



October 2023

Process Information

TCB105



3-coat color Renault EQB «Orange Valencia»

Envirobase High Performance

PRODUCTS

Envirobase High Performance Basecoat WB-RENEQB Transparent Organic Orange
Envirobase High Performance Basecoat colorless FAG4/184 Transparent Blender.

PROCESS DESCRIPTION

The colour EQB Orange Valencia is a particularly brilliant and deep orange color, 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 color has already been developed and is available in Envirobase High Performance quality.

However, the previous versions Prime/Tone 1 and the variants can only be implemented to a limited extent.

1. REPAIR AND PREPARATION OF SUBSTRATE

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

Use Greymatic according to the color shade. Greymatic G5 is required for this color.



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 color/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 color match, it is recommended to produce several spray out cards.

2.2 For the Renault Orange Valencia (EQB), a G5 groundcoat color is used.

The G5 shade gives the best guide as to when full coverage is achieved.



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Mixing the first and second Base Coat layers

Main Layer layer in ENVIROBASE High Performance

EQB Main Layer:

T476	70 Parts by weight
WB-RENEQB/	30 Parts by weight
T441	6 Parts by weight
T491	2 Parts by weight

Effect layer / Second layer in ENVIROBASE High Performance

EQB Second layer / Effect layer

FAG4/184/E2	90 Parts by weight
WB-RENEQB	30 Parts by weight

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Detailed weight chart:

Step 1:

MIXING BY WEIGHT:				
The weights are cumulative - please do NOT tare the balance between additions.				
Total Volume Required ML	T476	WB-RENEQB	T441	T491
100,0	65,5	94,0	99,7	101,6
200,0	130,9	188,0	199,4	203,3
250,0	163,7	235,0	249,2	254,1
300,0	196,4	282,1	299,1	304,9
350,0	229,1	329,1	348,9	355,7
400,0	261,9	376,1	398,7	406,5
450,0	294,6	423,1	448,6	457,3
500,0	327,3	470,1	498,4	508,1
550,0	360,0	517,1	548,3	559,0
600,0	392,8	564,1	598,1	609,8
650,0	425,5	611,1	648,0	660,6
700,0	458,2	658,1	697,8	711,4
750,0	491,0	705,1	747,6	762,2
800,0	523,7	752,1	797,5	813,0
850,0	556,4	799,2	847,3	863,9
900,0	589,2	846,2	897,2	914,7
950,0	621,9	893,2	947,0	965,5
1000,0	654,6	940,2	996,9	1016,3

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Step 2:

MIXING BY WEIGHT: The weights are cumulative - please do NOT tare the balance between additions.		
Total Volume Required ML	WB-RENEQB	FAG4/184
100	77,1	102,3
200	154,2	204,5
250	192,8	255,6
300	231,3	306,8
350	269,9	357,9
400	308,4	409,0
450	347,0	460,1
500	385,5	511,3
550	424,1	562,4
600	462,6	613,5
650	501,2	664,6
700	539,7	715,8
750	578,3	766,9
800	616,8	818,0
850	655,4	869,1
900	693,9	920,3
950	732,5	971,4
1000	771,0	1022,5

NOTE!

Please check the color 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.

The color formulation Renault EQB Orange Valencia is designed for the coating of complete vehicle parts.

It is possible to use this effect colour in a special procedure for colour blending.

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



Application of the basic tone (Step one) in Envirobase High Performance (Full Panel Application)

Mixing ratio:	100 : 10 : 5 parts by weight with T492 and T494 / T495 + 5% D8260
Spray gun setup:	HVLP technology with 1.3 mm nozzle
Spray pressure:	1.7 bar for the application of normal coats
Number of coats:	2 coats until the substrate is completely covered
Flash-off time:	Fastdry or comparable flash-off systems The basecoat must be completely flash-off matt. Alternatively 40° for 8 min.
Effect/Light coat:	1 light/effect coat with 1.2 bar
Flash-off before 2. layer:	5 - 10 minutes at 20 - 23 °C / The basecoat must be completely matt and dried.



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APPLICATION OF THE SECOND LAYER (STEP TWO) IN ENVIROBASE HIGH PERFORMANCE (FULL PANEL APPLICATION)

Mixing ratio:	100 : 10 : 15 parts by weight with T492 and T494 / T495
Spray gun set up:	HVLP technology with 1.3 mm nozzle
Spray pressure:	1.7 bar for the application of normal coats
Number of coats:	2 coats wet-on-wet + light/effect coat in the wet film. Number of spraying coats adapted to the previous test
Flash-off time:	Fast dry or comparable flash-off systems The basecoat must flash off completely matt. Alternatively 40° for 8 min.
Effect/Light coat:	1 lightcoat on top after drying if necessary.

First coat Step two:



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Second coat + light coat in the wet film:



Clearcoat Application:

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

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



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3-COAT COLOR RENAULT EQB «ORANGE VALENCIA»

COLOUR BLENDING PROCESS:



Preparation of the substrate in Greymatic G5

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

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Application of the main layer (Step one) in Envirobase High Performance (Blend)

Mixing ratio:	100 : 10 : 5 parts by weight with T492 and T494 / T495 + 5% D8260
Spray gun setup:	HVLP technology with 1.3 mm
Spray pressure:	1.7 bar for the application of normal coats
Number of coats:	2 coats until the substrate is completely covered
Flash-off time:	Fast dry or comparable flash-off systems The basecoat must be completely flash-off matt. Alternatively 40° for 8 min.
Effect/Light coat:	1 light/effect coat with 1.2 bar
Flash-off before 2. layer:	5 - 10 minutes at 20 - 23 °C / The basecoat must be completely matt and dried



APPLICATION OF THE BLEND WITH T490 IN ENVIROBASE HIGH PERFORMANCE:

Mixing ratio:	100 : 10 : 15 parts by weight with T492 and T494 / T495
Spray gun setup:	HVLP technology with 1.3 mm
Spray pressure:	1.7 bar for the application
Number of coats:	1 full coat in the blend zone



APPLICATION OF THE SECOND LAYER (STEP TWO) IN ENVIROBASE HIGH PERFORMANCE (BLEND)

Mixing ratio:	100 : 10 : 15 parts by weight with T492 and T494 / T495
Spray gun set up:	HVLP technology with 1.3 mm
Spray pressure:	1.7 bar for the application of normal coats
Number of coats:	2 coats wet-on-wet + light/effect coat in the wet film. Number of spraying coats adapted to the previous test
Flash-off time:	Fastdry or comparable flash-off systems The basecoat must flash off completely matt. Alternatively 40° for 8 min.
Effect/Light coat:	1 light fade out coat on top after drying

First coat:



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Second coat + light/effect coat in the wet film:



NOTE:

Try to let the layers flow out over a wide area,
otherwise there is a risk that this will become streaky,
or visible at certain angles

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Clearcoat Application:

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

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



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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: www.ppgrefinish.com

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