



HAMR-Shift

3-Stage Single Component Colour-Shift Colours

Product Description
 Single component basecoat with colour shifting effect.
 We recommend activating the basecoat where higher film builds 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  Spray Viscosity Potlife  Sprayguns  Application  Drying Further Treatment	<p>Stir well before use.</p> <p>Step 1: 1K Solid Black (white particles shifts may go over coloured bases)</p> <table border="1"> <tr> <td></td> <td>1</td> <td>100 (vol)</td> <td>100g</td> </tr> <tr> <td>9688, 9788, 9888</td> <td>0.05-0.1</td> <td>5-10 (vol)</td> <td>5 – 10g</td> </tr> <tr> <td>940, 950, 960, 970</td> <td>1</td> <td>90-110 (vol)</td> <td>80 – 97g</td> </tr> </table> <p>Mix well and strain before application.</p> <p>Step 2: HAMR-Shift Colour</p> <table border="1"> <tr> <td></td> <td>1</td> <td>100 (vol)</td> <td>100g</td> </tr> <tr> <td>9688, 9788, 9888</td> <td>0.05-0.10</td> <td>5 – 10 (vol)</td> <td>5 – 10g</td> </tr> <tr> <td>940, 950, 960, 970</td> <td>1</td> <td>90 – 110 (vol)</td> <td>80 – 97g</td> </tr> </table> <p>Mix well and strain before application.</p> <p>16 to 18 seconds DIN 4 cup at 25°C Step 1: 24 hours at 25°C (Activated 2 hours) Step 2: 24 hours at 25°C (Activated 2 hours)</p> <table border="1"> <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 – 1.4 mm</td> <td>3.0 – 4.0 bar</td> <td>15 – 20 cm</td> </tr> </table> <p>Apply basecoat over sound abraded finishes or over grey primers.</p> <table border="1"> <tr> <td></td> <td>Step 1</td> <td>Step 2</td> </tr> <tr> <td>Number of coats:</td> <td>1 thin + 1 wet coat</td> <td>1 wet + 1 wet + effect coat</td> </tr> </table> <p>Maintain an even spraying technique, it is crucial to put the same amount of Step 2 on all panels to achieve a uniform colour effect</p> <table border="1"> <tr> <td>Film thickness:</td> <td>15 - 20 µm</td> <td>15 – 20 µm</td> </tr> <tr> <td>Flash-off:</td> <td>3-5 mins.</td> <td></td> </tr> </table> <p>Note: Before Step 2 mist coat, enlarge the spray fan and adjust spraying pressure & distance to be:</p> <table border="1"> <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>Drying at 25°C: 5 mins Drying at 60°C: —</p> <p>After the step 2 coating is dust-free, apply HAMR clear coat as per TDS</p>		1	100 (vol)	100g	9688, 9788, 9888	0.05-0.1	5-10 (vol)	5 – 10g	940, 950, 960, 970	1	90-110 (vol)	80 – 97g		1	100 (vol)	100g	9688, 9788, 9888	0.05-0.10	5 – 10 (vol)	5 – 10g	940, 950, 960, 970	1	90 – 110 (vol)	80 – 97g	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 – 1.4 mm	3.0 – 4.0 bar	15 – 20 cm		Step 1	Step 2	Number of coats:	1 thin + 1 wet coat	1 wet + 1 wet + effect coat	Film thickness:	15 - 20 µm	15 – 20 µm	Flash-off:	3-5 mins.			2.0 bar (HVLP)	10-15 cm		3.5 bar (Conventional)	20-25 cm
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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.