ENVIROBASE®
HIGH PERFORMANCE

Product Information

Internal Repair System

Product Description

ENVIROBASE® High Performance Internal Repair System is designed to provide a simple repair process where there is a specific underhood color, or where the internal area is a low gloss version of the external color. Dedicated internal color formulas are provided as part of the PPG PAINTMANAGER® program software or by accessing Online Color. They are designed to match the OEM finish on internal unexposed body parts.

Once converted, activated and thinned, the internal repair color is capable of providing an accurately matched finish for engine bay and other unexposed areas.

Preparation of Substrate

Before and after any sanding operation, the substrate must be thoroughly degreased. Use an appropriate waterborne pre-cleaner.

Internal color may be applied over e-coated panels after cleaning with a scuff pad and waterborne pre-cleaner, factory finishes or PPG recommended primers after cleaning and wet sanding with P600 - P800 grade paper or dry sanding with P360 - P400. If there are rub throughs to bare metal, then ONECHOICE® SXA1031 Aerosol Etch Primer should be used, followed by a light de-nibbing if needed and then tacking off before applying internal color.

APPLICATION GUIDE:

Mixing - Internal Color (formulas containing T510 Converter)

Making Ready to Spray

Internal Color	100 parts

Stir before activating and thinning

T581 Activator	15 parts
T494 Thinner	15-20 parts for solid colors 20 parts for aluminums / pearls

Sprayable viscosity should be between 18-21 seconds, Din 4 cup. If necessary, a small amount of additional thinner (less than 5%) may be added to improve sprayability.

Mixing - Un-Thinned Pre Mixed Color (formulas not containing T510 Converter)

Making Ready to Spray

Mixed Color	70 parts/grams
T510 Converter	30 parts/grams

Stir before activating and thinning

Making Ready to Spray
Activate and thin color with T581 @ 15% by weight and reduce with T494 @ 20% by weight.

Internal Color	100 parts/grams
T581 Activator	15 parts/grams (15% by weight)
T494 Thinner	20 parts/grams (20% by weight)

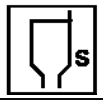
The parts are **CUMULATIVE.**
DO NOT TARE/ZERO OUT THE SCALE BETWEEN ADDITIONS.

Mixed Color	T510 Converter		T581 Activator	T494 Thinner	Approx. RTS Volume
Parts (Grams)	Parts (Grams)	STIR WELL	Parts (Grams)	Parts (Grams)	Oz.
140 (124)	200 (177)		230 (204)	270 (239)	8
280 (248)	400 (355)		460 (408)	540 (479)	16
420 (372)	600 (532)		690 (612)	810 (718)	24
560 (497)	800 (709)		920 (816)	1080 (958)	32
700 (621)	1000 (887)		1150 (1020)	1350 (1197)	40
840 (745)	1200 (1064)		1380 (1224)	1620 (1437)	48
980 (869)	1400 (1241)		1610 (1428)	1890 (1676)	56
1120 (991)	1600 (1416)		1840 (1628)	2160 (1911)	64

Sprayable viscosity should be between 18-21 seconds, Din 4 cup. If necessary, a small amount of additional thinner (less than 5%) may be added to improve sprayability.

MIXED PRODUCT DETAILS

Pot Life: 1 hour at 70°F (21°C)



Spray Viscosity: 18-21 seconds DIN4 70°F (21°C)

APPLICATION

HVLP Spraygun: 1.2 - 1.4 mm
Refer to manufacturer's recommendation for inlet air pressure.

Application: Apply one double coat or 2 single coats to give a dry film thickness of 0.5 - 1.0 mils.

FLASH OFF

Between coats, blow dry for the optimum process times.
Allow 15-20 minutes at 70°F (21°C) before handling.

TECHNICAL DATA

RTS Combinations	Internal Repair Color	Internal Repair Color: T581 : T494	Internal Repair Color: T581 : T494
Applicable Use Category	Underbody Coating	Underbody Coating	Underbody Coating
Weight Ratio:	Packaged	100 : 15 : 15	100 : 15 : 20
Density (g/L)	996-1134	1003-1106	1002-1103
Density (lbs./gal.)	8.31-9.46	8.37-9.23	8.36-9.20
VOC Actual (g/L)	91-111	113-128	109-125
VOC Actual (lbs./gal.)	0.76-0.93	0.94-1.07	0.91-1.04
VOC Regulatory (g/L)	290-395	315-369	316-370
VOC Regulatory (lbs./gal.)	2.42-3.07	2.63-3.08	2.64-3.09
Volatiles wt.%	64.83-81.38	65.34-78.07	66.62-78.88
Water wt.%	55.29-71.83	53.84-6656	55.47-67.73
Exempt wt.%	0	0	0
Water vol.%	62.77-72.30	59.68-67.31	61.23-68.46
Exempt vol.%	0	0	0

HEALTH AND SAFETY

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and MSDS of all the components, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product MSDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Store waterborne and solvent borne waste separately. A competent agent with appropriate certification must handle all waterborne wastes. Wastes must be disposed in accordance with all Federal, State, Provincial and local laws and regulations.
- Blended to spray waterborne Interior Color System with T581 activator has a flash point above 200°F and may be disposed in the waterborne waste stream intended for waterborne basecoat. The waste disposal facility should be informed that the waste stream contains isocyanates. T581 activator handled alone should be disposed of in the solvent borne waste stream.
- Always observe all applicable precautions and follow good safety and hygiene practices.

Emergency Medical or Spill Control Information: (412) 434-4515; In Canada (514) 645-1320

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