

GENERAL INFORMATION

W00 - W999 Octobase Eco Plus System is a waterbased base-coat layer in a clear-over-base system. Suitable for passenger cars, touring cars and commercial vehicles. With a complete range of toners which provide you the option to mix the most common OEM colours in the market.

MIXING RATIO



Thinner is implemented in the colour formulation.

Custom made formulas add 10% TW80 Octobase Eco Thinner or TW81 Octobase ECO Thinner Slow.

Shake lightly.



GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3	Please see appendix attached
HE	1,3	Please see appendix attached

APPLICATION



Re-coat with suitable clear coat within 8 hours. After 8 hours scuff and reply base coat.

Please see appendix attached.

FLASH OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	Until dry	Flash off	-
Dust free	-	Dust free	-
Dry to handle	-	Dry to handle	-
Dry to tape	-	Dry to tape	-
Dry to sand	-	Dry to sand	-
Dry to polish	-	Dry to polish	-

Please see appendix attached.

INFRARED DRYING



After full flash off and at proper distance	
Half-bake	5 min 60°C
Full-bake	
See IR Manufacturer information	

SUBSTRATES



W00 - W999 Octobase Eco Plus System should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium and primed plastic. Well sanded GRP, OEM primer and old paint systems in good condition.

Please make sure you choose a suitable primer/surfacer by checking the TDS of the primer/surfacer.

POT LIFE AT 20°C / 68°F



6 month

Potlife mentioned is only for ready to spray colours.

FINISHING MATERIALS



All Octoral applicable clear coats.

COMPONENTS



TW80 Octobase Eco Thinner
TW81 Octobase ECO Thinner Slow

ADDITIVES



AW001 Octobase Eco Underhood Additive
BW78/.../ BW89 Special Effect Colours

When adding BW78 /.../ BW89 Special Effect Colours shake the small bottle intensively for 2 minutes before use.

SURFACE PREPARATION



Pre clean the surface with TD20 Silicone Remover wipe on and wipe dry. Sand surface with P400 or finer grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with TD80 Octobase Eco Degreaser wipe on and wipe dry.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



PHYSICAL DATA

EU REGULATIONS W00 - W999 Octobase Eco Plus System	
VOC Code	2004/42/IIIB(d)420)418
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	118/d. Topcoat -All types. EU limit values: 420 g/l. (2007) This product contains a maximum of 418 g/l VOC.
Chemical Base	Acrylic Dispersion
Viscosity (RTS)	-
Specific Gravity (kg/l)	1,008
Flash Point Closed Cup	61°C / 141,8°F
Volume % Solids	14
Economy	7 m ² /L/20 m 280 ft ² /Gal/0,8 mil
Gloss	-
Colour	-

PROTECTION

Use suitable respiratory protection (*fresh air supply respirator is strongly recommended*).



For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.octoral.com/en/octoral/choose_localization

CLEAN UP



TR80 Octobase Eco Gun Cleaner

After cleaning the spray gun thoroughly blow dry the spray gun with compressed air.

STORAGE/SHELF LIFE

Minimum 1 - 2 years; (Under normal storage conditions 5°C - 30°C / 50°F - 90°F) (unopened container).

To prevent freezing, do not expose the product to temperatures below 5°C / 41°F during transportation and storage.

Please see appendix attached.



NOTES

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