ENVIROBASE®
HIGH PERFORMANCE

Product Information

ENVIROBASE® High Performance ONEVISIT™ Modifier
T4900 Standard Temperature Modifier
T4910 Hot and Dry Modifier

Product Description

Envirobase High Performance *OneVisit* modifier T4900 and T4910 allows for one visit in the spray booth when applying *Envirobase* basecoat.

The process is simple. Apply the coverage coats of basecoat to opacity, followed by final control coat into the wet film to achieve a uniform final finish.

VMW5556 Blending Adjuster should be used for the blending process applied as a wet full coat in the blend area.

Preparation of Substrate

Apply over original sanded and clean 2K finishes or a range of PPG primers - Refer to primer TDS for specific recommendations. The use of Grey A-Chromatic sealers is recommended for optimum results.

Note: **Do not apply over 1K or 2K Wash Etch Primers**

Wash off residues and dry thoroughly before re-cleaning with appropriate waterborne pre-cleaner. Refer to Technical Data Sheet.
The use of a tack-rag is recommended.

Before Application

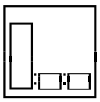
Hand-shake bottles of *Envirobase* tinter and T4900 and T4910 for a few seconds before use. **Do not shake vigorously.**

Mixed Envirobase RFU color 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. A 125 micron mesh is recommended.

APPLICATION GUIDE

Mixing Ratio



Envirobase High Performance Color

	2 Coat	3 Coat Color	
Solid Colors		**Solid Ground Coat/Mid**	
EHP Color	100 Vols	EHP Color	100 Vols
T4900/T4910	5 Vols	T4900/T4910	5 Vols
T494/T595	15 Vols	T494/t595	15 Vols
Metallic/Mica Colors		**Metallic Ground Coat/Mid**	
EHP Color	100 Vols	EHP	100 Vols
T4900/T4910	20 Vols	T4900/T4910	20 Vols
Blending Adjuster			
VWM5556	100 Vols		
T4900/T4910	20 Vols		

Envirobase High Performance Color + T493

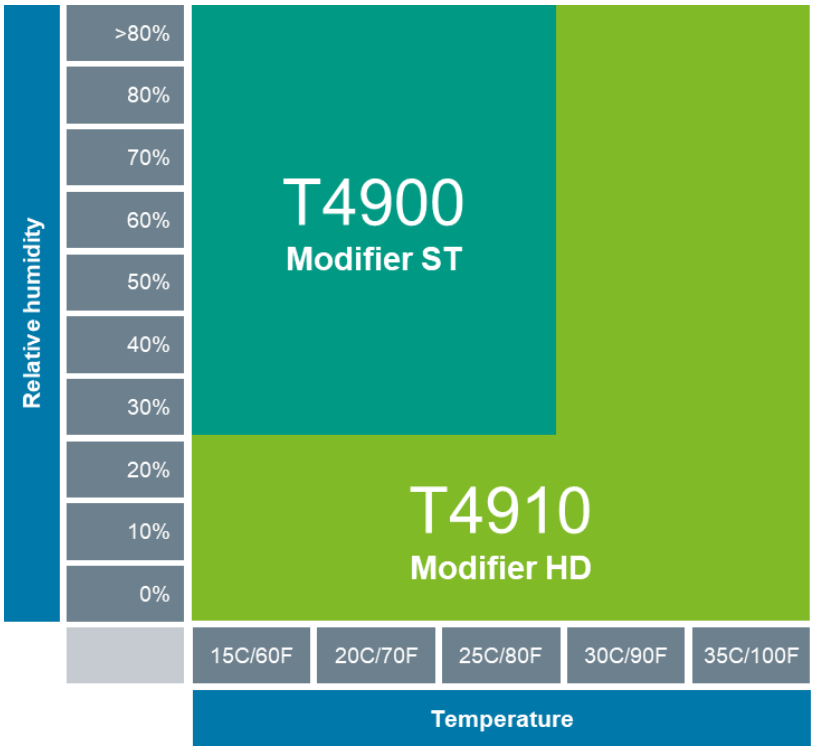
The addition of T493 is optional but reduces flash time between coats and improves final appearance & application

Solid		**Blending Adjuster**	
EHP Color	100 Vols	VWM5556	100 Vols
T4900/T4910	10 Vols	T4900/T4910	20 Vols
T494/T595	15 Vols	T494/T595	5 Vols
T493	5 Vols	T493	5 Vols
Metallic			
EHP Color	100 Vols		
T4900/T4910	20 Vols		
T494/T595	5 Vols		

Thinner Selection

VWM5556: Blending Adjuster
T494/T595: WB Thinners
T493: Hardener

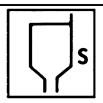
Temperature and Humidity Recommendation Chart:



NOTE: If humidity is below 30%, add 5% of T595 by volume.

APPLICATION GUIDE

Viscosity



Viscosity will vary pending the color/tinter combinations and mix ratio.
(If needed viscosity can be adjusted accordingly using T494 or T595)

Spray Gun Setup

Fluid Tip: Conventional/RP: 1.2 -1.3 mm
HVLP: 1.3 -1.4 mm

Inlet Pressure & Needle Setting

Full Panel: 25-27 psi inlet Pressure (Coverage coat and Control coat)
Full Trigger (Full wet uniform coat) followed by 1 1/4 -1 1/2 turns out from fully closed (Control Coat).

Blend In Process/area: 20-22 PSI inlet pressure
Trigger 1 1/4 turns out through the blend process
1 1/4 turns out (Control Coat)
Use reverse technique
See Blend Process Best Practice Section

Flash Off Process:

There are several ways and/or equipment to be used for the flash off process.
Flash off process:
•Raise temperature to 100-120°F (40-50C) until matte
Or
•Leave it to flash in ambient spray booth temperature and air flow.
Flash off process using blowers:

Air assisted low flow blowers mounted in booth in combination with 100-120°F (40-50C). Handheld or blowers by stand allow maximum inlet pressure 29 PSI (2 bar)

Handheld or blowers by stand keep a good distance from the panel – 39 inches (1 meter)

NOTE:
- If IR is used on clearcoat, then IR is required for the basecoat.

Blend-in Technique:

When performing a blend process, a Blending Adjuster is needed for most “Critical Colors” like – Silver Metallic, Light Metallic and Mica colors

Application process 2CT:
1. Prepare VWM5556 Blending Adjuster RFU in a separate spray gun or any dispenser system.
2. Apply the Blending Adjuster on adjacent panel or only in the area to be blended. The Blending Adjuster has to be applied as a wet uniform layer to enable the pigments/RFU color to get the correct lay-down and metallic orientation.
3. Apply 1 one thin coat of RFU color in the repair area, followed by reverse blend-in process to opacity. Avoid heavy coats. Blend the fading-out area as smooth as possible using reverse blend technique.
1. End the process with a light control coat in the blend area.
2. Apply hereafter full panel application process with RFU color on new/repaired panel.

Application process 3CT:
Required only for light metallic colors in step 1: Apply the VWM5556 Blending Adjuster in the area to be blended. The Blending Adjuster has to be applied as a wet layer to enable the pigments/RFU color to get the correct lay-down and metallic orientation.

3CT STEP 1:
A. Apply 1 coat one thin coat of Step 1 RFU color in the repair area, followed by reverse blend in process to opacity. Avoid heavy coats. Blend the fading-out area as smooth as possible using reverse technique. NOTE* Step 1 RFU Color has to be focused as limited as possible into the adjacent panel.
B. End Step 1 RFU color process with a light control coat in the blend area.(If the blend looks smooth, control coat is not needed.)
C. Allow STEP 1 to dry until matte.

CONTINUED ON NEXT PAGE, SEE 3CT STEP 2

APPLICATION GUIDE, continued

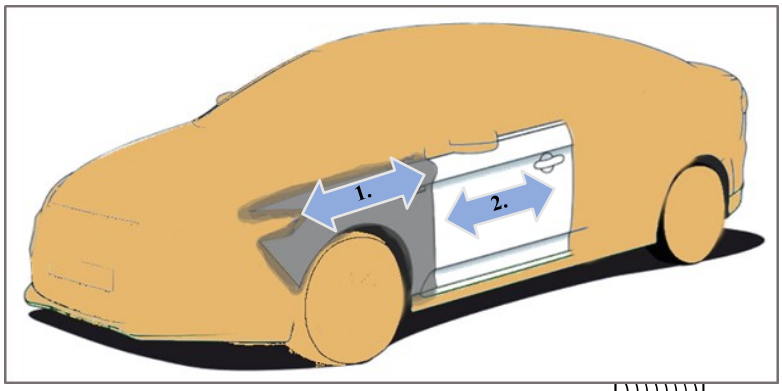
Blend-in Technique, continued

3CT STEP 2:

A. Apply the VWM5556 Blending Adjuster on the adjacent panel or only in the area to be blended. The Blending Adjuster has to be applied as a wet layer to enable the pigments/RFU color to get the correct lay-down and metallic orientation.
B. Apply 1 one thin coat of Step 2 RFU color in the repair area extending blend area over step 1, hereafter followed by reverse blend in process to correct appearance. Avoid heavy coats. Blend the fading-out area as smooth as possible using reverse blend technique
C. End the process with a light control coat in the blend area.
D. Follow full panel application process on new/repaired panel.

1. Repaired or new panel

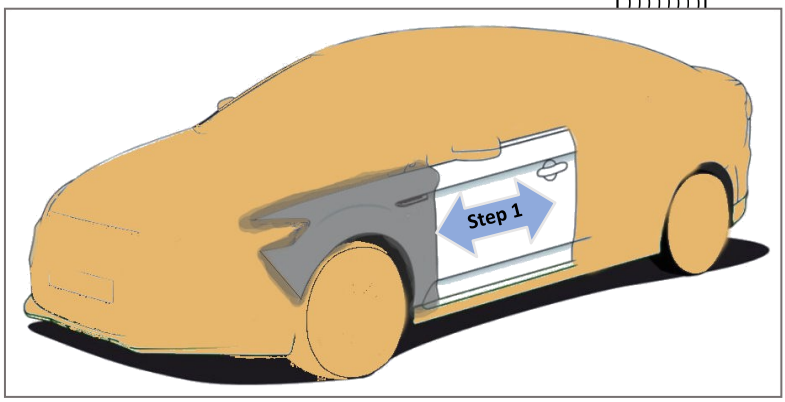
2. Adjacent panel



1: Blending Adjuster

Step 1. Apply the blend bed adjuster as a wet coat on the adjacent panel or in only in blend/fade-out area.

(The Blending Adjuster will allow the correct pigment lay down in the blend area)

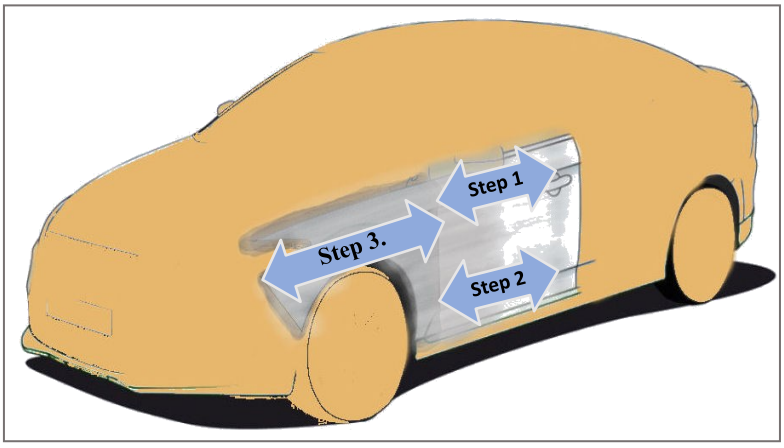


2: BASECOAT Color RFU

Step 1. Apply a light coat into the Blending area.

Step 2. Apply STD blend process into the Blending Area. Blend/fading-out as smooth as possible. End the blend process with a light control coat on blend area.

Step 3.Apply basecoat color on repaired panel to opacity.



APPLICATION GUIDE, continued

Repair & Recoating

Overcoating:
Envirobase OneVisit ready-for-use mix can be overcoated with an Envirobase clearcoat after flash off till matte.

De-nib:
It is possible to de-nib *Envirobase OneVisit*, after flash off, with fine sanding paper – P1000-1500 (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.

Equipment Cleaning

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

Use SWX100 Waterborne Spray Gun Cleaner.

Ensure all equipment is completely dry before storage or use.

Storage & Handline

Envirobase tinters, mixed color, and *OneVisit* modifier 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 42°F (5°C) and a maximum of 95°F (35°C). Avoid exposure to frost or freezing conditions.

Shelf life:2 Years (Unopened T4900 and T4910) RFU: 1 Month

Envirobase should be mixed in clean, dry containers and equipment. Do not use mixing containers or spray equipment that contains solvent residues. Mixing containers should ideally be plastic - If metallic, they should have an internal anti-corrosion coating .

VOC Information

RTS Combinations:	EHP : T4900	EHP: T4900 :T595	EHP : T4910	EHP : T4910 : T595
Volume Ratio:	100:20	100:05:15	100:20	100:05:15
Applicable Use Category	Color Coating	Color Coating	Color Coating	Color Coating
VOC Actual (g/L)	35-121	12-98	36-122	12-98
VOC Actual (lbs/gal)	0.29-1.01	0.1-0.82	0.3-1.02	0.1-0.82
VOC Regulatory (less water	135-392	59-371	140-395	59-371
VOC Regulatory (less water less exempt) (lbs/gal)	1.13-3.27	0.49-3.1	1.17-3.3	0.49-3.1
Density (g/L)	1007-1022	1010-1026	1008-1025	1010-1027
Density (lbs/gal)	8.4-8.53	8.43-8.56	8.41-8.55	8.43-8.57
Volatiles wt. %	76.2-80.6	77.9-82.3	76.2-80.6	77.9-82.3
Water wt. %	68.6-72.8	72.6-76.7	68.5-72.7	72.6-76.7
Exempt wt. %	0	0	0	0
Water vol. %	69.2-74.6	73.5-78.9	69.2-74.6	73.5-78.9
Exempt vol. %	0	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.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.
- 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

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning systems listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, result, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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