DYNACOAT

PROGRAMMED SYSTEM TECHNIQUE (PST)
BASECOAT
NORTH AMERICA

BASECOAT SB MM

Dynacoat Basecoat SB MM provides quick dry, good hiding and excellent color match. It can be used for spot repairs or complete refinishing.

SAFETY CONSIDERATIONS

- Use suitable protection.

SURFACE ABRADING

- Complete panel – Sand with P500 to P600 dry or P800 to P1000 wet
- Color blend area – De-gloss using a gray scuff pad.

SURFACE CLEANING

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

BY VOLUME

MIXING – BY VOLUME

Mix	Standard Mix
2	Parts Dynacoat Basecoat SB MM
1	Parts Dynacoat Universal Reducer
10%*	*For optimal system performance: Before reduction, harden basecoat with Dynacoat Hardener Fast, Medium, or Slow. Read the complete TDS for detailed information.

EQUIPMENT

- HVLP Gravity Fed 1.3-1.5mm
- Compliant Gravity Fed 1.3-1.5mm
- HVLP – 10 psi at the air cap maximum
- Consult spray gun manufacturer specifications.

APPLICATION

✓ 2-3 single coats or until opacity is achieved.

FLASH OFF (70°F (21°C))

Flash Drying Between Coats

- Flash 5-10 minutes between coats.

Flash Drying Before Clearcoat

- Flash 15-20 minutes before clearcoat.

RECOATABILITY

- 2-stage color formulas: Clearcoat with any Dynacoat clearcoat.
- 3-stage color formulas: Clearcoat with Dynacoat Clear Pro HS.

✓ Dynacoat Basecoat SB is not compliant in regulated markets. In National Rule areas, 3-stage formulas are required to be clearcoated with Dynacoat Clear Pro HS/Dynacoat Euro Clear LV.

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

AkzoNobel

DESCRIPTION

Dynacoat Basecoat SB MM provides quick dry, good hiding and excellent color match. It can be used for spot repairs or complete refinishing.

SUITABLE SUBSTRATES

- Cleaned and properly prepared –
  - Existing OEM finishes except for thermoplastic acrylic lacquer finishes.
  - All Dynacoat primers and sealers.

PRODUCT AND ADDITIVES

- Dynacoat Basecoat SB MM
  - Per OEM code formula
  - Item #568000 (Gallon)
- Dynacoat Universal Reducer, Extra-Fast
  - 50-60°F (10°C – 16°C)
  - Item #568017 (Quart)
  - Item #568018 (Gallon)
- Dynacoat Universal Reducer, Fast
  - 60-70°F (16°C – 21°C)
  - Item #568004 (Quart)
  - Item #568002 (Gallon)
  - Item #568110 (5-Gallon)
- Dynacoat Universal Reducer, Medium
  - 70-80°F (21°C – 27°C)
  - Item #567992 (Quart)
  - Item #567999 (Gallon
  - Item #568089 (5-Gallon)
- Dynacoat Universal Reducer, Slow
  - 80-90°F (27°C – 32°C)
  - Item #567995 (Quart)
  - Item #568012 (Gallon)
- Dynacoat Universal Reducer, Extra-Slow
  - >90°F (Blend with slow reducer)
  - Item #568087 (0.225 L)
  - Item #568109 (Liter)
- Dynacoat Hardener Fast
  - Item #568106 (0.225 L)
  - Item #568163 (Liter)
- Dynacoat Hardener Medium
  - Item #568086 (Liter)
- Dynacoat Hardener Slow

- Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures. Optimum storage temperature is approximately 70°F (21°C). Avoid too much temperature fluctuation. The maximum temperature range for storage is 40°F - 95°F (5°C – 35°C).
- Refer to price sheet for shelf life information.

BASIC RAW MATERIALS

- Dynacoat Basecoat SB MM
  - Physically drying resins, solvents and pigments.
- Dynacoat Universal Reducers
  - Special solvent blends.
- Dynacoat Hardeners
  - Polyisocyanate resins.

SUBSTRATE PREPARATION

Pre-Cleaning

- The surface must be dry and free from grease, oil and other foreign matter contaminants.

Surface Abrading

- Complete Panel
  - Sand with P500 to P600 dry or P800 to P1000 wet.
- Color Blend Area
  - De-gloss using a gray scuff pad.

Final Cleaning

- The surface must be dry and free from grease, oil and other foreign matter contaminants.

MIXING

Mix	Standard Mix
2	Parts Dynacoat Basecoat SB MM
1	Parts Dynacoat Universal Reducer

BY VOLUME

If improved system robustness including stone chip resistance, adhesion, flexibility, and system hardness is desired, Basecoat SB may be mixed with hardener.

Mix	Hardened Basecoat Mix
100	Parts Dynacoat Basecoat SB MM
10%	Dynacoat Hardener Fast, Medium, or Slow

- Stir together, THEN-

50	Parts Dynacoat Universal Reducer

BY VOLUME

POT-LIFE WHEN MIXED

Product Mix	At 70°F (21°C)
• Basecoat SB, reduced	– Indefinite in a sealed container
• Basecoat SB, hardened and reduced	– 4 hours

SPRAY GUN SETUP

HVLP or Compliant Spray Gun Setup	Application Air Pressure
• HVLP Gravity – 1.3-1.5mm	– HVLP – 10 psi (<0.7 bar) at cap maximum.
• Compliant Gravity – 1.3-1.5mm	– Consult manufacturer specifications.

APPLICATION

Solid Colors

- Apply 2-3 single coats or until opacity is achieved. Flash off between coats.

Metallic & Effect Colors

- Apply single coats until opacity is achieved. Flash off between coats.
  - When needed, apply an orientation coat.
  - Increase the distance to approximately 8-12 inches and apply a light coat.

Spot Repairs

- Apply thin coats until opacity is achieved. Flash off between each coat.
  - Extend each coat until coverage is obtained.
  - In the case of metallic colors, air pressure adjustments may be required to achieve the correct color control.
- After coverage is achieved, fade color into existing finish.

DRYING / CURING TIME (70°F (21°C))

Flash Drying Between Coats

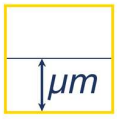
- Flash 5-10 minutes between coats.

Flash Drying Before Clearcoat

- Flash 15-20 minutes before clearcoat.

RECOATING

- 2-stage color formulas: Clearcoat with any Dynacoat Clearcoat.
- 3-stage color formulas: Clearcoat with Dynacoat Clear Pro HS/Dynacoat EuroClear LV.
- Maximum recoat window of 24 hours at 70°F (21°C).
- After 24 hours scuff the dried color and re-apply Dynacoat Basecoat SB MM color before clearcoating.



FILM THICKNESS

Using suitable application, 1 coat will achieve a thickness of 0.4-0.8 mils (10-20 µm).

THEORETICAL COVERAGE

- Actual coverage is dependent on many factors. These may include: the shape of the object, surface smoothness, application technique and other application variables.
  - Theoretical coverage: ± 326 sq.ft./gallon (8m²/liter) ready to spray per coat and 100% transfer efficiency.

VOC / REGULATORY INFORMATION

Notice: Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on 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.

- Dynacoat Basecoat SB MM ready to spray
  - VOC: 6.58 lb./gal. (790 g/L)
- Dynacoat Basecoat SB MM 3-stage colors ready to spray and using Dynacoat Clear Pro HS/Dynacoat Euro Clear LV
  - VOC: 4.48 lb./gal. (537 g/L)

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