

Product Information

EC800 Ultra Fast 2.1 Clearcoat

Product Description

EC800 is an ultra fast, high gloss 2.1 VOC highly productive clearcoat designed specifically for use with Envirobase High Performance basecoats. This clearcoat, with its no bake requirement and zero flash between coats, dramatically reduces cycle times while maintaining the quality and appearance required by high production shops. From an environmental standpoint, the low 2.1 VOC of EC800 Clearcoat along with the high solids resin also decreases clearcoat material usage and therefore greatly reduces the overall VOC emissions.

Preparation of Substrate:



In all cases, wash all surfaces to be painted with soap and water, then apply the appropriate OneChoice[®] or Global[®] cleaner. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.



Wet sand with U.S. 500-600 / European P800-1200 grade paper or dry sanding with U.S. 400-500 / European P600-800 grade paper.



Wash off residue and dry thoroughly before re-cleaning with appropriate OneChoice or Global substrate cleaner. The use of a tack rag is recommended.

APPLICATION GUIDE:

Mixing Ratio



EC800	4 vols
ECH8075	1 vol
ECA8x/ D8767 / DT1855 / SLV898	1 vol

Refer to PaintManager™ for exact mix by weight volumes.



Pot life @ 68°F / 20°C	With ECA8x Reducers	1 - 1.5 hours
	With D8767/DT1855/SLV Reducers	2 hours

Hardener

ECH8075

Accelerated Reducer

ECA81 Fast	65°F -75°F / 18°C - 24°C
ECA83 Normal	70°F - 85°F / 21°C - 29°C

Thinner

D8767 or DT1855 77° F - 95°F / 25°C - 35°C
SLV898 Low VOC Retarder*

* Thinner selection may be dependent on temperature and or size of repair. For use in extreme temperatures +95°F / +35°C, SLV898 may be used as a replacement up to one full part for D8767 or DT1855 thinners. For VOC data and additional information, see OneChoice product bulletin OC-17.

Optional Additives:



SLV814	EC800	ECH8075	ECA8x / D8767 / DT1855	SLV814
	4	1	1	+ 10%
SLV73	EC800	ECH8075	ECA8x / D8767 / DT1855	SLV73
	4	1	1	+ 1 oz. to RTS qt.

When used on plastic parts, EC800 does not require the use of SLV814 Universal flexibilizer. However, for very flexible or leading edge parts such as bumper covers and fascias, the addition of SLV814 will improve overall flexibility.

Note: For flattening recommendations, see OneChoice bulletin OC-7.

Spray gun set-up:



Fluid Tip	1.3 - 1.5
Spray Viscosity	12-14 secs DIN 4 @ 20°C / 68°F

Spray pressure:

HVLP at air cap	Max. 10 psi
Refer to the manufacturers gun recommendations for inlet air pressures	

Number of coats:



Apply 2 medium wet coats

Film build:

Minimum Dry	2.0 mils
Maximum Dry	3.0 mils
Recommended film build per coat wet	2.0 - 2.5 mils
Recommended film build per coat dry	1.0 - 1.5 mils

Flash off at 68°F/20°C:



No flash required

Drying Times:

Dust-free	10 - 15 minutes
68°F / 20°C	
Air Dry to Re-assemble	1 hour
68°F / 20°C	
Force Dry*	N/A
140°F / 60°C	
Tape Time	1 hour
68°F / 20°C	
IR (Infrared)	N/A



*For in-Service delivery at low temperatures (below 60°F/ 16°C) or inclement weather conditions, allow EC800 a minimum of 4 hours air dry at shop temperature (above 60°F/ 16°C or above) or bake for 10 minutes @ 120°F / 49°C metal temperature and cool for one hour prior to putting into service.

APPLICATION GUIDE:

Overcoat / Recoat / Polishing



Overcoat / Recoat time

2 - 3 hours at 68°F / 20°C air dry or after force dry for 10 minutes @ 120°F / 49°C metal temperature and cool down for one hour. EC800 must be sanded before recoating with primer, color or clear.



Grade wet

U.S. 500 – 600 / European P800 - 1200



Grade dry

U.S. 400 – 500 / European P600 - 800



Overcoat with

Envirobase High Performance Basecoat, primer, color or clear



Polishing 30 - 45 Minutes

Polishing is not normally required. If, however, polishing is required to remove minor dirt nibs, sand with P1500 or finer and follow normal polishing procedures.

Performance Guidelines

Allow basecoat to flash off for 15 minutes (but no longer than 24 hours) before applying EC800. If the basecoat dries longer than 24 hours, additional basecoat must be applied before clearcoating. The timing will depend on thickness and temperature.

Fading Out EC800

After spot repairing, Use OneChoice SLV840 blending solvent and apply starting from the outside of the repair moving towards the center of the repaired area to lose the clearcoat blend edge.

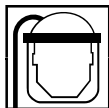
Technical Data

Use of recommended products in ready to spray mixes will be compliant under a Clear Coating VOC limit of 2.1 lbs/gal (250 g/L) in Canada and the US except parts of California. EA81 contains the solvent TBAC. For facilities that are required to track TBAC emissions: ECA81 contains TBAC at 2.7 lbs/gal, a 4:1:1 blend using ECA81 contains TBAC at 0.5 lbs/gal and a 4:1:1+10% blend using ECA81 contains TBAC at 0.4 lbs/gal. Due to unique California air district VOC regulations, EA81 is not allowed for compliant use within that state (only).

RTS Combinations:	EC800 : ECH8075 : ECA8x	EC800 : ECH8075 : D8767 / DT1855	EC800 : ECH8075 : ECA8x+ SLV814	EC800 : ECH8075 : D8767/DT1855+ SLV814
Volume Ratio:	4 : 1 : 1	4 : 1 : 1	4 : 1 : 1 +10%	4 : 1 : 1 +10%
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating (flexed)	Clear Coating (flexed)
VOC Actual (g/L)	118	104	111	98
VOC Actual (lbs/gal)	0.99	0.87	0.93	0.82
VOC Regulatory (less water less exempt) (g/l)	249 - 250	226 - 228	240 - 241	219
VOC Regulatory (less water less exempt) (lbs/gal)	2.08 - 2.09	1.89 - 1.90	2.00 - 2.01	1.83
Density (g/L)	1059 - 1093	1073 - 1119	1074 - 1105	1087 - 1129
Density (lbs/gal)	8.84 - 9.12	8.95 - 9.34	8.96 - 9.22	9.07 - 9.42
Volatiles wt. %	64.1 - 65.2	64.6 - 66.1	65.1 - 66.1	65.5
Water wt. %	0.1	0.1	0.1	0.1
Exempt wt. %	52.9 - 54.4	54.9 - 56.8	54.6 - 56.0	56.4 - 58.1
Water vol. %	0.1	0.1	0.1	0.1
Exempt vol. %	52.8 - 52.9	54.4	53.8 - 53.9	55.2 - 55.3
Solids vol. %	33.6	33.5	33.4	33.3
Sq Ft. Coverage / U.S.gal. 1 mil. @ 100% transfer efficiency	539	538	535	534

Health and Safety

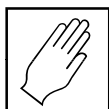
See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and MSDS's of all the components, since the mixture will have the hazards of all its parts.



- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.



- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product MSDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

Emergency Medical or Spill Control Information (412) 434-4515; In Canada (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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