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

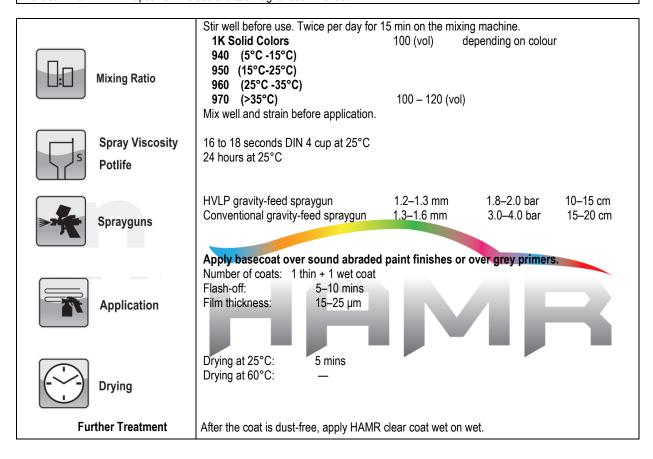
Pre-treatment

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.



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.

Stir well before use. Twice per day for 15 mins on the mixing machine. 1KS/1KP/1KX/BH-Metallic Colors 100 (vol) 100 g (5°C-15°C) 940 950 (15°C-25°C) Mixing Ratio 960 (25°C-35°C) 970 (>35°C) 100-120 (vol) 90-107 q Mix well and strain before application. **Spray Viscosity** 16 to 18 seconds DIN 4 cup at 25°C 24 hours at 25°C **Potlife** HVLP gravity-feed spraygun 1.2-1.3 mm 1.8-2.0 bar 10-15 cm Conventional gravity-feed spraygun 3.0-4.0 bar 15-20 cm 1.3-1.6 mm **Sprayguns** Apply basecoat over sound abraded finishes or over grey primers. Number of coats: 1 thin + 1 wet coat + 1 mist coat to match effect 5 - 8 minsFlash-off: Note: Before mist coat, enlarge the spray fan and 15 cm adjust spraying pressure & distance to be: 2.0 bar (HVLP) 3.5 bar (Conventional) 20 cm Application Film thickness: 15 – 25 um Drying at 25°C: 5 mins Drying at 60°C: **Drying** After the final coat is dust-free, apply HAMR clear coat wet on wet. **Further Treatment**

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

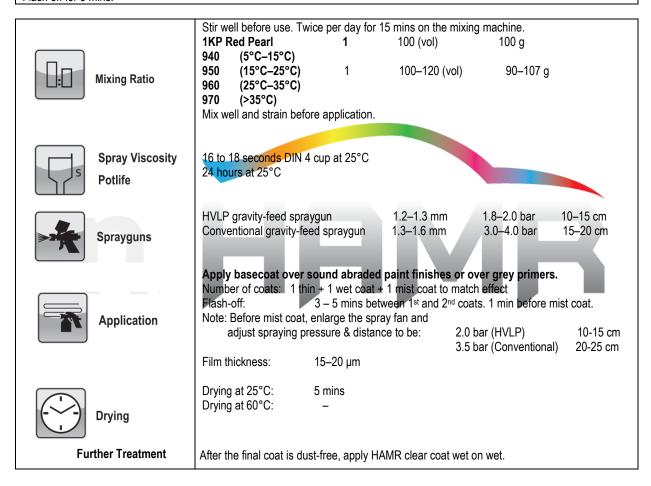
Wash off residues and dry thoroughly.

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.



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 1/5/2019

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.

	Stir well before use. Twice per day for 15 mins on the mixing machine.			
	Step 1: 1K Solid Colours	100 (vol)	depending on colour	
Пп	9688, 9788 , 9888	5-10 (vol)	5 – 10g	
	940 , 950, 960, 970	90-110 (vol)	80 – 97g	
Mixing Ratio	Mix well and strain before application.			
	Step 2: 1KX/BH-/1KP Xirallic/Pearl Colours	100 (vol) 1	00g	
	9688, 9788, 9888	5 – 10 (vol)	5 – 10g	
Spray Viscosity	940, 950, 960, 970 Mix well and strain before application.	90 – 110 (vol)	80 - 97g	
Potlife	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)			
Sprayguns	HVLP gravity-feed spraygun 1.2 – 1. Conventional gravity-feed spraygun 1.3 – 1.6			
Application	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 μ m 15 – 25 μ m Flash-off: 3-5 mins.			
	Note: Before Step 2 mist coat, enlarge the spray fan and			
	adjust spraying pressure & distance to be	,		
		3.5 par (Conventional) 20-25 cm	
Drying	Drying at 25°C: 5 mins Drying at 60°C: —			
Further Treatment	After the final coat is dust-free, apply HAMR clear	ar coat wet on we	t.	

Basecoat 3c



3-Stage Single Component Metallic Candy

Product Description

Single component basecoat with metallic candy effect for repairing automotive 3-stage finishes.

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

	Stir well before use. Step 1: 1K Metallic Colour	100 (vol)	depending on colour	
Mixing Ratio	9688, 9788 , 9888	5-10 (vol)	5 – 10g	
	940 , 950, 960, 970	90-110 (vol)	80 – 97g	
	Mix well and strain before application.			
	Step 2: Tinted Binder Colour Coat	100 (vol) 10	00g	
	9688, 9788, 9888	5 – 10 (vol)	5 – 10g	
Spray Viscosity	940, 950, 960, 970 Mix well and strain before application.	90 – 110 (vol)	80 – 97g	
Potlife	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)			
Sprayguns		- 1.3 mm		
Application	Apply basecoat over sound abraded finis Step 1 Number of coats: 1 thin + 1 wet coat + effect		Step 2 + 1 wet (until desired effect	
Drying	Film thickness: 15 - 20 μm 15 – 20 μm Flash-off: 3-5 mins. Note: Before Step 1 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			
Further Treatment	Drying at 25°C: 5 mins Drying at 60°C: —			
After the final coat is dust-free, apply HAMR clear coat wet on wet.				