in good quality Electrocoat, it is recommended that the Electrocoat is sanded using Red Scotch-Brite™, leaving it as intact as possible, prior to application of the Internal Repair Colour.

Rub through areas should be coated with D8421 (G5), D8424 (G6) or D8426 (G7) Aerosol 1K primers.



For structural areas of bare metal, it is recommended that either an Etch primer followed by a wet on wet primer, D8077/8, or an Epoxy Primer be used, prior to the application of Internal Repair colour.

Good preparation is vital in order to obtain the best results from these products Internal Repair System should **not** be applied directly over Etch Primer D831.

These products are for professional use only.

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PREPARATION OF WB ENGINE BAY CONVERTER

Hand-shake bottles of Envirobase Engine Bay Converter and tinters for a few seconds before use to ensure that they are thoroughly homogeneous.

MIXING RATIOS - Dedicated Internal Colour

Mix the Internal colour in accordance with the PPG colour information on IT systems.

This formulation will contain T510 WB Engine Bay Converter:

NOTE: The colour must be stirred thoroughly when the converter is added, *BEFORE* activation and thinning.

Making ready for use by weight:

Engine Bay Colour	100 parts
D8260 Activator	15 parts
Then add Thinner*	15 - 20 parts for Solid Colours, 20 parts for Aluminiums / Pearls

To give an application viscosity of 18 - 21 Seconds

* Choose Thinner according to application temperature and size of repair, 10 parts thinner may be used for double coating:

MIXING RATIOS - Converting an Existing Colour

Where the internal area is a matt version of the external colour, mix the Envirobase colour in accordance with the PPG colour information on IT systems or microfiche.

Making ready for use by weight:

Envirobase Colour	70 parts
WB Engine Bay Converter T510	30 parts
	Stir thoroughly then add:-
D8260 Activator	15 parts
Thinner*	15 - 20 parts for solid colours, 20 parts for Aluminiums / Pearls

To give an application viscosity of 18 - 21 Seconds

* Choose Thinner according to application temperature and size of repair, 10 parts thinner may be used for double coating:

THINNER SELECTION

The choice of thinner should be made according to application temperature, humidity, air movement and size of repair.

The following ranges should be used for guidance only.

T494 - up to 30°C, T495 - over 30°C.

Areas requiring topcoating can be directly overcoated with Envirobase or Deltron Progress UHS DG topcoats after the appropriate flash off time.



MIXED PRODUCT DETAILS

Potlife 1 hour at 20°C - when activated

Spray viscosity 18 - 21 secs DIN4 / 20°C

SPRAYGUN SET UP

Compliant Spraygun 1.3 - 1.4 mm

Spray pressure 2 bar

Number of coats Apply one double coat or 2 single coats to give a dry film thickness of 10 - 25 microns.

FLASH OFF AT 20°C:

Between coats *Ensure that each coat is fully flashed off before overcoating.*
Blow dry or use Express systems for the optimum process times.
5 minutes between coats if using single coats.
15 minutes, or a complete Express cycle, before topcoating



PROCESS STEPS - DEDICATED INTERNAL COLOUR

For an Internal colour taken from the colour system that includes the WB Engine Bay Converter.

1. Select the Internal colour using the Engine Bay Colour Directory or Colour Swatch.
2. Using the normal colour retrieval system, mix the Envirobase Internal Colour, this includes the addition of T510 WB Engine Bay Converter.
3. Stir colour thoroughly before activation - see below.
4. Any rub through areas to bare metal should first be primed using D8421 (G5), D8424 (G6) or D8426 (G7) Aerosol 1K primers.
Apply a light coat of colour to internal edges and sealer areas to maximize coverage.
Flash off using air blowers or Express systems.
5. Apply coats of colour to internal areas and any external panels that need a wet on wet surface for topcoat. Use double coats (single coats can be applied if preferred) to reach coverage.
6. Flash off using air blowers or Express systems.
7. Apply the topcoat to external panels, as necessary, after 15 minutes (or when fully flashed off), and bake. Internal colours can be overcoated with Envirobase + Clearcoat or Deltron Progress UHS DG colour.
8. Normally this Internal Repair system does not require flattening and should be directly topcoated. If some dirt inclusions occur, then light flattening / denibbing can be carried out after 20 minutes using P1200 or finer flattening paper (dry).

The weight of the activator and thinner required by certain weights of mixed colour to produce ready-for-use paint is detailed below. The weights correspond to the mixing ratio: 100 parts Envirobase Internal colour: 15 parts Engine Bay Activator: 15 - 20 parts thinner.
Add Mixing stick to container, before taring the scale.
Stir colour thoroughly before adding Activator and thinners.
'TARE' the scale after mixing or measuring out the colour. The weights of activator and thinner are CUMULATIVE – DO NOT TARE THE SCALE BETWEEN ADDITIONS.

Volume of Envirobase Interior colour mix	Final ready-for-use volume		Weight of D8260 Activator	Weight of Thinner	
				Grams to 15 parts	Grams to 20 parts
Litres	Litres		Grams		
0.10	0.14	S	116	131	137
0.25	0.35	T	291	320	342
0.40	0.55	I	466	519	547
0.50	0.68	R	582	659	684
0.75	1.02		874	978	1026
1.00	1.37	W	1165	1317	1368
1.50	2.05	E	1747	1976	2052
2.00	2.74	L	2330	2634	2736
2.50	3.42	L	2912	3293	3420

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PROCESS STEPS - CONVERTING AN EXISITING COLOUR

For an Envirobase colour that needs converting to an Internal colour.

1. Select the colour using the Envirobase Colour Directory or Colour Swatch.
2. Using the normal colour retrieval system, mix the Envirobase colour, and stir thoroughly.
3. Referring to the table below, add the Engine bay additive and stir thoroughly.
4. Continue to activate and thin the Internal colour, as recommended below.
5. Any rub through areas to bare metal should first be primed using D8421 (G5), D8424 (G6) or D8426 (G7) Aerosol 1K primers.
6. Apply a light coat of Internal colour to internal edges and sealer areas to maximize coverage. Flash off using air blowers or Express systems.
7. Apply coats of colour to internal areas and any external panels that need a wet on wet surface for topcoat. Use double coats (single coats can be applied if preferred) to reach coverage.
8. Flash off using air blowers or Express systems.
9. Apply the topcoat to external panels, as necessary, after 15 minutes, (or when fully flashed off), and bake. Internal colours can be overcoated with Envirobase + Clearcoat or Deltron Progress UHS DG colour.
10. Normally this Internal Repair system does not require flatting and should be directly topcoated. If some dirt inclusions occur, then light flatting / denibbing can be carried out after 20 minutes using P1200 or finer flatting paper (dry).

The weight of the Converter, activator and thinner required by certain weights of mixed colour to produce ready-for-use paint is detailed below. The weights correspond to the mixing ratio: 70 parts Envirobase colour: 30 parts Engine Bay Converter: 15 parts Engine Bay Activator: 15 - 20 parts thinner.

Add Mixing stick to container, before taring the scale.

Stir thoroughly before adding activator and thinners.

'TARE' the scale after mixing or measuring out the colour. Add a stirrer to the container before the tare. The weights of activator and thinner are **CUMULATIVE** – DO NOT TARE THE SCALE BETWEEN ADDITIONS.

Approx Final ready-for-use volume	Weight of Envirobase HP Colour Mix	Weight of T510 WB Engine Bay Converter		Weight of D8260 Activator	Weight of Thinner	
					Grams to 15 parts	Grams to 20 parts
Litre	Grams	Grams		Grams		
0.10	50	73	S	84	94	98
0.25	125	182	T	209	236	245
0.40	200	291	I	334	377	392
0.50	250	364	R	418	472	491
0.75	375	545		627	707	736
1.00	500	727	W	836	943	981
1.50	750	1091	E	1254	1415	1472
2.00	1000	1454	L	1672	1886	1962
2.50	1250	1818	L	2090	2358	2453

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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.

HEALTH AND 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

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