ENVIROBASE®
HIGH PERFORMANCE

Product Information

EC800 Ultra Fast Clearcoat

National Rule

Product Description

ENVIROBASE® High Performance EC800 is an ultra fast, high gloss highly productive clearcoat designed specifically for use with *Envirobase* High Performance basecoats. This clearcoat, with its no bake requirement and zero flash between coats, dramatically reduces cycle times while maintaining the quality and appearance required by high production shops.

Preparation of Substrate

- In all cases, wash all surfaces to be painted with soap and water, then apply the appropriate ONECHOICE® cleaner. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.
- Wet sand with US 500-600 / European P800-P1200 grade paper or dry sanding with US 400-500 / European P600-P800 grade paper.
- Wash off residue and dry thoroughly before re-cleaning with appropriate *OneChoice* substrate cleaner. The use of a tack rag is recommended.

APPLICATION GUIDE:

Mixing Ratio for EC800

EC800: **4 vols**
ECH8075/ECH8095: **1 vol**
ECA83/DT1585/SL87: **1 vol**

Refer to PAINTMANAGER™ for exact mix by weight volumes.

Pot Life at 70°F (21°C): with ECA83 Reducer 1-1.5 hours
with DT1855/DT1585/SL87 Reducers: 2 hours

Hardener:		**Accelerated Reducer:**		**Thinner:**	
ECH8075	Clearcoat Hardener	ECA83	Normal 70-85°F (21-29°C)	DT1565	Fast Thinner 60-70°F (16-21°C)
ECH8095	Clearcoat Hardener - Slow			DT1575	Medium Thinner 70-77°F (21-25°C)
				DT1585	Slow Thinner 77-95°F (25-35°C)
				SL87	Retarder*

* Thinner selection may be dependent on temperature and or size of repair. For use in extreme temperatures +95°F/+35°C, SLV898 may be used as a replacement up to one full part for DT1855/DT1585 thinners. For VOC data and additional information, see *OneChoice* product bulletin OC-17.

Optional Additives:

SL814 Universal Flexibilizer: add 10% to RTS volume
SLV73 Fisheye Eliminator: add 1 oz. to RTS quart

When used on plastic parts, EC800 does not require the use of SL814 Universal Flexibilizer. However, for very flexible or leading edge parts such as bumper covers and fascias, the addition of SL814 will improve overall flexibility.
Note: For flattening recommendations, see *OneChoice* bulleting OC-7.

Spraygun Set-up and Pressure:

HVLP: 10 maximum psi at the cap
Fluid Tip: 1.3-1.5 mm
Spray Viscosity: 12-14 seconds DIN 4 at 70°F (21°C)

Note: For best overall results, refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.

Application:

Apply: 2 medium wet coats.

Film Build:

Minimum Dry: 2.0 mils
Maximum Dry: 3.0 mils
Recommended film build per coat wet: 2.0-2.5 mils
Recommended film build per coat dry: 1.0-1.5 mils

Flash Off at 70°F (21°C):

No flash required

Drying Times:

Dust-free:
70°F (21°C) 10-15 minutes
Air Dry to Re-assemble:
70°F (21°C) 1 hour

Force Dry:*
140°F (60°C) N/A
Tape Time:
70°F (21°C) 1 hour
IR (Infrared): N/A

*For in-service delivery at low temperatures (below 60°F/16°C) or inclement weather conditions, allow EC800 a minimum of 4 hours air dry at shop temperature (above 60°F/16°C) or bake for 10 minutes at 120°F/49°C metal temperature and cool for one hour prior to putting into service.

Overcoat / Recoat / Polishing:

Overcoat/Recoat Time: 2-3 hours at 70°F (21°C) air dry or after force dry for 10 minutes at 120°F (49°C) metal temperature and cool down for one hour. EC800 must be sanded before recoating with primer, color or clear.

Grade wet: US 500-600 / European P800-P1200
Grade dry: US 400-500 / European P600-P800

Overcoat with: *Envirobase* High Performance Basecoat, primer, color or clear

Polishing: 30-45 minutes. Polishing is not normally required. If, however, polishing is required to remove minor dirt nibs, wet sand with P1500 and follow normal polishing procedures.

Performance Guidelines:

- Allow basecoat to flash off for 15 minutes (but no longer than 24 hours) before applying EC800, If the basecoat dries longer than 24 hours, additional basecoat must be applied before clearcoating. The timing will depend on thickness and temperature.

Fading Out EC800
After spot repairing. Use *OneChoice* SXA840 blending solvent and apply starting from the outside of the repair moving towards the center of the repaired are to lose the clearcoat blend edge.

Technical Data:

RTS Combinations	EC800 : ECH80xx : ECA83	EC800 : ECH80xx : DT1585	EC800 : ECH80xx : ECA83 +SL814	EC800 : ECH80xx : DT1585 + SL814
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating (Flexed)	Clear Coating (Flexed)
Weight Ratio:	4 : 1 : 1	4 : 1 : 1	4 : 1 : 1 +10%	4 : 1 : 1 +10%
VOC Actual (g/L)	118	104-244	111	98-225
VOC Actual (lbs./ US gal.)	0.99	0.87-2.04	0.93	0.82-1.88
VOC Regulatory (less water, less exempt (g/L)	249-250	226-388	240-241	219-374
VOC Regulatory (less water, less exempt (lbs./ US gal.)	2.08-2.09	1.89-3.24	2.00-2.01	1.83-3.12
Density (g/L)	1059-1093	1017-1119	1074-1105	1044-1129
Density (lbs./ US gal)	8.84-9.12	8.55-9.34	8.96-9.22	8.71-9.42
Volatiles wt.%	64.1-65.2	63.3-66.1	65.1-66.1	64.4-65.5
Water wt.%	0.1	0.1	0.1	0.1
Exempt wt.%	52.9-54.4	39.6-56.8	54.6-56.0	42.8-58.1
Water vol.%	0.1	0.1	0.1	0.1
Exempt vol.%	52.8-52.9	37.1-54.4	53.8-53.9	39.5-55.3
RTS Solids vol.%	33.6	34.1	33.4	33.9
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	539	547	535	544

HEALTH AND SAFETY

See 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.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.
- 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.
- 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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