

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 re-apply 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	
Physical Properties	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 µm 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).

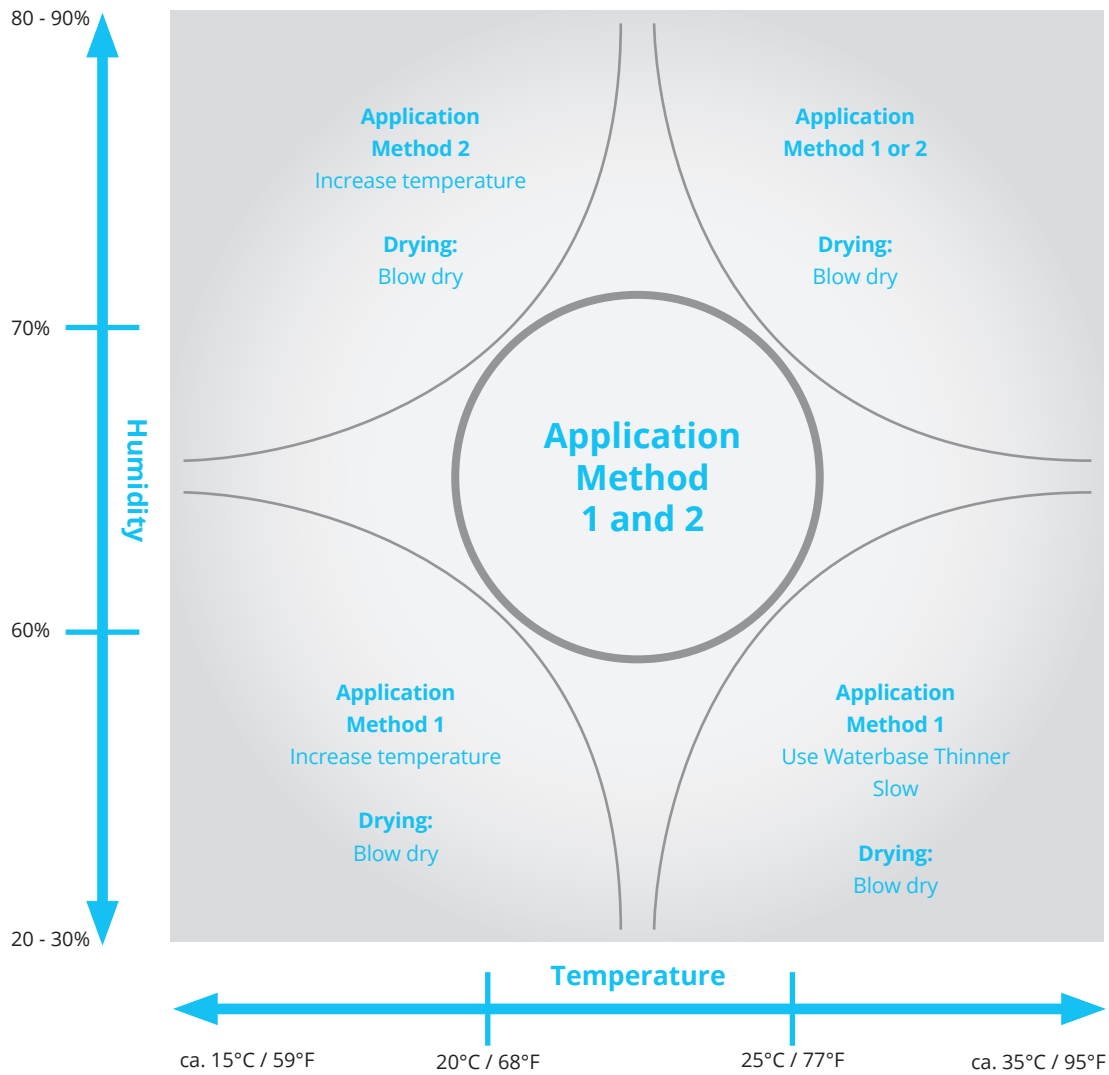
To prevent freezing, do not expose the product to temperatures below 5°C / 41°F during transportation and storage.

Please see appendix attached.



NOTES

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APPLICATION METHOD 1:

	DESCRIPTION	AIR PRESSURE (BAR / PSI)
STEP 1	Two singles wet coats, wet on wet to cover	2 bar / 29 psi
STEP 2	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-
STEP 3	Drop coat (effect colours only)	1 bar / 14,5 psi
STEP 4	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-



NOTES

Surface must be carefully cleaned.
If necessary, first apply a mist coat and blow dry.

APPLICATION METHOD 2: **

	DESCRIPTION	AIR PRESSURE (BAR / PSI)
STEP 1	First single wet coat	2 bar / 29 psi
STEP 2	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-
STEP 3	Second single wet coat	2 Bar / 29 psi
STEP 4	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-
STEP 5	Drop coat (effect colours only)	1 Bar / 14,5 psi
STEP 6	Blow dry untill matt at 30 - 35°C / 85 - 95°F	-

At temperatures between 20 - 25°C and a relative humidity between 60 - 70%, both Application Methods 1 and 2 are recommended.
** Application 2 is preferred for deep black solid colours to achieve the darkest shade.



OCTORAL

BEST PRACTICES

BLENDING PROCESS

GENERAL INFORMATION

Recommendations for blending a challenging aluminium effect colour in to an adjacent part with Octobase Eco Plus Series. Blending high covering effect colours with a greater than 60% of aluminium toner content can be a challenge. Especially when blending these colours in a spot repair or into the adjacent panel depending on the type of colour. To help with blending we now have two formulas on the COINS system.

When viewing the formula screen, the formula *without* the [Blending] box ticked will give fast full coverage.

When viewing the formula screen, the formula *with* the [Blending] box ticked provides an altered formula for less coverage and better blending qualities.

RECOMMEND PROCESS TO FOLLOW INVISIBLE EFFECT COLOUR BLENDING



Colour check

Always determine the right colour and/or colour variant. This should be done at the earliest stage possible, preferably when estimation of the repair is done. Creating a spray-out at this stage is best practice.



Cleaning

Clean with TD20 Silicone Remover and/or TD80 Octobase Eco Degreaser.



Protection

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



OCTORAL

BEST PRACTICES

BLENDING PROCESS

STEP 1 PREPARE BLEND AREA

**Dry sanding**

Prepare the blending area by dry sanding with DA sander orbit 3-5 grit P1500.

Avoid sand through edges.

**Wet sanding**

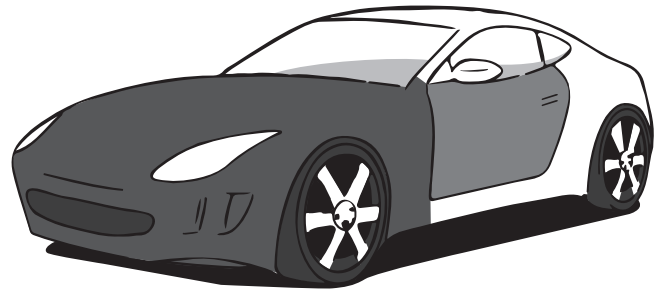
Prepare the blending area by wet sanding using grit P2000/P3000.

**Scuffing**

Prepare the blending area by using scuffing pad fine and ultra fine.

**Cleaning**

Clean with TD20 Silicone Remover and/or TD80 Octobase Eco Degreaser.



STEP 2 MIX & APPLICATION W23

**Blending additive**

Mix W23 blending additive with TW80 Octobase Eco Thinner. Mixing ratio: W23 + 10% TW80.

**Application**

Apply one flowing coat off W23 on 2/3 off the blending area.

**Gun setup**

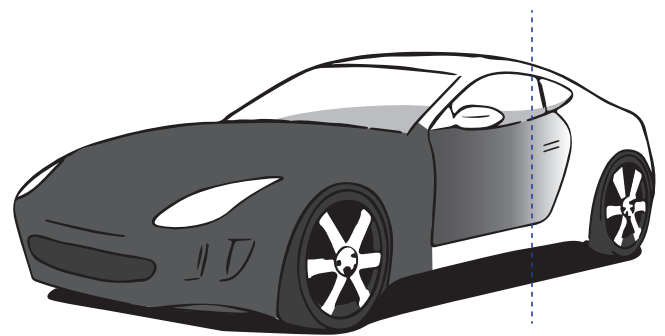
	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2-1,3	2/29
HE	1,2-1,3	2/29

**Flash-off**

Until a uniform matt surface.

**Note**

It is also possible to do this process in reverse, apply Octobase Eco Plus System to full coverage on the repair area, dry the Octobase Eco Plus System then apply the W23 mix to the blend area dry and finish the blending process as described.





OCTORAL

BEST PRACTICES

BLENDING PROCESS

STEP 3 APPLICATION OF WATERBASE



Application Color

Octobase Eco Plus Blending color formula + 10% TW80.
See option in COINS.



Application

Apply 2-3 coats or till covered arcing into blending area. Do not apply color beyond area 3 (See picture).



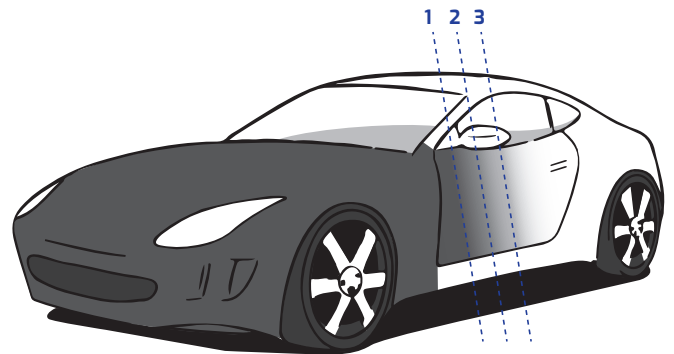
Gun setup

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2-1,3	2/29
HE	1,2-1,3	2/29



Flash-off

Until a uniform matt surface.



STEP 4 APPLICATION WATERBASE DROP COAT



Application dropcoat

Apply dropcoat at double distance at 1 bar. stay with in the blending area. Do not apply color beyond area 3 (See picture).



Gun setup

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2-1,3	1/14,5
HE	1,2-1,3	1/14,5

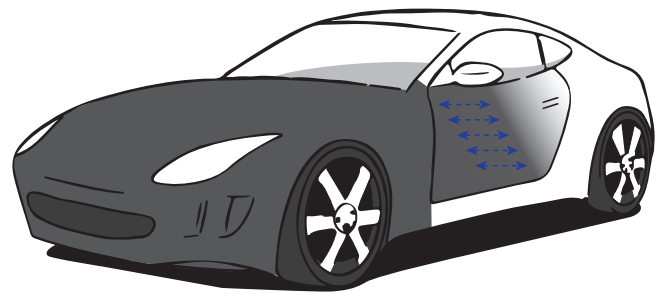


Flash-off

Until a uniform matt surface.



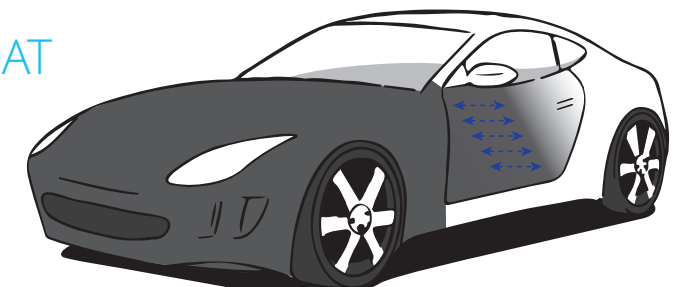
The drop coat must be applied for colour and effect, this will also assist colour blending.



STEP 5 APPLICATION CLEAR COAT



Select a suitable Octoral clear coat and follow the technical information on the TDS.



The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. Unless valspar agrees otherwise in writing, valspar makes no warranties, express or implied, and disclaims all implied warranties including warranties of merchantability or fitness for a particular use or freedom from patent infringement. Valspar will not be liable for any special, incidental or consequential damages. Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option. © 2021 Valspar b.v. All rights reserved.