

PPG AQUACOVER™ ONE 645

DESCRIPTION

One-component, waterborne acrylic dispersion finish

PRINCIPAL CHARACTERISTICS

- Finish for interior accommodations, machinery spaces and engine rooms
- Particularly suitable when solvents are not permitted because of health and safety reasons
- Fast-drying and recoatable
- Good weather resistance
- Good color retention
- Allows safer working during hull outfitting of new-buildings
- Also suitable for exterior environment up to C3H (ISO 12944-6)

COLOR AND GLOSS LEVEL

- White (other colors available on request)
- Gloss

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	44 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 4.0 g/kg; 25 g/l
Recommended dry film thickness	50 - 100 µm (2.0 - 4.0 mils) per coat
Theoretical spreading rate	8.0 m²/l for 50 µm (321 ft²/US gal for 2.0 mils)
Dry to touch	1 hour
Overcoating Interval	Minimum: 12 hours Maximum: Unlimited
Shelf life	At least 24 months when stored cool and dry

Notes:

- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Substrate conditions

- 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 at least 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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Air spray

Recommended thinner

Tap water

Volume of thinner

5 - 10%, depending on required thickness and application conditions

Nozzle orifice

1.8 – 2.0 mm (approx. 0.070 – 0.079 in)

Nozzle pressure

0.3 - 0.4 MPa (approx. 3 - 4 bar; 44 - 58 p.s.i.)

Airless spray

Recommended thinner

Tap water

Volume of thinner

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

Nozzle orifice

Approx. 0.46 – 0.53 mm (0.018 – 0.021 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
- Please contact your PPG representative for availability in your region

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

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	Minimum	16 hours	12 hours	8 hours
	Maximum	Unlimited	Unlimited	Unlimited

Note:

- Surface must be dry and free from any contamination

SAFETY PRECAUTIONS

- 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
- See Safety Data Sheet and product label for complete safety and precaution requirements

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
- Guide | PPG SIGMACARE PLUS | Online guide to maintenance at sea

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