



AQUAMAX® Extra Basecoat - Under Bonnet Repair series 550

PRODUCT DESCRIPTION

The *AquaMax* Extra Basecoat Under Bonnet Repair Process is designed to simplify and speed up repairs to vehicles where the finish in the engine bay area is different to the external finish. It can be used where the engine bay of a vehicle is finished in a different colour to the external panels or where the engine bay is simply a lower gloss version of the external colour. The activated mix can be applied directly to electrocoat to accurately reproduce the engine bay finish as well as act as a wet-on-wet groundcoat to all external layers that need to be topcoated. This removes the need to undercoat and colour the internal area and allows internal and external areas to be coated in one step, an invaluable efficiency of time.

PRODUCTS

TYPE	DESCRIPTION	CODE
COLOUR	<i>AquaMax</i> Extra Basecoat	Series 550
ADDITIVES	<i>AquaMax</i> Extra Engine Bay Additive	E050
	<i>AquaMax</i> Extra Engine Bay Activator	0300
THINNER	<i>AquaMax</i> Extra VOC WB Thinner	9970
CLEANERS	ONECHOICE® Water-Methylated Spirits Cleaner	SWX250
	PROTEC® Heavy Duty Degreaser	AA-6822
	<i>AquaMax</i> Extra VOC WB Gun Cleaner	1700
SPRAYING EQUIPMENT	SATAjet® 5000 B HVLP Digital WSB 0.6L	SATA-210625/UNIT
	[118281] 60 x SATA® RPS 0.3L Disp Cups 125µm (WB)	947-58070/CARTON
	[125062] 57 x <i>Sata</i> RPS 0.6L Disp Cups 125µm (WB)	947-57861/CARTON
	[118471] 40 x <i>Sata</i> RPS 0.9L Disp Cups 125µm (WB)	947-57956/CARTON
	[ANDIS536] WB Pocket Air Dryer	947-58167/UNIT
ABRASIVES	STARTLINE® P1500 Topaz 150mm Grey Scourer UF Disc	STA.00660/UNIT
	<i>Startline</i> P1500 Topaz 152X229mm Grey Scourer UF Pad	STA.00630/UNIT
	<i>Startline</i> P1500 Topaz 115mmX10m Grey Scourer UF Roll	STA.00640/UNIT
	<i>Startline</i> P360 Topaz 150mm Red Scourer VF Disc	STA.00650/UNIT
	<i>Startline</i> P360 Topaz 152X229mm Red Scourer VF Pad	STA.00610/UNIT
	<i>Startline</i> P360 Topaz 115mmX10m Red Scourer VF Roll	STA.00620/UNIT



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SUBSTRATES & PREPARATION



AquaMax Extra Basecoat can be applied over the following substrates when prepared as indicated:

SUBSTRATE	PREPARATION
New electrocoated panels in sound condition	<i>Startline</i> VF Maroon Scourer. Leave the electrocoat as intact as possible; rub-throughs should be coated with <i>OneChoice</i> 1K Epoxy Rub Thru Primers
OEM finishes in sound condition	<i>Startline</i> UF Grey Scourer, by hand or machine.
Sound, fully cured 2 pack refinish finishes	<i>Startline</i> UF Grey Scourer, by hand or machine.
<i>MaxMeyer</i> VOC Wet-On-Wet primers - 9701, 9704 and 9706	Sanding is not required - allow 15 minutes flash off at 25°C.
<i>MaxMeyer</i> 8717 VOC Primer Filler	Block sand with <i>Startline</i> P240 (dry), then orbital sand with <i>Startline</i> P400-P600 (dry).
<i>OneChoice</i> 1K Epoxy Rub Thru Primers - SUA340, SUA440, SUA460 AND SUA540	<i>Startline</i> P800 (dry), by hand.

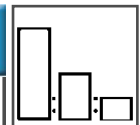
Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Degreaser, followed by SWX250 *OneChoice* Water-Methylated Spirits Cleaner.

The use of a clean tack rag is recommended to remove dust from the surface before topcoating.

Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for it's intended use.

AquaMax Extra Basecoat can NOT be applied directly over acid etch primers.

MIXING RATIO BY VOLUME



Note that the tinter mix must be stirred thoroughly after addition of E050, before activation and thinning.

DEDICATED ENGINE BAY COLOUR

Weigh out colour as per engine bay formula in *Protec* PAINTMANAGER® - the formula will already contain E050.

PRODUCT	PARTS
<i>AquaMax</i> Extra Basecoat engine bay colour	100
0300	15
9970	10 - 15 % - solid colours, for improved coverage
	15 - 20 % - solid and metallic/mica colours

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CONVERTING AN EXISTING COLOUR

Weigh out colour as per the formula in *Protec PAINTMANAGER*®.

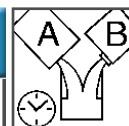
PRODUCT	PARTS
<i>AquaMax</i> Extra Basecoat	100
E050	30
0300	15
9970	10 -15 % - solid colours, for improved coverage
	15 - 20 % - solid and metallic/mica colours

NOTES

- Gently agitate *AquaMax* Extra Basecoat tinters, including E050 *AquaMax* Extra Engine Bay Additive, for a few seconds before use. DO NOT shake vigorously.
- Mixed *AquaMax* Extra Basecoat colours must be thoroughly hand stirred before application.
- Use 125µm Nylon paint strainers/filters that have been specifically designed for waterborne paint - the above *Sata* RPS cups are recommended.
- Mixing vessels ideally should be plastic. If metal they should have an internal anti-corrosion coating.

POTLIFE

1 hour at 25°C, once activated.



SPRAY VISCOSITY

18 - 21 seconds (DIN 4) at 25°C.



SPRAYGUN SETTINGS

The specifications below are for the recommended spraygun, or similar.

GUN TECHNOLOGY	<i>Satajet</i> 5000 B HVLP WSB	
SPRAY PRESSURE	OPACITY COAT	1.2 - 1.5 bar. Suggested fluid control: two turns out from closed with the fan control fully open.
	CONTROL COAT	1.1 bar Suggested fluid control: one turn out from closed with the fan control fully open.





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APPLICATION & FLASH OFF



APPLICATION

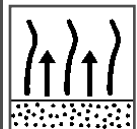
STANDARD	Apply single coats at 1.2 - 1.5 bar until opacity is reached
EXPRESS	Apply light even double coats at 1.2 - 1.5 bar until opacity is reached

Note: Heavy application must be avoided, or popping of the film may result

FLASH OFF

BETWEEN COATS		Until uniformly matt.
BEFORE CLEARCOAT	AIR DRY (25°C, <50% humidity)	Until uniformly matt and dry.
	INFRA RED	Dry until the film becomes uniformly matt before using an I.R lamp. 2 minutes - Short Wave 3 minutes - Medium Wave

Note: Drying may be accelerate using an air blower/mover



PERFORMANCE TIPS

- **Optimising metallic/pearl control & process speed:** Apply a control coat onto a dry film.
- **Spray booth cycle time reduction:** The clearcoat should be made Ready For Use and brought into the spray booth at the same time as the basecoat.
- **Air blowers/movers:** Use an air blower/mover, such as 947-58167/UNIT. *DO NOT use the spraygun as an air blower - this will result in oil and dust particles in the film.*

TOTAL DRY FILM BUILD

10 - 20 µm.



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REPAIR, RECOATING & TOPCOATING



DE-NIBBING

De-nib dry and uniformly matt *AquaMax* Extra Basecoat with *Startline* P1000 - P2000, cushioned with air. Tack rag to remove sanding dust and recoat before applying clearcoat.

RECOATING

After 24 hours, one coat of *AquaMax* Extra Basecoat or E010 must be applied prior to clearcoat application. Maximum recoat time is 48 hours, after which it must be thoroughly sanded and recoated.

EQUIPMENT CLEANING

Clean all mixing equipment immediately after use, using a dedicated waterborne equipment cleaning machine, with a final rinse using 1700 *AquaMax* Extra VOC WB Gun Cleaner or an alcohol-based cleaner such as SWX250 *OneChoice* Water-Methylated Spirits Cleaner.

Ensure all equipment is completely dry before storage or use.

STORAGE

- Store in a dry place away from heat
- During storage and transportation, maintain temperature between 5°C and 35°C
- Avoid exposure to frost or freezing conditions

HEALTH & SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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