Section 6

Basecoat Application - OneVisit™

Basecoat Application - OneVisit™

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.

Basecoat Application - OneVisit™

ENVIROBASE® High Performance *OneVisit* Modifier Basecoat T4xx

Product Description:

Applied as a OneVisit basecoat application 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* HP *OneVisit* Modifier (2CT colours)			
Volume / Parts	Metallic Colours	High Chroma, Red, Green and Blue Mica Colours	Solid Colours and White Mica/ Metallic*
Envirobase HP	100	100	100
T4900 / T4910	20	15	5
T494 / T495			15

*Colours with high T400 content

Mixing Ratios with *Envirobase* HP *OneVisit* Modifier (3CT colours).			
Step	Volume / Parts	Metallic Colours	Solid Colours
Step 1	*Envirobase* HP	100	100
	T4900 / T4910	20	5
	T494 / T495		15
Step 2	T490 + Mica / Solid	100	100
	T494 / T495	20	20

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.

Optimal Application: (OneVisit)

- 1.8 bar inlet pressure (Full coat and Control coat)
- Full Trigger (Full wet uniform coat) followed by 1¼ - 1½ turn out (Control coat).

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

These products are for professional use only.
For full technical specification refer to TDS: RLD213V.

Blend In Process/area:

- 1.5 bar inlet pressure.
- Trigger 1¼ turn out through the blend process - 1¼ turn out (Control coat).
- Use reverse technique.

OneVisit™ Application Process

Preparation

Bare Metal

D837
DELTRON® Spirit Wipe

Ready to Use

D8401
Deltron Waterborne
Low VOC Cleaner

Ready to Use

e-Coat

D837
Deltron Spirit Wipe

Ready to Use

D8401
Deltron Waterborne
Low VOC Cleaner

Ready to Use

Undercoat

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)

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

D8501/D8505/D8507
Deltron DP4000
2K Primer

Mix: 4:1:2 / 2:1:0.5
Hardener: D8302 / D8238
Thinner: D8715
Thinner: D8740
(Plastic Parts)

Dedicated Engine Bay Colours

Mix: 100 Parts Colour
15 Parts D8260 Activator
10-20 Parts T494

Converting Existing Colours

Mix: 70 Parts *Envirobase* Colour
30 Parts T510
Stir thoroughly then add:
15 Parts D8260 Activator
10-20 Parts T494

Select correct Primer shade

- G1
- G3
- G5
- G6
- G7

Colour

T4xx
ENVIROBASE®
High Performance
Basecoat

***OneVisit*
Application Process**

Mixing Ratios with *Envirobase* HP
OneVisit Modifier (3CT colors)

Step	Volume/Parts	Metallic Colors	Solid Colors
Step 1	*Envirobase* HP	100	100
	T4900/T4910	20	5
	T494/T495		15
Step 2	T490 + Mica/Solid	100	100
	T494/T495	20	20

Mixing Ratios with Blending Adjuster

	Volume/Parts
T4904 Blending Adjuster	100
T4900/T4910	20

Clearcoat

D8177
Deltron Progress Rapid
Performance
Clearcoat

Mix: 2:1:06
Hardener: D8307/08
Thinner: D8757/58

D8131
Deltron UHS Clearcoat

Mix: 2:1
Hardener: D8254

D8731 & D8430
Deltron Spot
Blender

Ready to Use

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