



Basecoat

2-Stage Solid Colours

Product Description

Single component solid Colours for repairing automotive 2-stage finishes. Mix at 1:1

Technical Characteristics

Colours: mixing system Shelf life: 48 months at 25°C Theoretical spreading rate: 120 m²/l (avg) at 1 µm

Pre-treatment

Wet flat with P800-1000 grade paper or dry flat with P600-800 grade paper.
Degrease with HAMR Prepsolve.
Wash off residues and dry thoroughly.
Re-clean with HAMR Prepsolve. The use of a tack rag is recommended.

	Mixing Ratio	<p>Stir well before use. Twice per day for 15 min on the mixing machine.</p> <table border="0"> <tr> <td>1K Solid Colors</td> <td>1</td> <td>100 (vol)</td> <td>depending on colour</td> </tr> <tr> <td>940 (5°C -15°C)</td> <td></td> <td></td> <td></td> </tr> <tr> <td>950 (15°C-25°C)</td> <td>1</td> <td></td> <td></td> </tr> <tr> <td>960 (25°C -35°C)</td> <td></td> <td></td> <td></td> </tr> <tr> <td>970 (>35°C)</td> <td></td> <td>100 – 120 (vol)</td> <td></td> </tr> </table> <p>Mix well and strain before application.</p>	1K Solid Colors	1	100 (vol)	depending on colour	940 (5°C -15°C)				950 (15°C-25°C)	1			960 (25°C -35°C)				970 (>35°C)		100 – 120 (vol)	
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	Spray Viscosity Potlife	16 to 18 seconds DIN 4 cup at 25°C 24 hours at 25°C																				
	Sprayguns	<table border="0"> <tr> <td>HVLP gravity-feed spray gun</td> <td>1.2–1.3 mm</td> <td>1.8–2.0 bar</td> <td>10–15 cm</td> </tr> <tr> <td>Conventional gravity-feed spray gun</td> <td>1.3–1.6 mm</td> <td>3.0–4.0 bar</td> <td>15–20 cm</td> </tr> </table>	HVLP gravity-feed spray gun	1.2–1.3 mm	1.8–2.0 bar	10–15 cm	Conventional gravity-feed spray gun	1.3–1.6 mm	3.0–4.0 bar	15–20 cm												
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	Application	<p>Apply basecoat over sound abraded paint finishes or over grey primers.</p> <p>Number of coats: 1 thin + 1 wet coat Flash-off: 5–10 mins Film thickness: 15–25 µm</p>																				
	Drying	<p>Drying at 25°C: 5 mins Drying at 60°C: —</p>																				
Further Treatment		After the coat is dust-free, apply HAMR clear coat wet on wet.																				

The products are suitable for professional use only. The data contained in this publication are based on our current knowledge and experience. You can obtain the latest version of technical data sheet directly from your supplier.

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