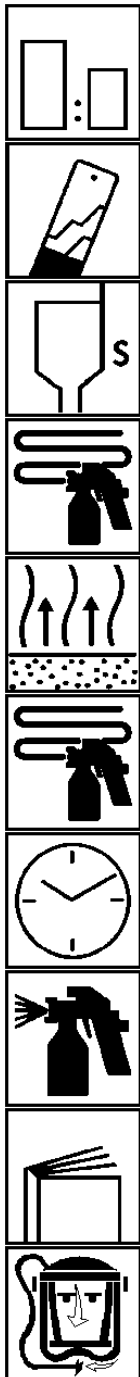


PRIMABASE



100:100
Primabase
3.2.1 Thinner

14-15

(syphon feed)
3*1
1.4-1.6 mm
3-4 bar

4-8 mins.

(syphon feed)
1*1
1.4-1.6 mm
2 bar

min. 15 mins. 20°C.
max. 5 hrs. 20°C. (solid
colours only)

Visionclear Plus
Focusclear LV
Primaclear 808
Topclear 821

6.3.1.0.2

Description:

One-pack basecoat for private cars, commercial vehicles and equipment, as well as for repairs to existing OEM two-coat and three-coat systems and design-work.

Product and Additives:

Primabase
3.2.1 Thinners

Special additives:
Flexi -o-actif

Basic Raw Materials:

Base paint: convertible binders.
Clearcoats: acrylic resins.
Hardeners: polyisocyanate resins.

Suitable Substrates:

- existing finishes, with the exception of thermoplastic acrylic finishes.
- all current Catinas preparatory products for car refinishing, with the exception of direct application to Etching primer CR.

Surface Preparation:

Existing finishes: Degrease and sand with P1000 grit wet, or manually with P400 grit dry or mechanically with P360 grit dry.

Spot repairs and fade-out areas of thermoplastic (reflow) and other OEM coatings: When making spot repairs, scuff with Scotch Brite Type S Ultra Fine the fade-out area and the area to be recoated only with a clearcoat. Use Vim or Ata should only in conjunction with Scotch Brite Type S Ultra Fine.

When making spot repairs, cover the fade-out area with an initial coat of Blendfix 1K thinned with 200 % 3.2.1 Thinner. Spray one single wet coat of this mixture. After a drying time of 5-10 minutes at 20°C, recoat with Primabase

Mixing Ratio by Volume:

100 parts of Primabase:
100 parts of 3.2.1 Thinner slow or extra slow:

Spraying Viscosity:

14-15 s DIN Cup 4 at 20°C

Potlife:

When mixed 24 hours at 20°C

Spray gun fluid tip and working pressure:

Spray gun:	Fluid tip:	Working pressure:
Gravity feed:	1.2-1.5 mm	3-4 bar
Syphon feed:	1.4-1.6 mm	3-4 bar
Pressure pot:	1.1-1.2 mm	4-5 bar.
HVLP:	1.2-1.5 mm	0.7 bar at the tip

Application Process:

First apply one single coat to the repair area. After a flash-off time of 4-8 minutes, cover the area overall. Depending on the hiding power of the colour, apply two or three thin single coats, allowing for a flash-off time of 4-8 minutes between coats (do not apply these coats too wet). Cover Primabase metallic colours with a final mist coat, using a working pressure of 2 bar.

Note: With HVLP applications a reduction of air pressure is not really necessary; just enlarge the spray distance to the object. For color accuracy the pressure can be reduced to 2½-3 bar at the clock.

After a drying time of 15 minutes at 20°C, Primabase can be finished with Clearcoat..

Spot Repairs and Fade-Out Areas Primabase metallic colours:

When making spot repairs, use a working pressure of 1-1½ bar to spray thin coats until achieving opacity. Allow the metallic coat to set to a matt finish. Next, fade out twice, well extending beyond the edges, using a working pressure of 1-1½ bar.

Note: With HVLP applications reduce the pressure to ± 2 bar at the clock (for keeping the spot small).

Masking of Primabase at 20°C:

Primabase + 3.2.1 Thinner: 15 minutes

After the drying times mentioned above, the Primabase metallic coat may be masked and recoated with another Primabase metallic colour. After 10-20 minutes' setting at 20°C, apply a topcoat of Visionclear P or one of the Focusclear LV.

Primabase Solid colours:

Cover the spot repair area with two or three coats until achieving opacity. Allow the solid coat to set to a matt finish. Next fade out twice, well extending beyond the edges. After 15-20 minutes' drying at 20°C, Primabase solid colours can be recoated with Visionclear Plus or one of the Focusclear LV. However, it is essential to cover Primabase solid colours with a clearcoat within 5 hours.

However, if this is not possible for whatever reason, for example, because of design applications or the use of several colours on trucks and buses, add 5 parts by weight of Hardener V250 or Hardener V335. Next mix with 3.2.1 Thinner. This will prolong the recoating time to a maximum of 7 days.

(In the case of design applications of Primabase Solid colours, do not apply more than three colours over each other successively).

Film Thickness:

Primabase metallic and pearl colours : 5-10µm per coat
Primabase solid colours : 10-15µm per coat.

Cover rate:

Theoretical: 8 m²/l unthinned Primabase Metallic at 25µm.
6 m²/l unthinned Primabase Solid at 35µm.

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:

Use 3.2.1 Thinner, Catina Solvent or a nitrocellulose thinner.

What to do:

If pinholing occurs in the Primabase metallic coat due to silicones?

The best thing to do is to spray two mist coats first and to allow for longer flash-off times. Thus the risk of pinholing can be avoided.

Recoatibility:

Primabase has to be recoated with Visionclear P, Focusclear LV, Primaclear 808, Topclear 821 , Superclear 921.

Packaging:

1 lt

HEALTH & SAFETY DATA concerning Primabase and additives:

For professional use only.(See **Material Safety Data Sheet**).

See text on the label of this product.

The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.
