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 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 m^2/l for 50 µm (353 ft^2/US gal for 2.0 mils) 5.9 m^2/l for 75 µm (235 ft^2/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

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%

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

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%

Cleaning solvent

- Tap water and THINNER 40-25

CLEANING PROCEDURE

- 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 of cleaning procedure

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

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ADDITIONAL DATA

Spreading rate and film thickness	
DFT	**Theoretical spreading rate**
50 µm (2.0 mils)	8.8 m^2/l (353 ft^2/US gal)
75 µm (3.0 mils)	5.9 m^2/l (235 ft^2/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 PPG AQUACOVER 45	Minimum	8 hours	6 hours	4 hours
	Maximum	Unlimited	Unlimited	Unlimited

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 & 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

- Information sheet | Explanation of product data sheets

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