



Section 7

Basecoat Application - Standard



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Panel Preparation & Cleaning



Best Practice:

To ensure the vehicle is sufficiently clean and ready for repair PPG recommend that the vehicle is thoroughly cleaned prior to it entering the workshop.

Removal of general traffic film, dirt and tar spots will help ensure a consistent and a RIGHT FIRST TIME repair can always be achieved.

Recommended Best Practice:

Jet Wash or Steam Clean the vehicle.

Any initial 'In Process' cleaning to the repair should be done using both solvent and water based cleaners at all workshop stages. Both cleaners will ensure any mineral salts and contaminants are removed.
(For cleaning polyester bodyfiller – only use solvent spirit wipe)

The PPG Cleaning range includes:

D837 Spirit Wipe and D8401 Waterborne Low VOC Cleaner to assist with this process.

Both products should be used via a pressure pump dispenser bottle.
Excess product is then removed using a premium lint free cloth.

These products are for professional use only.

For full technical specification refer to TDS: RLD63V.

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ENVIROBASE® High Performance Basecoat T4xx

Product Description:

Applied as part of a two-stage or multi-stage basecoat paint system,, **Envirobase High Performance colour** reproduces original solid, metallic, mica or special effect paint finishes, giving excellent covering power and fade out capability.

Best Practice & Application:

- Each tinter should be inverted 2-3 times before pouring.
Best Practice: It is recommended not to shake the bottle.
- Should be kept (stored) ideally in an ambient environment between 15-25°C and not dropping below + 4°C for a sustained period of time

Mixing Ratios

Mixing Ratios with *Envirobase High Performance Colour*

	By Volume
<i>Envirobase Solid Colours</i>	100 Vols
Thinner T494 / T495	10 Vols
<i>Envirobase Metallic or Solid Colours</i>	100 Vols
Thinner T494 / T495	15-20 Vols

Gun Set up:

- A preferred 1.2, 1.3 or WSB** gravity feed spray gun set up will give consistent results across the colour and effect spectrum.

Spraying Pressure:

- 2 bar inlet pressure for the full coats. 1.2 to 1.5 bar for the 'control' coat.

Optimal Application:

- 1 x 25% (light coat) gun dried followed by 1 x 100% coat and then a 75% coat as a wet on wet process to achieve full coverage
- A 25% control coat is then applied to the dried film to attain an even appearance.
- Controlled 75% gun pass overlaps should be used for a consistent uniform final appearance.



Optimal flash-off performance is attained when used in conjunction with mechanical drying (dehydrating) equipment.

** WSB refers to a specific Sata Spray gun set up

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For full technical specification refer to TDS: RLD213V.

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Spraygun Setup

The importance and purpose of setting up or 'balancing' any spraygun correctly for use with PPG paint products are as follows:

- Ensuring full compliancy with current legislation and to help reduce VOC emissions.
- To achieve a 'right first time' consistent and good quality paint finish to each repair.
- Maximising the paint transfer efficiency, improving process time and reducing paint material usage.
- To help the operative achieve maximum control of paint material flow, whilst optimising the spraygun and products performance.





Standard Application Process



Preparation	Undercoat		Colour	Clearcoat
Bare Metal	D837 DELTRON® Spirit Wipe Ready to Use  	D8092 Deltron Wash Etch Primer Chromate Free Mix: 1:1 Activator: D8293 or D833 (Slow)  	D8521/D8525/D8527 Deltron DP5000 2K Primer Can be applied with a roller Mix: 7:1:1.2 (Spray) Hardener: D8302 Thinner: D8718 (Medium) D8719 (Slow)  	D8177 Deltron Progress Rapid Performance Clearcoat Mix: 2:1:06 Hardener: D8307/08 Thinner: D8757/58  
	D8401 Deltron Waterborne Low VOC Cleaner Ready to Use  	D8561/D8565/D8567 Deltron DP7000 Air Dry Primer Spray Application Mix: 3:1:0.5 Roll Application Mix: 3:1 Hardener: D8270 Thinner: D8727/28  	G1 T4xx ENVIROBASE® High Performance Basecoat Mix: Performance Additive Process for Silver Metallics (greater than 70% aluminium toner) T4xx – 100 Parts T492 – 10 Parts T494 – 10-20 Parts Min Performance Additive Process for all other colours T4xx – 100 Parts T492 – 10 Parts T494 – 5 Parts Min Standard Process for Metallics, Pearls and Special Effects T4xx – 100 Parts T494 – 15-25 Parts Standard Process for Solid Colours T4xx – 100 Parts T494 – 10 Parts 	D8731 & D8430 Deltron Spot Blender Ready to Use  
e-Coat	D837 Deltron Spirit Wipe Ready to Use  	D8501/D8505/D8507 Deltron DP4000 2K Primer Mix: 4:1:2 / 2:1:0.5 Hardener: D8302 / D8238 Thinner: D8715 Thinner: D8740 (Plastic Parts)  	G3	D8131 Deltron UHS Clearcoat Mix: 2:1 Hardener: D8254  
	D8401 Deltron Waterborne Low VOC Cleaner Ready to Use  	Dedicated Engine Bay Colours Mix: 100 Parts Colour 15 Parts D8260 Activator 10-20 Parts T494  	G5 G6 G7 Converting Existing Colours Mix: 70 Parts Envirobase Colour 30 Parts T510 Stir thoroughly then add: 15 Parts D8260 Activator 10-20 Parts T494	D8115 Deltron Matt Clearcoat Mix: 5:1:3.5 Hardener: D8302 Thinner: D8718/19  
				D8117 Deltron Semi-Gloss Clearcoat Mix: 5:1:3.5 Hardener: D8302 Thinner: D8718/19  