

## 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 attached Best Practice on page 3.**

## 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.**

## 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 months

**Potlife mentioned is only for ready to spray colours that are not activated with HW65 Octobase Eco Plus Optimum Hardener. Potlife for activated colours is 30 - 60 minutes.**

## COMPONENTS



TW80 Octobase Eco Thinner  
HW65 Octobase Eco Plus Optimum Hardener

**Please refer to best practice on the next pages, this hardener is only suitable in combination with HS420 clear coats.**

## 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.**



## INFRARED DRYING



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

## NEXT LAYER



All Octoral applicable clear coats.

## 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/1 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 m²/L/20 µm 280 ft²/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:

[SDS Octoral](#)

### CLEAN UP



TR80 Octobase Eco Gun Cleaner

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

### PROTECTION



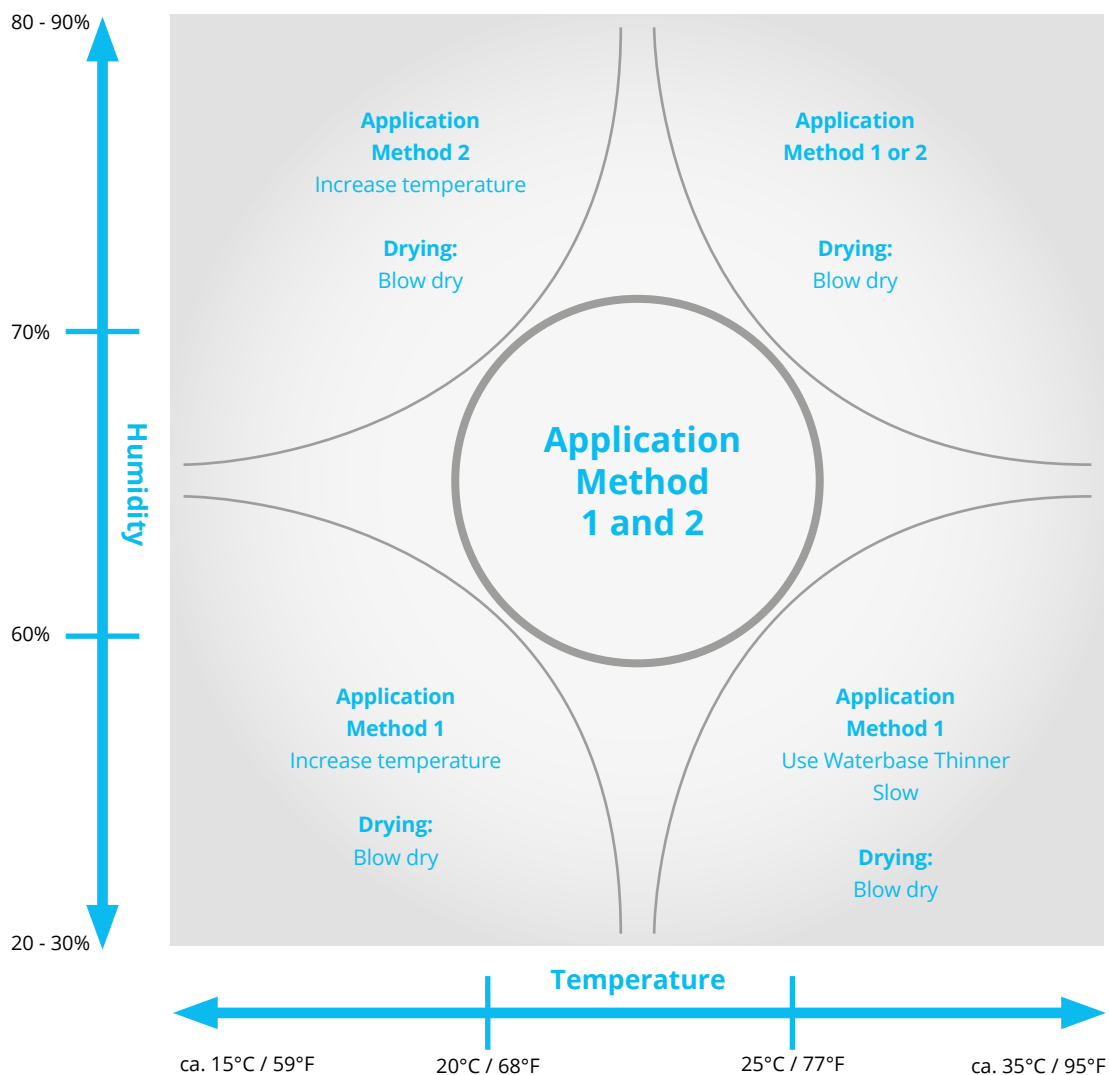
The up-to-date shelf life overview can be found by clicking on the following link:

[Shelf life overview Octoral](#)

**Please see appendix attached.**

### NOTES





### APPLICATION METHOD 1:

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



#### NOTE

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

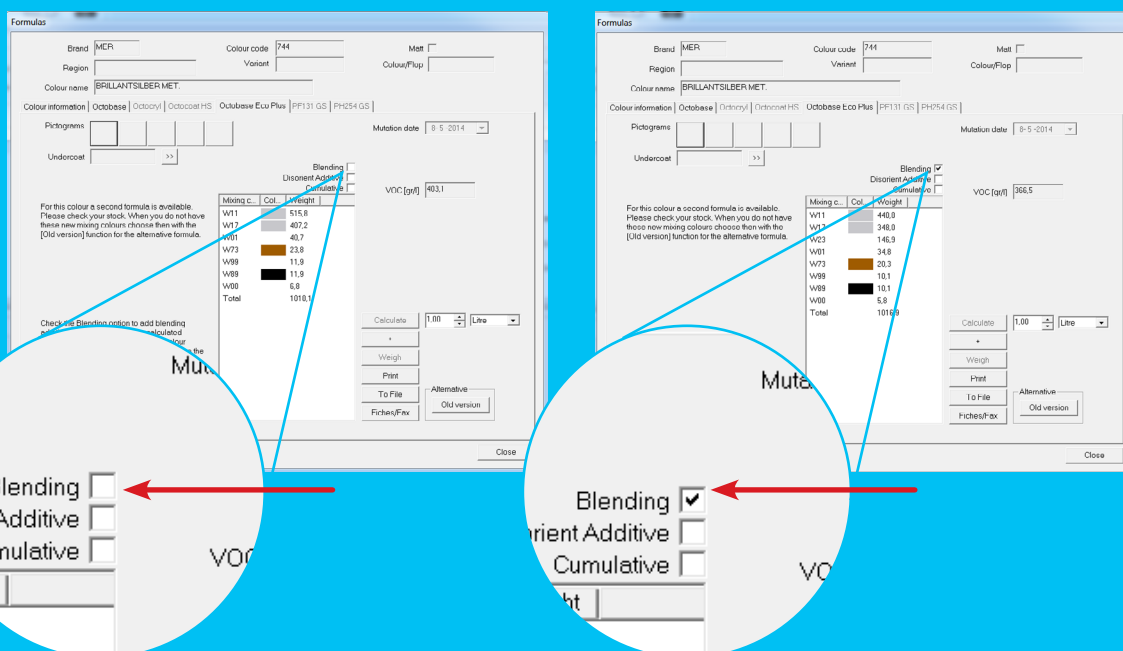
### APPLICATION METHOD 2: \*\*

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

## GENERAL INFORMATION

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



## RECOMMENDED PROCESS TO FOLLOW FOR INVISIBLE EFFECT COLOR BLENDING

### PREPARATION



#### Color check

Always determine the right color and/or color variant. This should be performed at the earliest stage possible, preferably when estimation of the repair is carried out. 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).

## STEP 1 PREPARE BLENDING AREA



### Dry sanding

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

**Prevent sand from entering through edges.**



### Wet sanding

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



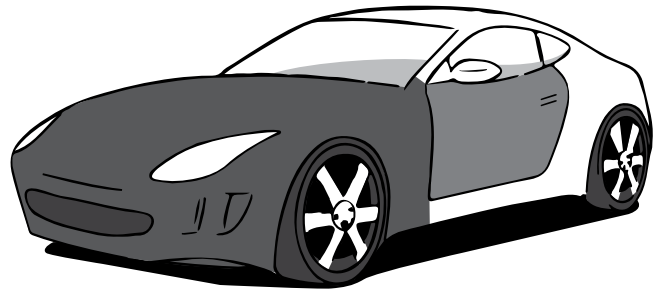
### Scuffing

Prepare the blending area by using an ultra-fine scuffing pad.



### Cleaning

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



## STEP 2 MIXING & 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 of 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



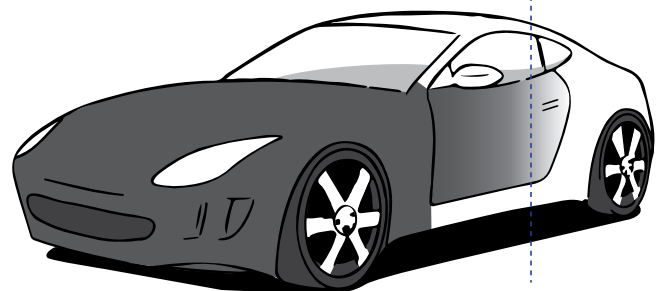
### Flash-off

Until achieving a uniform matt surface.



### Note

It is also possible to carry out this process in reverse order. Apply Octobase Eco Plus System for full coverage on the repair area. Dry the Octobase Eco Plus System then apply the W23 mix to the blending area dry and finish the blending process as described.



## 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 until covered arcing into blending area. Do not apply color beyond area 3 (See picture).



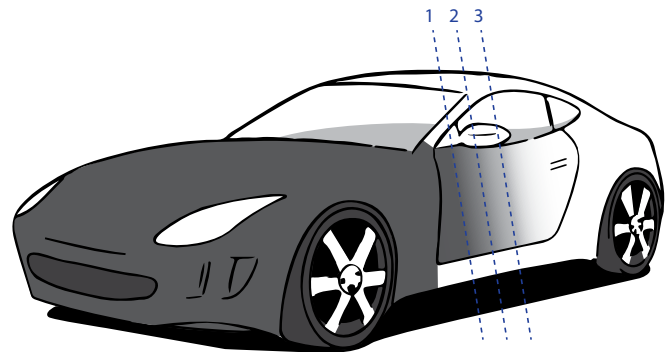
### Gun setup

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



### Flash-off

Until achieving a uniform matt surface.



## STEP 4 APPLICATION OF WATERBASE DROP COAT



### Application of dropcoat

Apply dropcoat at double distance at 1 bar. stay within 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

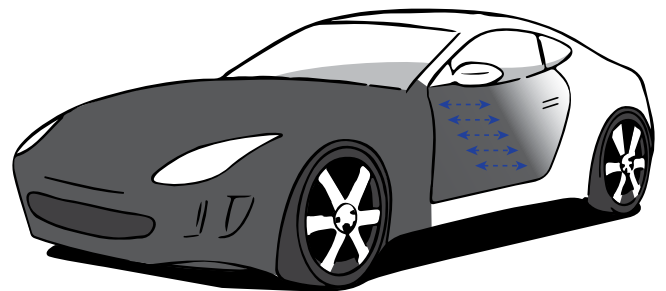


### Flash-off

Until achieving a uniform matt surface.



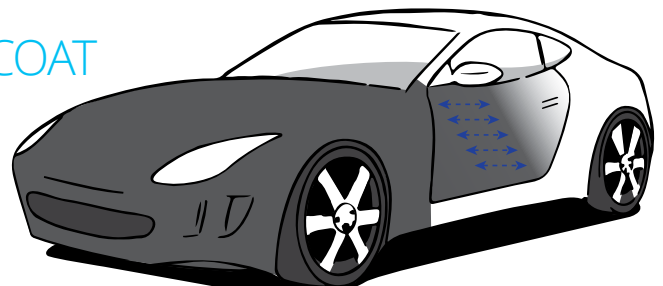
The drop coat must be applied for color and effect, this will also assist color blending.



## STEP 5 APPLICATION OF CLEAR COAT



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



## HW65 OCTOBASE ECO PLUS OPTIMUM HARDENER

### PREPARATION



#### Colour check

Always determine the right colour and/or colour variant. This should be performed at the earliest stage possible, preferably when estimation of the repair is performed. 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).



#### Surface preparation

Use sanding paper grit P500 or finer on repair area, and P1500 on blending area.

## STEP 1



#### Mixing Octobase Eco Plus System (step 1)

Add 2% of HW65 Octobase Eco Plus Optimum Hardener by weight to the mixed and thinned colour formula.



#### Mixing Octobase Eco Plus System (step 2)

Add 15 - 20% of the TW80 Octobase Eco Thinner, Mix thoroughly without incorporating air.



#### Note

After adding the hardener, the activated basecoat should be applied within:

30 minutes for effect colours

60 minutes for solid colours

Clean spray-gun immediately after use.

## STEP 2



#### Application

Apply colour @ 2,0 bar, drop-coat @ 1 bar. For gun set-up see table below. Blend into the adjacent panel if needed.

	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.

### FINISHING PRODUCTS



TD20 Silicone Remover  
C401 HS420 High Production Clear  
C500 HS420 Superb Clear Coat  
C417 Universal Clear  
C600 Rapid Production Clear  
C650 Optimum Clear  
TW80 Octobase Eco Thinner  
TD80 Octobase Eco Degreaser  
HW65 Octobase Eco Plus Optimum Hardener