

Product Information

EC530 En-V® Performance Clearcoat

Product Description

EC530 **En-V**® Performance Clearcoat is a high gloss clear designed specifically for use with ENVIROBASE® High Performance Waterborne Basecoat. This clearcoat reduces cycle times while maintaining the quality and appearance required by high production shops. EC530 **En-V** Performance Clearcoat is compliant in all North American refinish markets.

Preparation of Substrate



- Wash all surfaces to be painted with soap and water, then apply the appropriate ONECHOICE®, or DELTRON® 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*, or *Deltron* substrate cleaner. The use of a SX1070 *OneChoice* tack rag is recommended.

APPLICATION GUIDE:

Mixing Ratio for EC530 *En-V* Performance Clearcoat



EC530: 3 parts
ECH5075: 1 part
ECRxx/DT18xx/ 1 part



Usable Pot Life at 70°F (21°C): 2 hours

Hardener:

ECH5075 Standard Hardener

Reducer:

ECR65 Low Temp Reducer	DT1845 Compliant Reducer Normal
ECR75 Mid Temp Reducer	DT1850 Compliant Reducer Medium
ECR85 High Temp Reducer	DT1855 Compliant Reducer Slow
ECR98 Hot and Humid Ultra High Temp Reducer	DT1565 Fast Compliant Thinner
	DT1575 Medium Compliant Thinner
	DT1585 Slow Complaint Thinner

See reducer selection guide on page 4 for additional information

ECR98 is the required retarder for all markets.

Optional Additives:

SLV814 Universal Flexibilizer: add 10% to RTS volume
SL93LV Accelerator add 2% to RTS quart
SLV73 Fisheye Eliminator: add 1 oz. to RTS quart

SLV814 Universal Flexibilizer is recommended not required for plastic parts

Spraygun Set-up and Pressure:

Fluid Tip: 1.3 - 1.5 mm
Spray Viscosity: 16 secs DIN4 at 70°F (21°C)
HVLP: 10 maximum psi at the cap
Compliant: 29 - 40 psi at the gun

Note: Refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.

Application:

Apply: 2 medium wet coats

Film Build:

Minimum Dry Film Build:	2.0 mils
Maximum Dry Film Build:	3.5 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):

Flash: 3 - 5 minutes between coats

Drying Times:

Dust-free:
70°F (21°C) 80 - 100 minutes



Air Dry to Re-assemble:
70°F (21°C) 4 hours minimum

Force Dry:
140°F (60°C) 25 minutes

Tape Time:
70°F (21°C) 3 - 4 hours

IR (Infrared): N/A

All force dry times are quoted for metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature.

Overcoat / Recoat / Polishing:



Overcoat/Recoat Time: 2 hours after recommended air dry or force dry bake cycle.

Re-Repair: Re-repair area must be sanded appropriately before recoating with primer, color or clearcoat



Overcoat with: *Envirobase* High Performance primer, color or clearcoat.

Polishing: After recommended air dry or force dry and cool down, minor dirt nibs can be removed. Sand with P1500 or finer and follow normal polishing procedures.

Performance Guidelines:

Allow basecoat to thoroughly dry before applying EC530 *En-V* Performance Clearcoat. If allowed to dry longer than 24 hours, additional basecoat must be applied before clearcoating. The timing will depend on film thickness, temperature and humidity.

Technical Data:

RTS Combinations	EC530 : ECH5075 : ECRxx/DT18xx	EC530 : ECH5075 : ECRxx/DT18xx + SLV814	EC530 : ECH5075 : ECRxx/DT18xx+ SL93LV	EC530 : ECH5075 : ECRxx/DT18xx + SLV73
Applicable Use Category	Clear Coating	Clear Coating (Flexed)	Clear Coating	Clear Coating
Volume Ratio:	3 : 1 : 1	3 : 1 : 1 +10%	3 : 1 : 1 +2%	3 : 1 : 1 +5%
VOC Actual (g/L)	35-137	36-128	34-128	34-128
VOC Actual (lbs./ US gal.)	0.29-1.14	0.30-1.07	0.28-1.07	0.28-1.07
VOC Regulatory (less water, less exempt (g/L)	73-232	77-226	73-223	73-230
VOC Regulatory (less water, less exempt (lbs./ US gal.)	0.61-1.94	0.64-1.89	0.61-1.86	0.61-1.92
Density (g/L)	1154-1210	1160-1212	1158-1213	1156-1209
Density (lbs./ US gal)	9.63-10.10	9.68-10.11	9.66-10.12	9.65-10.09
Volatiles wt.%	57.7-59.9	59.2-61.2	58.7-60.8	60.0-61.7
Water wt.%	0.0	0.0	0.0	0.0
Exempt wt.%	46.0-57.1	48.3-58.2	47.8-56.0	49.4-59.0
Water vol.%	0.0	0.0	0.0	0.0
Exempt vol.%	40.9-52.7	43.0-53.7	42.4-53.6	44.0-54.7
RTS Solids vol.%	42.8-43.4	41.7-42.3	42.5-42.6	40.7-41.5
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	687-696	669-678	682-683	653-658

EC530 En-V Performance Clearcoat Reducer Selection Guide

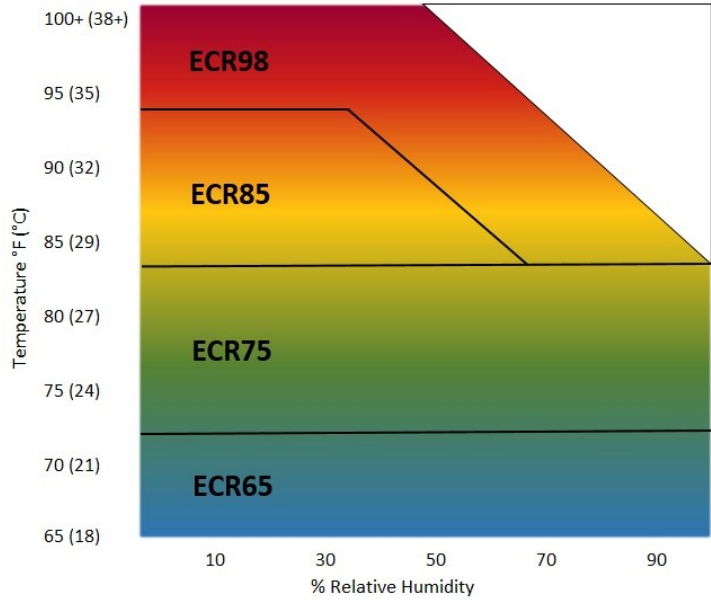
Higher Air Movement
Temperature and Humidity
(Larger)

Average Air Flow & Humidity
12,000-24,000 CFM - 30%-90% RH

Lower Air Movement
Temperature and Humidity
(Smaller)



EC530 EN-V™ Performance Clearcoat Reducer Selection Guide



For Repairs greater than 3 panels consider using the next higher temperature reducer

Temperature, Air Flow, Humidity and Size of the Repair will affect Reducer selection

HEALTH AND SAFETY

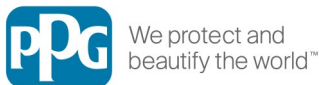
See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



- 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.
- 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

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 statements 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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