



Basecoat

2-Stage Red Pearl

Product Description

Single component basecoat 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

Phase 1

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.

Phase 2 (Optional)

Apply one thin layer of a solid colour that are close to the final colour, or a dark grey, after one min's flash-off, apply one more wet layer of the same colour.

Flash off for 5 mins.

	Mixing Ratio	Stir well before use. Twice per day for 15 mins on the mixing machine.																				
	Spray Viscosity Potlife	<table border="0"> <tr> <td>1KP Red Pearl</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>1</td> <td>100–120 (vol)</td> <td>90–107 g</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></td> <td></td> </tr> </table>	1KP Red Pearl	1	100 (vol)	100 g	940 (5°C–15°C)				950 (15°C–25°C)	1	100–120 (vol)	90–107 g	960 (25°C–35°C)				970 (>35°C)			
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	Sprayguns	Mix well and strain before application.																				
	Application	<p>16 to 18 seconds DIN 4 cup at 25°C 24 hours at 25°C</p> <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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	Drying	<p>Apply basecoat over sound abraded paint finishes or over grey primers. Number of coats: 1 thin + 1 wet coat + 1 mist coat to match effect Flash-off: 3 – 5 mins between 1st and 2nd coats. 1 min before mist coat.</p>																				
Further Treatment		<p>Note: Before mist coat, enlarge the spray fan and adjust spraying pressure & distance to be:</p> <table border="0"> <tr> <td></td> <td>2.0 bar (HVLP)</td> <td>10-15 cm</td> </tr> <tr> <td></td> <td>3.5 bar (Conventional)</td> <td>20-25 cm</td> </tr> </table> <p>Film thickness: 15–20 µm</p> <p>Drying at 25°C: 5 mins Drying at 60°C: –</p>		2.0 bar (HVLP)	10-15 cm		3.5 bar (Conventional)	20-25 cm														
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		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.

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