Technical Data Sheet

FUTURE COATING SYSTEM **BASE COAT**

Characteristic Properties

Base produces metallic effect finishes for cars and equipment as well as for designs and special effect colors. The complete system is a "two coats system" consisting of base as the base coat then clear coats are applied.The Final finish is characterized by magnificent optical effect and high gloss.

Materials For Application :

Base .
Metallic Thinner.
Clear Coat Hardener for Clear Coat.

Suitable Substrates & Surface Preparation

- Existing finishes (except thermoplastic acrylic TPA) Degrease and dry flat with P400 sandpaper or wet flat with P1000 sandpaper.
- Other 2-K filler products as After wet flatting with P800 sandpaper.
- Thermoplastic acrylic before application of base over thermoplastic acrylic one should apply either of the following: Two component filler

Mixing Ratio (By Volume)

Base Coat	Thinner
100	100

Spraying Viscosity

14-15 Sec/DIN Cup No. 4/20°C.

Spraying Conditions

Spray gun	Nozzle diameter	Working pressure
Gravity feed	1.3-1.4 mm	3 - 4 bar
Suction feed	1.7-1.8 mm	3 - 4 bar
Gravity feed (HVLP)	1.2-1.5 mm	Max. 0.7 bar at the air cap
Suction feed(HVLP)	1.4-1.6 mm	Max. 0.7 bar at the air cap

Spraying Process

- First apply one single coat of base to the repair area. After a flash off time of 5-10 minutes cover the area overall with a single wet coat.Depending on the hiding power of the color, apply 2 or 3 thin single coats allowing 5-10 minutes between coats.
- Recoat base with 1-2 mist coats using a working pressure of 4 bar.
- After 20 minutes drying at 20°C, the base coat can be sprayed with clear coat.

Special Technique For Spot Repairs

When making spot repairs use a working pressure of 1-1.5 bar to spray thin coats until achieving opacity. Allow the metallic coat to set to matt finish. Next fade out twice well extending beyond the edges. After 15 minutes drying at 20°C the metallic base coat may be recoated with another layer. After 15-20 min drying at 20°C apply a topcoat of clear coat

Coverage

Taking into account a transfer efficiency of 70% ,the theoretical material usage for one layer is 7 m^2/L ready to spray mixture which calculates to 15 m^2/L unthinned paint at 10 um .

Note: The practical cover rate depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

Cleaning Of Equipment

Thinner or Nitrocellulose Thinner.

Packing

1 L & 3.75 L

Color

Refer to color card (Base Coat Metallic).

SheLf Life

5 Years at 20°C.

Material Safety Data

When using these products its required to comply with the national regulation for health and safety, The data on the label of the product must be considered. Storage and transportation should be comply with the local laws, The information given in this data sheet is based upon our best knowledge and experience with application conditions set to standards. The customers are requested to verify the results by their own selves to make sure that the product is suitable for their application and application conditions.

Flash Points and Transport Classification

Product	Flash point	ADR transport code
Future Coating System Base	21-55°C	3-31°C
Future Coating System Thinner	21-55°C	3-31°C