

# 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

## 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
Recommended dry film thickness	50 - 100 µm (2.0 - 4.0 mils) per coat
Theoretical spreading rate	8.0 m <sup>2</sup> /l for 50 µm (321 ft <sup>2</sup> /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.)

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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. 0.46 - 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

## WARRANTY

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