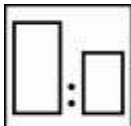




Dynacoat Basecoat PRO – D1.04.05

Description Dynacoat Basecoat PRO is developed to re-produce solid, pearl and metallic auto-motive colours. With different thinners it can be used for small repairs up to total re-sprays, Dynacoat Basecoat PRO has excellent coverage and fast drying properties

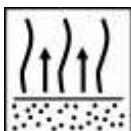
This product is not for sale to Vehicle Refinishers in the EU, who need to comply to the Directive 2004/42/EC

Mixing ratio  100 Dynacoat Basecoat PRO
50-80 Dynacoat Thinners Fast / Medium / Slow


Mixing stick  Use Dynacoat measuring stick
No. 1

Equipment  Spray gun set-up: 1.2-1.4 mm Application pressure: 2-4 bar*
* see user manual spraygun used

Application  2 - 3 x 1 coat

Flash-off  Between coats Before clearcoat
3-5 minutes @ 20°C 15 minutes @ 20°C
**Depends on thinner used*

Clearcoat application  See clearcoat T.D.S.

Protection  Use suitable respiratory protection
AkzoNobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete technical data sheet for detailed product information

TECHNICAL INFORMATION

Description Dynacoat Basecoat PRO is developed to re-produce solid, pearl and metallic auto-motive colours. With different thinners it can be used for small repairs up to total re-sprays, Dynacoat Basecoat PRO has excellent coverage and fast drying properties

Product and additives

Dynacoat Basecoat Pro

Dynacoat Thinners:

- Fast thinner** for spot-repairs up to 3 panels @ 15-20°C
- Medium thinner** for spot-repair up to a complete resprays @ 20-30°C
- Slow thinner** for larger object and / or at higher temperatures 25-30°C and up

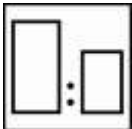
Basic Raw Materials

Basecoat: Physical drying binders
Thinners: blend of solvents

Suitable substrates

- OEM finishes and old painted surfaces.
- 1K Primer Grey
- Dynacoat Acrylic Filler 4+1
- Dynacoat Filler 5+1
- Dynacoat Filler 4100
- 2K Epoxy Primer
- Note: Do not apply directly to wash primers**

Mixing



- 100** Dynacoat Basecoat PRO
- 50-80** Dynacoat Thinners (Fast / Medium / Slow)

-**Note:** Always check colour before application to the object.

Viscosity

13-17 seconds DC4 at 20°C (depends on mixing ratio used)

Spray gun set-up and application pressure

Gravity feed	1.2-1.4 mm	2-4 bar (see user manual spraygun used)
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Application

For solid colours:

Apply 2-3 single coats until coverage, allowing flash-off until mat between coats.

For effect colours:

Apply 2-3 single coats until coverage, allowing for flash-off until mat between coats, if necessary apply a mist-coat for better metallic orientation by reducing the pressure with 0.5 bar and apply a light final coat with increasing the distance to +/- 30-40-cm

Spot repairs:

With spot repairs, use lower application pressure and apply thin coats until reaching opacity. Allow the basecoat PRO to flash off between coats. Next, fade out, by extending beyond the edges, using similar application pressure. In case of metallic colours apply a drop coat (metallic orientation coat) when needed by increasing the spray gun distance.

*Allow for a minimum of 15 minutes final flash-off time at (20°C) before clearcoat application.

Taping/masking

After 20 minutes flash-off at 20°C Basecoat PRO solid, metallic and pearl colours can be taped.

Denibbing

Allow to flash off sufficiently, at least 20 minutes at 20°C. Then lightly sand the damaged area with P500 free-cut dry or P1000grit wet sanding paper sanding paper. Thoroughly remove sanding residue before continuing Basecoat PRO application

Re-coat time

Basecoat PRO has to be re-coated with clearcoat within:

Solid colours : 5 hours **Metallic and Pearl:** 48 hours (2 days)

NOTE: To extend the re-coat time of solid colours up to 48 hours (2 days), mix Basecoat PRO as follows:
 Stir the Basecoat PRO colour thoroughly before adding 10% Dynacoat Hardener.
 Stir this mixture thoroughly before adding Dynacoat Thinner, then stir again thoroughly

Pot-life

6 months at 20°C
 4 hours if hardener is added

Film thickness

Per coat:	7- 9 µm
Recommended application (2 coats):	14-18 µm

Theoretical coverage

Ready for use mixture at 1µm dry film thickness

± 140 m²/liter

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

Cleaning of equipment

Use Dynacoat Gun Cleaner or Dynacoat Thinners

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.
Shelflife: 4 years at 20°C.
