

# ENVIROBASE<sup>®</sup> HIGH PERFORMANCE



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## Product Information

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### EC700 ONE-VISIT™ Production Clearcoat

#### Product Description

EC700 ONE-VISIT Production Clearcoat is a high gloss, high solids productivity clearcoat designed specifically for use with Envirobase High Performance. The OneVisit clearcoat, with its short bake times and zero flash time, reduces cycle times while maintaining the quality and appearance required by high production shops. From an environmental standpoint, the low 2.1 VOC of EC700 ONE-VISIT Production Clearcoat along with the high solids resin also decreases clearcoat material usage and therefore greatly reduces the overall VOC emissions.

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#### Preparation of Substrate:



In all cases, wash all surfaces to be painted with soap and water, then apply the appropriate Global or OneChoice 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 Global or OneChoice substrate cleaner. The use of a tack rag is recommended.

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## APPLICATION GUIDE:

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### Mixing Ratio for EC700 ONE-VISIT Production Clearcoat

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EC700      4 vols  
ECH70XX    1 vol



Pot life\* @ 68°F / 20°C      1 – 1.5 hours

\*Note: Pot life will be shortened with increased temperatures.

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Use the tables to determine the proper hardener needed for the application.

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### Hardener Selection

ECH7070	Fast Hardener 55° - 75°F (13° - 24°C)
ECH7080	Medium Hardener 75° - 95°F (24° - 35°C)
ECH7090	Slow Hardener 95°F and above (35°C)

Hardener selection may be dependent on the size of repair.

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### Optional Additive:

SLV814 Universal flexibilizer may be used to flex EC700



EC700 :	4 vols
ECH70XX:	1 vol
SLV814 :	10%

When used on plastic parts, EC700 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.

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### Spraygun set-up:



Fluid Tip	1.2 - 1.3
Spray Viscosity	17-19 secs DIN 4 @ 20°C / 68°F

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### Spray pressure:

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

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### Number of coats:



Apply 1 light to medium flowing coat immediately followed by a second medium coat to give 2 mils dry film thickness.

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### Flash off at 68°F/20°C:



Allow 1 minute of flash time between the 1<sup>st</sup> and 2<sup>nd</sup> coats. For 2 or more panels, no flash time between coats is required.

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### Drying Times:

Dust-free 68°F / 20°C	20 - 40 minutes
Dry to handle 68°F / 20°C	3 - 5 hours
Air Dry 68°F / 20°C	3 - 5 hours
Force Dry 140°F / 60°C Metal Temperature*	When using ECH7070 - 15 minutes When using ECH7080 - 20 minutes When using ECH7090 - 20 minutes
Tape Time 68°F / 20°C	3 - 5 hours
IR (Infrared)	8 - 15 minutes

\*All force dry times are quoted for metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature.

**Cumulative Parts Mix by Weight Activation Chart for EC700 ONE-VISIT Production Clearcoat**

Clearcoat Required	EC700 Clearcoat Parts	ECH70XX Hardener Parts
¼ Pint / 4 oz.	126.3	154.8
½ Pint / 8 oz.	252.5	309.5
¾ Pint / 12 oz.	378.8	464.3
1 Pint / 16 oz.	505.0	619.0
1.5 Pints / 20 oz.	631.3	773.8
1.75 Pints / 28 oz.	883.8	1083.3
1 Quart / 32 oz.	1010.1	1238.1
1.5 Quarts / 40 oz.	1515.1	1857.1
2 Quarts / 64 oz.	2020.1	2476.1

**APPLICATION GUIDE:**

**Overcoat/Recoat**



Overcoat/Recoat Time

12-16 hours at 68°F / 20°C air dry or after force dry cool down. EC700 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



Polishing

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

**Performance Guidelines**

Allow the Envirobase HP Waterborne Basecoat to flash off for 15 minutes (but no longer than 24 hours) before applying EC700. If basecoat dries longer than 24 hours, additional basecoat must be applied before clearcoating. The timing will depend on thickness and temperature.

Recoating times will be extended at lower temperatures. EC700 may be sanded with 1200 grit paper or finer and polished when hard, to rectify minor imperfections.

**Fading Out EC700**

After spot repairing, Use OneChoice SXA840 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**

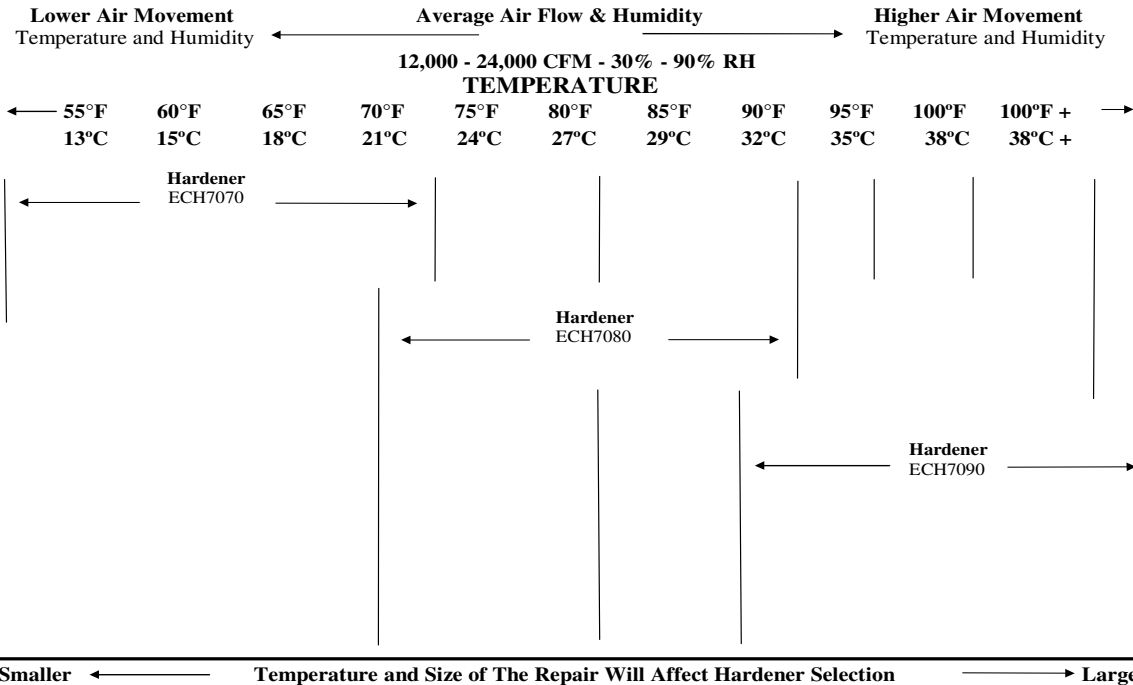
**Total dry film build:**

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

**RTS Combinations:**

	EC700 : ECH70XX	EC700 : ECH70XX : SLV814
Volume Ratio:	4 : 1	4 : 1 : 10%
Applicable Use Category	Clear Coating	Clear Coating (flexed)
VOC Actual (g/L)	155	145
VOC Actual (lbs/gal)	1.29	1.21
VOC Regulatory (less water less exempt) (g/L)	250	243
VOC Regulatory (less water less exempt) (lbs/gal)	2.09	2.03
Density (g/L)	1164	1168
Density (lbs/gal)	9.71	9.75
Volatiles wt. %	57.1	58.7
Water wt. %	0.0	0.0
Exempt wt. %	43.7	46.2
Water vol. %	0.0	0.0
Exempt vol. %	37.9	40.3
Solids vol. %	44.4	43.2
Sq Ft. Coverage / U.S.gal. 1 mil. @ 100% transfer efficiency	712	693

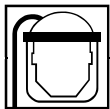
## EC700 ONE - VISIT™ PRODUCTION CLEARCOAT HARDENER SELECTION GUIDE



### 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 (414) 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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