



Basecoat

2-Stage Metallic Colours (Aluminium/Pearl/Xirallic)

Product Description
Single component metallic colours for repairing automotive 2-stage finishes. Mix at 1:1

Technical Characteristics
Colour: 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 mins on the mixing machine.</p> <table border="0"> <tr> <td>1KS/1KP/1KX/BH–Metallic Colours</td> <td>1</td> <td>100 (vol)</td> <td>100 g</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></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>1</td> <td>100–120 (vol)</td> <td>90–107 g</td> </tr> </table> <p>Mix well and strain before application.</p>	1KS/1KP/1KX/BH–Metallic Colours	1	100 (vol)	100 g	940 (5°C–15°C)				950 (15°C–25°C)				960 (25°C–35°C)				970 (>35°C)	1	100–120 (vol)	90–107 g
1KS/1KP/1KX/BH–Metallic Colours	1	100 (vol)	100 g																			
940 (5°C–15°C)																						
950 (15°C–25°C)																						
960 (25°C–35°C)																						
970 (>35°C)	1	100–120 (vol)	90–107 g																			
	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												
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																			
	Application	<p>Apply basecoat over sound abraded finishes or over grey primers. Number of coats: 1 thin + 1 wet coat + 1 mist coat to match effect Flash-off: 5–8 mins Note: Before mist coat, enlarge the spray fan and adjust spraying pressure & distance to be:</p> <table border="0"> <tr> <td>2.0 bar (HVLP)</td> <td>15 cm</td> </tr> <tr> <td>3.5 bar (Conventional)</td> <td>20 cm</td> </tr> </table>	2.0 bar (HVLP)	15 cm	3.5 bar (Conventional)	20 cm																
2.0 bar (HVLP)	15 cm																					
3.5 bar (Conventional)	20 cm																					
	Drying	<table border="0"> <tr> <td>Drying at 25°C:</td> <td>5 mins</td> </tr> <tr> <td>Drying at 60°C:</td> <td>—</td> </tr> </table>	Drying at 25°C:	5 mins	Drying at 60°C:	—																
Drying at 25°C:	5 mins																					
Drying at 60°C:	—																					
Further Treatment		After the final 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.

HAMR Coatings Pty Ltd. Australia. Tel (03 8797 5515) HAMRCOATINGS.COM ISSUE 15/10/2021 This supersedes all older data sheets.