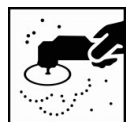


**VALOREM WB**

Valorem WB is the color for the Valorem waterborne basecoat paint system. It offers great color accuracy and ease of application. Valorem WB is easy to blend and is compliant in VOC regulated regions. When used with the Valorem clearcoat system a glossy and durable surface is achieved.

**SAFETY CONSIDERATIONS**

- Use suitable personal protection.
- When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator.

**SURFACE ABRADING**

- Repair area           ○ Sand repair area using #P500-600 dry.
- Color blend area   ○ Gray scuff pad or sand with P1000 on an interface pad and DA.

**SURFACE CLEANING**

- Use suitable surface cleaners and technique to ensure a clean surface

**MIXING STICK****Mix**

100  
5-40

**Standard Mix**

Parts Valorem WB color  
Parts VWA-10 Waterborne Activator  
○ Stir color formula mix thoroughly prior to adding VWA-10 Waterborne Activator.

BY VOLUME

**EQUIPMENT****HVLP or Compliant Spray-Gun Set-Up**

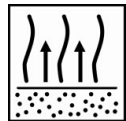
- 1.3-1.5 mm HVLP Gravity
- 1.2-1.4 mm Compliant Gravity

**Application Air Pressure**

- HVLP – 10 psi (<0.7 bar) at cap maximum.
- Consult manufacturer specifications.

**APPLICATION**

- 2 to 3 medium coats or until covered.

**FLASH OFF****Flash Between Coats at 70°F (21°C)**

- Until completely matte in appearance.

**Flash at 70°F (21°C) Before Clearcoating**

- 15 to 20 minutes.

**RECOATABILITY**

- Valorem has a selection for clearcoats for application over Valorem WB. The selection is based on many considerations including environment, size of the repair or time.

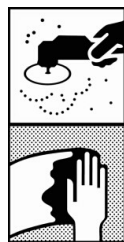
Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information

**VALOREM WB****DESCRIPTION**

Valorem WB is the color for the Valorem waterborne basecoat paint system. It offers great color accuracy and ease of application. Valorem WB is easy to blend and is compliant in VOC regulated regions. When used with the Valorem clearcoat system a glossy and durable surface is achieved.

**PRODUCT ASSORTMENT**

- Valorem WB
  - VWA-10 Waterborne Activator
  - VWH-20 Waterborne Hardener
  - VWX-30 Waterborne RM Additive
- Mixed per color formulation
  - Item #596541 (1L)
  - Item #596227 (0.5L)
  - Item #596279 (1L)
- Do not allow product to freeze.
  - Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).
  - Refer to the Product Shelf Life Overview TDS or the current price list for the most up-to-date shelf-life information.

**SURFACE PREPARATION****Sanding**

- Repair area
  - Color blend area
- Sand repair area using #P500-600 dry.
  - Gray scuff pad or sand with P1000 on an interface-pad and DA.

**Surface Cleaning**

- Use suitable surface cleaners and technique to ensure a clean surface.



BY VOLUME

**MIXING****Mix**

100

Parts Valorem WB Color

5-40

Parts VWA-10 Waterborne Activator

**Suggested Reductions –**

- Solid Colors 10 to 20 parts VWA-10 Waterborne Activator
- Pearl Colors 20 to 30 parts VWA-10 Waterborne Activator
- Metallic Colors 30 to 40 parts VWA-10 Waterborne Activator



BY WEIGHT

**MIXING WITH READY MIX ADDITIVE (METALLIC COLOR POT-LIFE EXTENDER)****Mix**

100

Grams Valorem WB MM Metallic color formula (Stirred)

5

Grams Valorem VWX-30 Waterborne RM Additive

- Use this ratio for every 100 grams of basecoat in your mixed metallic color.
- Stir together and then reduce as normal with 30-40 parts of VWA-10 Waterborne Activator.
- Ready Mix Additive should only be used in metallic colors. Do not use with solid colors.

**VALOREM WB****MIXING WITH VWH-20 WATERBORNE HARDENER**

- VWH-20 Waterborne Hardener is recommended for use when additional system robustness including stone chip resistance, adhesion, or system hardness is desired.
- VWH-20 Waterborne Hardener should be used in the first layer of tri-coat systems or where the recommended film thickness of the entire system may be exceeded.

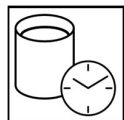


BY WEIGHT

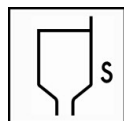
**Mix**

100	Grams Valorem WB MM color formula (stirred)
5-10	Grams VWH-20 Waterborne Hardener

- Use this ratio for every 100 grams of basecoat in your mixed color.
- Stir together and then reduce as normal with 30-40 parts of VWA-10 Waterborne Activator.

**POT-LIFE WHEN MIXED****Product Mix**

	<b>70°F (21°C)</b>
• Valorem WB, Solid or Pearl colors mixed	– 3 months
• Valorem WB, Metallic colors	– 1 week
• Valorem WB, Metallic colors with Ready Mix Additive	– 3 months
• Valorem WB, SEC or those containing WS021	– 24 hours
• Valorem WB Colors containing 5-10% VWH-20 Waterborne Hardener	– 1.5 to 3 hours

**VISCOSITY, MEASURED WITH A DIN #4 VISCOSITY CUP AT 70°F (21°C)**

- Valorem WB – 20 to 35 seconds.

**SPRAY-GUN SET-UP****HVLP or Compliant Spray-Gun Set-Up**

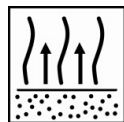
- |                                | <b>Application Air Pressure</b>            |
|--------------------------------|--|
| • 1.3-1.5 mm HVLP Gravity      | – HVLP – 10 psi (<0.7 bar) at cap maximum. |
| • 1.2-1.4 mm Compliant Gravity | – Consult manufacturer specifications.     |

**APPLICATION****Valorem WB Solid Colors**

- Apply 2-3 single coats or until opacity is achieved.
- Use increased airflow to flash off between coats or until matte in appearance.

**Valorem WB Metallic Colors**

- Apply 1 full coat, 100 % closed. If needed apply intermediate coats, 80% as wet as the first coat until coverage is achieved. Flash dry between coats until the basecoat dries completely to a matte finish.
- If needed, apply an orientation coat:
  - Increase the distance to approximately 12 to 14 inches and apply a damp coat with no wet areas. The finish should look like “satin” when completed.

**VALOREM WB****FLASH DRYING AT 70°F (21°C)****Between Coats**

- Flash until completely matte in appearance.

**Before Clearcoat**

- 15-20 minutes

**Flash and Drying Notes**

- Humidity and airflow influence the Valorem WB flash off and drying times.
- Flash can be reduced to a minimum by using air accelerator systems at approximately 3 feet (≈1m) from the repair and increasing the airflow over the object.
- Introducing heat is also an option. When heat is used for drying, allow object to cool down to application temperature before proceeding with color or clearcoat application.
- Infrared heating is not recommended for flash drying of Valorem WB.

**RECOATING**

- Valorem has a selection for clearcoats for application over Valorem WB. The selection is based on many considerations including environment, size of the repair or time.

**VOC / REGULATORY INFORMATION**

Notice: Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

**Valorem WB Ready to spray VOC:**

- <3.4lbs./Gallon (407 grams/Liter)

**AkzoNobel Inc., North America**

**Address: 1845 Maxwell Street – Troy, MI USA**

**Tel: 800.618.1010**

**FOR PROFESSIONAL USE WITH SUITABLE HSE EQUIPMENT**

**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Safety Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

Coatings brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.

**Head Office**

AkzoNobel Car Refinishes B.V., PO Box 3, 2170 BA Sassenheim, The Netherlands