August 2024 **341V_AME_OVI**

AquaMax Extra OneVisit Impulso

Aquamax Extra Waterborne Basecoat Colour
OneVisit™ Impulso ST 1.590.9000
OneVisit™ Impulso HD 1.590.9100
Blender Performante 1.978.0093
Aquamax Thinners 1.911.9970
Activator 1.960.0300

PRODUCTS

Aquamax Extra is waterborne basecoat mixing scheme that significantly reduces solvent emissions into the environment and complies with all current and future legislative requirements. *Aquamax Extra* color reproduces original solid, metallic, mica or special effect paint finishes, giving excellent covering power and fade out capability.

The new *OneVisit Impulso* 1.590.9000 and 1.590.9100 allows for One Visit in the spray booth, when applying *AquaMax Extra* basecoat.
The process is simple. Apply the first full coat of basecoat to opacity, followed by final control coat into the wet film to achieve a uniform final finish.
1.978.0093 Blender Performante is a new developed product to be used for blending process applied as a wet full coat in the blend area.

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PREPARATION OF SUBSTRATE

Degrease all surfaces to be painted with appropriate MAX MEYER waterborne substrate cleaner before wet sanding with P800 grade paper or dry sanding with P400-500 grade paper.

Wash off residues and dry thoroughly before re-cleaning with appropriate waterborne MAX MEYER pre-cleaner see - Technical Data Sheet Cleaners.

The use of a tack-rag is recommended.

Apply over original sanded and clean 2K finishes, or a range of MAX MEYER primers - refer to primer TDS for specific recommendations. The use of GreyMatic primers is recommended for optimum results.

Note: Do not apply over 1K or 2K Wash Etch Primers

Wash off residues and dry thoroughly before re-cleaning with appropriate waterborne pre-cleaner see - Technical Data Sheet.

PRE-APLICATION

Hand-shake bottles of *AquaMax Extra* tinter and 1.590.9000/1.590.9100 for a few seconds before use. Do not shake vigorously.
Mixed *AquaMax Extra* RFU colour should be thoroughly hand-stirred before application. If not used immediately it should be hand-stirred again before use.
Use nylon paint filters specially designed for use with waterborne paint materials.
A 125 micron mesh is recommended.

MIXING RATIOS

Mixing Ratios with *AquaMax Extra OneVisit Impulso*(2CT colors).

Volume / Parts	Metallic Colors	High Chroma. Red, Green and Blue Mica Colors	Solid Colors and White Mica/Metallic (*)
AquaMax Extra	100	100	100
1.590.9000 / 1.590.9100	20	15	5
1.911.9970			10 - 15

(*) Colors with high 1.500.1150 content. (+50%)

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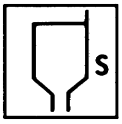
Mixing Ratios with *AquaMax Extra OneVisit Impulso*(3CT colors).

Step	Volume / Parts	Metallic Colors	Solid Colors
Step 1	*AquaMax Extra*	100	100
	1.590.9000 / 1.590.9100	20	5
	1.911.9970		15
Step 2	AquaMax Extra Mica / Solid	100	100
	1.911.9970	20	20

Optional Mix Ratios using hardener/1.960.0300 in RFU: (2CT and 3CT)
Metallic Colors: 100:20:5:5
Solid Colors: 100:10:15:5

Mixing Ratios with Blender Performante

	Volume / Parts
1.978.0093 Blender Performante	100
1.590.9000 / 1.590.9100	20



Viscosity will vary pending the color/toner combinations and mix ratio.
(If needed viscosity can be adjusted accordingly using 1.590.9000 / 1.590.9100)
Potlife RFU: 1 month. Stir well before use

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AQUAMAX EXTRA OneVisit Modifier. SET UP & PROCESSES

Standard Spray gun set-up:

Conventional/RP STD Temp:	1,2mm
Conventional/RP High Temp:	1,3mm
HVLP STD Temp:	1,3mm
HVLP High Temp:	1,4mm

Inlet pressure and needle settings application*:*

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

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.
See Blend Process Best Practice Section

Flash off Process:

There is several ways/equipment to be used for the flash off process.
- Raise temperature to 40ºC – 50ºC till matt
  or
- Leave it to flash in ambient spray booth temperature and air flow.

Flash off process using blowers:

- Air assisted low flow blowers mounted in booth in combination with 40ºC – 50ºC till matt. (10 min waiting not needed)

  Air assisted low flow blowers mounted in booth at ambient spray booth temperature. (10 min waiting not needed)

- Handheld or blowers by stand allow maximum inlet pressure 2 bar
- Handheld or blowers by stand keep a good distance to the panel – 1 meter

*NOTE: For all processes using handheld or by stand blowers, allow 10 min flash off prior blowing process.

Total dry film build: 10 - 20 µm

Drying time with IR equipment will vary pending on color as they have different wave length reflections.

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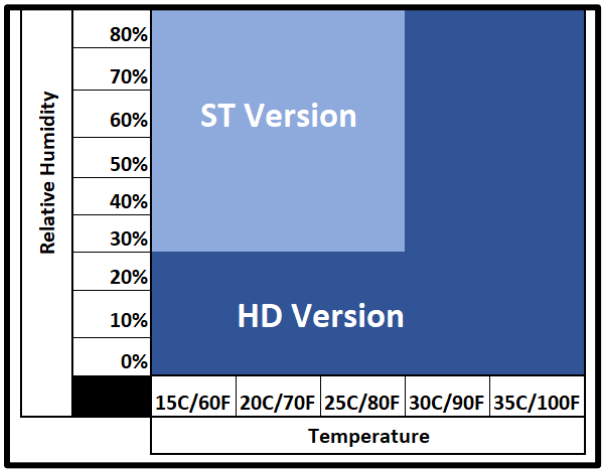
Temperature and Humidity Recommendation Chart:



Thinner selection Below 30-35°C 1.590.9000 Above 30-35°C 1.590.9100

BLEND IN TECHNIQUE

When performing a blend process, a Blender Performante is needed for most “Critical Colors” like – Silver Metallic and Light Metallic colors

Application process 2CT:

1. Prepare 1.978.0093 Blender Performante RFU in a separate spray gun or any dispenser system.

2. Apply the Blender Performante on adjacent panel or only in the area to be blended. The Blender Performante need to be applied as a wet uniform layer to enable the pigments/RFU color to get the correct lay-down and metallic orientation.

3. Apply 1 coat one thin coat of RFU color in the repair area, followed by reverse blend in process to opacity. Avoid heavy layers. Blend the fading-out area as smooth as possible using reverse technique.

4. End the process with a light control coat in the blend area.

5. Apply hereafter full panel application process with RFU color on new/repaired panel.

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Application process 3CT:

1. Only needed for light metallic colors in step 1: Apply the 1.978.0093 Blender Performante RFU in the area to be blended. The Blender Performante need to be applied as a wet layer to enable the pigments/RFU color to get the correct lay-down and metallic orientation.

2. 3CT STEP 1:

3. Apply 1 coat one thin coat of Step 1 RFU color in the repair area, followed by reverse blend in process to opacity. Avoid heavy layers. Blend the fading-out area as smooth as possible using reverse technique.

NOTE Step 1 RFU Color has to be focused as limited as possible into the adjacent panel

4. End Step 1 RFU color process with a light control coat in the blend area.(If the blend looks smooth, control coat is not needed.)

5. 3CT Step 2:

6. Apply the 1.978.0093 Blender Performante RFU on the adjacent panel or only in the area to be blended. The Blender Performante has to be applied as a wet layer to enable the pigments/RFU color to get the correct lay-down and metallic orientation.

7. Apply 1 coat one thin coat of Step 2 RFU color in the repair area extending blend area over step 1, here after followed by reverse blend in process to correct appearance. Avoid heavy layers. Blend the fading-out area as smooth as possible using reverse technique.

8. End the process with a light control coat in the blend area.

9. Apply hereafter full panel application process on new/repaired panel.

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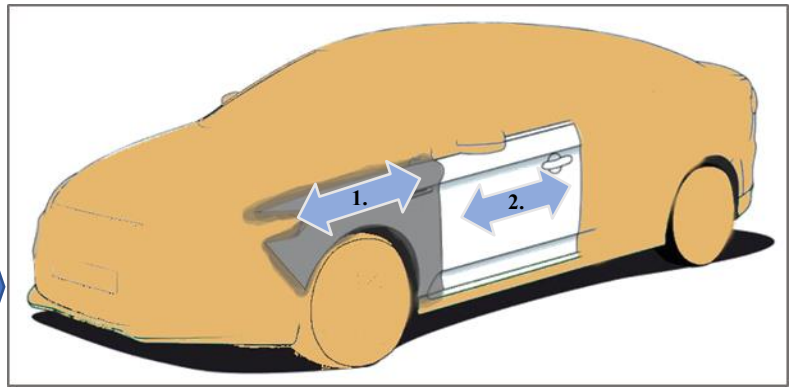
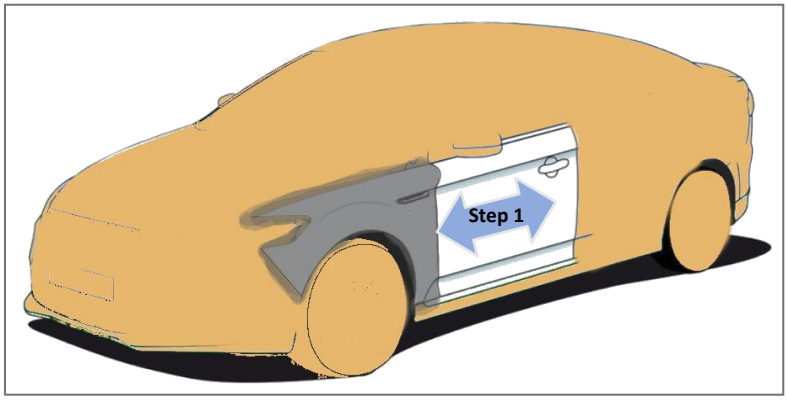
1. **Repaired or new panel**
2. **Adjacent panel**

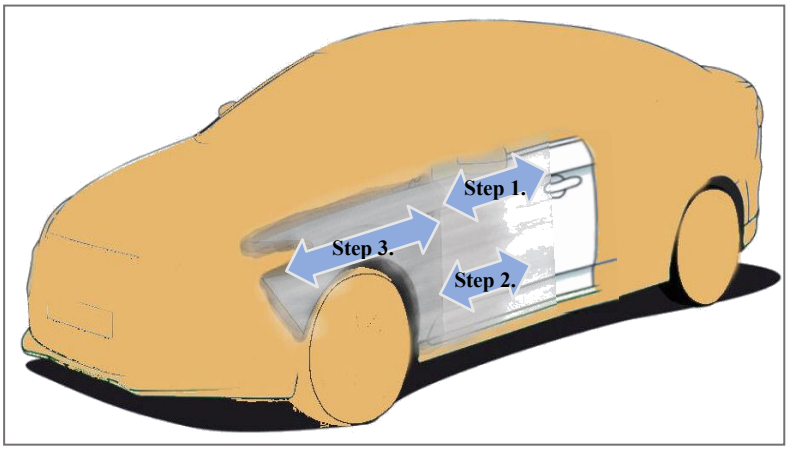


1:
Blending Adjuster
Step 1.Apply the blend bed adjuster as a wet coat on the adjacent panel or in only in blend/fade-out area.

(The Blending Adjuster will allow the correct pigment lay down in the blend area)



2:
WBBC Color RFU
Step 1.Apply a light coat into the Blending area.
Step 2.Apply STD blend process into the Blending Area. Blend/fading-out as smooth as possible. End the blend process with a light control coat on blend area.
Step 3.Apply WBBC color on repaired panel to opacity.



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REPAIR AND RECOATING

Overcoating: *AquaMax Extra OneVisit Impulso*ready for use mix can be overcoated with a MAX MEYER clearcoat after flash off till mat.

De-nib: It is possible to de-nib *AquaMax Extra OneVisi*t Modifier, after flash off, with fine sanding paper – P1000-1500 (dry paper) using air blowing and a tack rag to remove sanding dust and followed by a spot repair (see FADING-OUT section) prior to the clearcoat application.

EQUIPMENT CLEANING

- Clean all mixing equipment immediately after use, preferably using a dedicated waterborne equipment cleaning machine.
- Use tap water, with a final rinse using deionized water or an alcohol-based cleaner such as D846.
- Ensure all equipment is completely dry before storage or use.

STORAGE & HANDLING

ENVHP tinters, mixed colour & *OneVisit Impulso*should be stored in a cool, dry place away from sources of heat. During storage and transportation temperatures must be maintained at a minimum of +5°C and a maximum of +35°C. Avoid exposure to frost or freezing conditions.

Shelf life: 2 years (Unopened 1.590.9000/1.590.9100) RFU Mix: 1 Month.

ENVHP should be mixed in clean, dry containers and equipment. Do not use mixing vessels or spray equipment that contains solvent residues. Mixing vessels should ideally be plastic - if metallic they should have an internal anti-corrosion coating.

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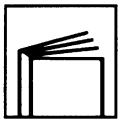
VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC.
The VOC content of this product in ready to use form is max. 420g/litre.
Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

WASTE HANDLING & DISPOSAL / HEALTH & SAFETY



These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: **www.MaxMeyerrefinish.com**

Store waterborne & solventborne wastes separately. All wastes must be handled by a competent agent with appropriate certification. Waste **must** not be disposed of into drains or watercourses.

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