

# PPG AQUACOVER™ ONE 625

## DESCRIPTION

One-component, waterborne acrylic zinc phosphate primer

## PRINCIPAL CHARACTERISTICS

- Primer for interior accommodations, machinery spaces and engine rooms
- Particularly suitable when solvents are not permitted because of health and safety reasons
- Excellent adhesion to various types of old- or weathered coatings
- Good adhesion to steel
- Good anticorrosive properties
- Fast-drying and recoatable
- Allows safer working during hull outfitting of new-buildings

## COLOR AND GLOSS LEVEL

- Offwhite
- Flat

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	One
Mass density	1.2 kg/l (10.0 lb/US gal)
Volume solids	42 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 4.0 g/kg
Recommended dry film thickness	50 - 75 µm (2.0 - 3.0 mils) per coat
Theoretical spreading rate	8.8 m²/l for 50 µm (353 ft²/US gal for 2.0 mils) 5.9 m²/l for 75 µm (235 ft²/US gal for 3.0 mils)
Dry to touch	1 hour
Overcoating Interval	Minimum: 6 hours Maximum: Unlimited
Shelf life	At least 18 months when stored cool and dry

### Notes:

- See ADDITIONAL DATA – Spreading rate and film thickness
- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

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## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils) or power tool cleaned to min. ISO-St3
- Steel with approved shop primer; sweep blasted to SPSS-Ss or power tool cleaned to SPSS-Pt2
- Compatible previous coat must be dry and free from any contamination

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### Substrate temperature and application conditions

- Substrate temperature during application should be above 10°C (50°F)
- Substrate temperature during application should be at least 3°C (5°F) above dew point
- Relative humidity during application should not exceed 75%

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## INSTRUCTIONS FOR USE

- Stir well before use
- The temperature of the paint should preferably be above 15°C (59°F), otherwise extra thinner may be required to obtain application viscosity
- Too much tap water results in reduced sag resistance
- Adequate ventilation must be maintained during application and curing
- Must be protected from freezing at all times during storage and/or transport

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### Airless spray

#### **Recommended thinner**

Tap water

#### **Volume of thinner**

0 - 5%, depending on required thickness and application conditions

#### **Nozzle orifice**

Approx. 0.48 – 0.58 mm (0.019 – 0.023 in)

#### **Nozzle pressure**

12.0 - 15.0 MPa (approx. 120 - 150 bar; 1741 - 2176 p.s.i.)

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### Brush/roller

- Long haired brush or polyether roller with rounded edges

#### **Recommended thinner**

Tap water

#### **Volume of thinner**

0 - 5%

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## Cleaning solvent

Tap water and THINNER 40-25

## Cleaning procedures

- Pulsator filter and tip filter must be taken out of the equipment and cleaned properly
- The following tables illustrate the cleaning procedure of the spray equipment when changing from spraying with solvent-borne paint to waterborne paints (table 1) and from waterborne paints to solvent-borne paints (table 2)

**Table 1: Cleaning procedure from solvent-borne to waterborne paints**

Steps	Cleaning text
1st cleaning	THINNER 90-53
2nd cleaning	THINNER 40-25
3rd cleaning	With warm tap water of 30°C (86°F) to 35°C (95°F) after which waterborne paints can be sprayed

**Table 2: Cleaning procedure from waterborne to solvent-borne paints**

Steps	Cleaning text
1st cleaning	Warm tap water of 30°C (86°F) to 35°C (95°F)
2nd cleaning	THINNER 40-25
3rd cleaning	THINNER 90-53

## ADDITIONAL DATA

### Spreading rate and film thickness

DFT	Theoretical spreading rate
50 µm (2.0 mils)	8.8 m²/l (353 ft²/US gal)
75 µm (3.0 mils)	5.9 m²/l (235 ft²/US gal)

Note: Maximum DFT when brushing: 50 µm (2.0 mils)

### Overcoating interval for DFT up to 75 µm (3.0 mils)

Overcoating with...	Interval	10°C (50°F)	20°C (68°F)	30°C (86°F)
itself, and AQUACOVER ONE 645	Minimum	8 hours	6 hours	4 hours
	Maximum	Unlimited	Unlimited	Unlimited

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Curing time for DFT up to 75 µm (3.0 mils)	
Substrate temperature	Dry to touch
10°C (50°F)	2 hours
20°C (68°F)	1 hour

## SAFETY PRECAUTIONS

- See Safety Data Sheet and product label for complete safety and precaution requirements
- Although this is a waterborne paint, care should be taken to avoid inhalation of spray mist, as well as contact between the wet paint and exposed skin or eyes

## WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective and Marine Coatings to supply the same product on a worldwide basis. However, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances. Under these circumstances an alternative product data sheet is used.

## REFERENCES

- EXPLANATION TO PRODUCT DATA SHEETS
- INFORMATION SHEET
- 1411

## WARRANTY

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