






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 Colors</td> <td>100 (vol)</td> <td>100 g</td> </tr> <tr> <td>940 (5°C–15°C)</td> <td></td> <td></td> </tr> <tr> <td>950 (15°C–25°C)</td> <td></td> <td></td> </tr> <tr> <td>960 (25°C–35°C)</td> <td></td> <td></td> </tr> <tr> <td>970 (>35°C)</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 Colors	100 (vol)	100 g	940 (5°C–15°C)			950 (15°C–25°C)			960 (25°C–35°C)			970 (>35°C)	100–120 (vol)	90–107 g
1KS/1KP/1KX/BH–Metallic Colors	100 (vol)	100 g															
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	Spray Viscosity Potlife	<p>16 to 18 seconds DIN 4 cup at 25°C 24 hours at 25°C</p>															
	Sprayguns	<table border="0"> <tr> <td>HVLP gravity-feed spraygun</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 spraygun</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 spraygun	1.2–1.3 mm	1.8–2.0 bar	10–15 cm	Conventional gravity-feed spraygun	1.3–1.6 mm	3.0–4.0 bar	15–20 cm							
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Conventional gravity-feed spraygun	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											
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	Drying	<p>Drying at 25°C: 5 mins Drying at 60°C: —</p>															
Further Treatment		<p>After the final coat is dust-free, apply HAMR clear coat wet on wet.</p>															

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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)			
1KP Red Pearl	1	100 (vol)	100 g																			
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	Sprayguns	Mix well and strain before application.																				
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HVLP gravity-feed spraygun	1.2–1.3 mm	1.8–2.0 bar	10–15 cm																			
Conventional gravity-feed spraygun	1.3–1.6 mm	3.0–4.0 bar	15–20 cm																			
	Drying	<p>Apply basecoat over sand 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. 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 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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Further Treatment		After the final coat is dust-free, apply HAMR clear coat wet on wet.																				

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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	100 (vol)	depending on colour	
	Spray Viscosity	9688, 9788, 9888	5-10 (vol)	5 – 10g	
		940, 950, 960, 970	90-110 (vol)	80 – 97g	
	Potlife	Mix well and strain before application.			
		Step 2: 1KX/BH-/1KP Xirallic/Pearl Colours	100 (vol)	100g	
	Sprayguns	9688, 9788, 9888	5 – 10 (vol)	5 – 10g	
		940, 950, 960, 970	90 – 110 (vol)	80 - 97g	
	Application	16 to 18 seconds DIN 4 cup at 25°C			
		Step 1: 24 hours at 25°C (Activated 2 hours)			
	Drying	Step 2: 24 hours at 25°C (Activated 2 hours)			
		HVLP gravity-feed spraygun	1.2 – 1.3 mm	1.8 – 2.0 bar	10 – 15 cm
		Conventional gravity-feed spraygun	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:	—		
	Further Treatment	After the final coat is dust-free, apply HAMR clear coat wet on wet.			

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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.

 Mixing Ratio	Stir well before use.			
	Step 1: 1K Metallic Colour 9688, 9788, 9888 940, 950, 960, 970	100 (vol) 5-10 (vol) 90-110 (vol)	depending on colour 5 – 10g 80 – 97g	
 Spray Viscosity Potlife	Mix well and strain before application.			
	Step 2: Tinted Binder Colour Coat 9688, 9788, 9888 940, 950, 960, 970	100 (vol) 5 – 10 (vol) 90 – 110 (vol)	100g 5 – 10g 80 – 97g	
 Sprayguns	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)			
 Application	HVLP gravity-feed spraygun	1.2 – 1.3 mm	1.8 – 2.0 bar	10 – 15 cm
	Conventional gravity-feed spraygun	1.3 – 1.4 mm	3.0 – 4.0 bar	15 – 20 cm
 Drying	Apply basecoat over sound abraded finishes or over grey primers.			
	Step 1		Step 2	
Further Treatment	Number of coats: 1 thin + 1 wet coat + effect coat		1 wet + 1 wet (until desired effect Achieved)	
	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	
Drying at 25°C:		5 mins		
Drying at 60°C:		—		
After the final coat is dust-free, apply HAMR clear coat wet on wet.				

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