Product Information

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.

**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.
APPLICATION GUIDE:
Mixing Ratio for EC700 ONE-VISIT Production Clearcoat

<table>
<thead>
<tr>
<th>EC700</th>
<th>4 vols</th>
</tr>
</thead>
<tbody>
<tr>
<td>ECH70XX</td>
<td>1 vol</td>
</tr>
</tbody>
</table>

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

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

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

**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.

**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.

**Spraygun set-up:**

- **Fluid Tip**
  - 1.2 - 1.3
- **Spray Viscosity**
  - 17-19 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 pressure

**Number of coats:**

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

**Flash off at 68°F/20°C:**

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

**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**
  - When using ECH7070 - 15 minutes
  - When using ECH7080 - 20 minutes
  - When using ECH7090 - 20 minutes
- **Temperature***
  - 140°F / 60°C Metal
  - 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

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

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
- Volume Ratio: 4 : 1
- Applicable Use Category: Clear Coating
- VOC Actual (g/L): 155
- VOC Actual (lbs/gal): 1.29
- VOC Regulatory (less water less exempt) (g/L): 250
- VOC Regulatory (less water less exempt) (lbs/gal): 2.09
- Density (g/L): 1164
- Density (lbs/gal): 9.71
- Volatiles wt. %: 57.1
- Water wt. %: 0.0
- Exempt wt. %: 43.7
- Water vol. %: 0.0
- Exempt vol. %: 37.9
- Solids vol. %: 44.4
- Sq Ft. Coverage / U.S.gal. 1 mil. @ 100% transfer efficiency: 712

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