



Basecoat 3c

3-Stage Single Component Xirallic/Pearl Colours

Product Description

Single component basecoat with Xirallic/pearl effect for repairing automotive 3-stage finishes. Mix at 1:1
We recommend activating the basecoat where higher than normal film builds will occur.

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	Stir well before use. Twice per day for 15 mins on the mixing machine.			
		Step 1: 1K Solid Colours	1	100 (vol)	depending on colour
	Spray Viscosity	9688, 9788, 9888	0.05-0.10	5-10 (vol)	5 – 10g
	Potlife	940, 950, 960, 970	1	90-110 (vol)	80 – 97g
	Sprayguns	Mix well and strain before application.			
		Step 2: 1KX/BH-/1KP Xirallic/Pearl Colours	1	100 (vol)	100g
	Application	9688, 9788, 9888	0.05-0.10	5 – 10 (vol)	5 – 10g
		940, 950, 960, 970	1	90 – 110 (vol)	80 - 97g
	Drying	16 to 18 seconds DIN 4 cup at 25°C			
	Further Treatment	Step 1: 24 hours at 25°C (Activated 2 hours) Step 2: 24 hours at 25°C (Activated 2 hours)			
		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
		Apply basecoat over sound abraded finishes or over grey primers.			
		Step 1	Step 2		
		Number of coats: 1 thin + 1 wet coat	1 wet + 1 mist coat to match effect		
		Film thickness: 15 µm	15 – 25 µm		
		Flash-off: 3-5 mins.			
		Note: Before Step 2 mist coat, enlarge the spray fan and adjust spraying pressure & distance to be:			
			2.0 bar (HVLP)	10-15 cm	
			3.5 bar (Conventional)	20-25 cm	
		Drying at 25°C:	5 mins		
		Drying at 60°C:	—		
		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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