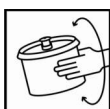
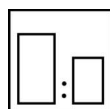


Serie 900+ WaterBase MM 900 - 999

APPLICATION DATA



Mixing Ratio

: (Only for USA 3.5 VOC Base Coat)
Topple packaging before use for 10 sec.
Use the Paint pusher.

Custom made formulas: add 10% Thinner 9-151 / 9-161.

For 3.5 VOC North America Regulated Areas, please refer to the Color Focus Formual Retrieval Software for the compliant Thinner selection.



Application viscosity

DINCUP 4mm/20°C(70°F)

: Airspray (sec) : -
Pressure tank (sec) : -
Airless (sec) : -

(* **Application Method 1 and Application Method 2:**
See APPENDIX 1

(** **Maximum 24 hrs drying (20-25°C) before clear coating**



Gravity feed

Suction feed

Pressure tank

Airless

HVLP

HE

Nozzle diameter (mm)

Spraying pressure (bar/psi)

-

-

-

-

-

-

-

-

1,3

See Info Manufacturer

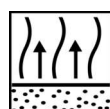
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See Info Manufacturer



Spray coats / Layer thickness (µm)

: (*) / 15-20µm (0.6-0.8mil)



Flash-off (min)

20°C/70°F

: -



Drying time (min)

20°C/70°F

: (**)

60°C/140°F

: -

Obj.



Potlife (min)

20°C/70°F

: 6 months

Only for USA; If used as instructed, this product is designed to comply with VOC standards in low-VOC jurisdictions. Confirm compliance with state and local air quality rules before use.

The technical data in these publications are based on our present knowledge and give you an idea of the various applications without obligations.

Serie 900+ WaterBase MM 900 - 999



PRODUCT INFO

- Area of application** : Waterbased base-coat layer in a clear-over-base system. Suitable for passenger cars, touring cars, trucks etc.
- Chemical base** : Acrylic dispersion.
- General qualities** : Waterbase Serie is a base-coat which has to be finished with a HS Clear Coat.
- Auxiliary materials** : 9-151/ 9-161

Physical properties	Specific gravity (kg/l)	: 0.992 to 1.103
	Flash point	: Closed cup: >61°C (>141.8°F)
	Vol.% solids	: 15-35
	Economy	: 15 m ² /L/20 µm (0.8 mil)
	Gloss	:
	Color	: Not available.

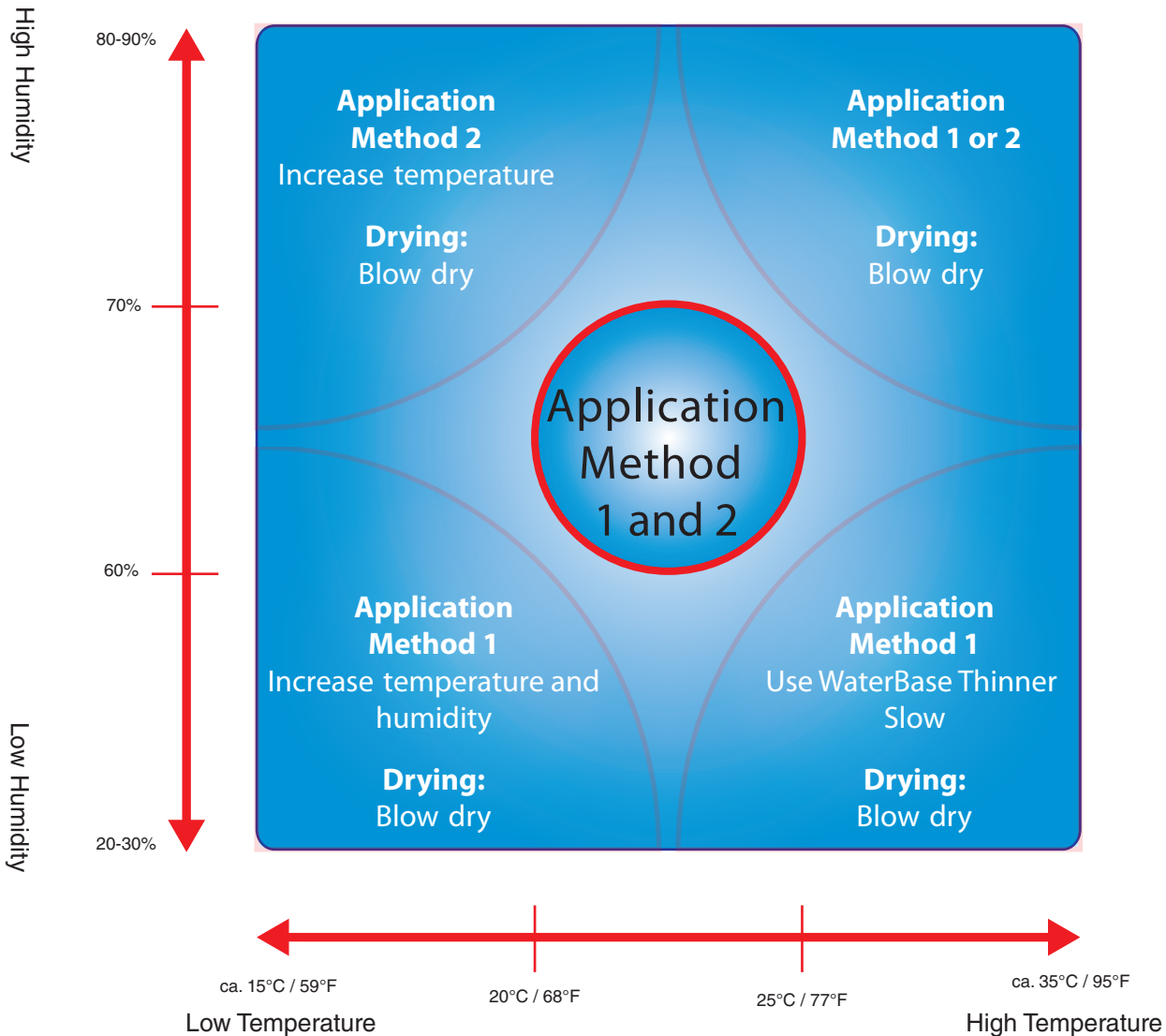
- Substrates** : See undercoats
- Undercoats** : 8-145, 8-149 (Sanding), 30-746, 1-7510/1-7520, (80-221 only for USA)
- Finishing materials** : 1-204, 8-104, 8-214, 8-314, 8-414, (80-121 only for USA)
- Cleaning the equipment** : 9-852 WaterBase Gun Cleaner
- Storage life (years)** : min. 1- 2 (>5°C - <25°C) (see appendix)
(Under normal storage conditions and unopened tins).

Only for USA; If used as instructed, this product is designed to comply with VOC standards in low-VOC jurisdictions. Confirm compliance with state and local air quality rules before use.

The technical data in these publications are based on our present knowledge and give you an idea of the various applications without obligations.

APPENDIX 1

WATER BASECOAT APPLICATION FOR DIFFERENT HUMIDITY AND TEMPERATURE



Application Method 1:

- One mist coat	2 Bar / 29 psi
- Blow dry *	
- Two single wet coats, wet on wet to cover	2 Bar / 29 psi
- Blow dry *	
- Drop coat (effect colours only)	1 Bar / 14.5 psi
- Blow dry *	

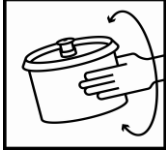
Application Method 2: **

- One mist coat	2 Bar / 29 PSI
- Blow dry *	
- First single wet coat	2 Bar / 29 PSI
- Blow dry *	
- Second single wet coat	2 Bar / 29 PSI
- Blow dry *	
- Drop coat (effect colours only)	1 Bar / 14.5 PSI
- Blow dry *	

At temperatures between 20 -25 ° C and a relative humidity between 60-70%, both Application Methods 1 and 2 are recommended.
 * Blow dry until matt at 30-35°C / 85-95°F
 ** Application 2 is preferred for deep black solid colours to achieve the darkest shade.

APPENDIX 2

25-1-2012



**Topple packaging before use for 10 sec.
Use the Paint pusher.**

Storage life / Shelf life Serie 900+ WaterBase MM 900 - 999

Under normal storage conditions, constant temperature and unopened packaging (>5°C-<25°C)=(>41°F-<77°F)

900+	
WaterBase	
MM	Storage life (years)
900	2
901	1½
902	1½
903	1½
904	2
905	2
906	2
911	1½
912	2
913	2
913B	2
913C	2
913VC	2
913VF	2
919	2
921	1½
922	1½
924	2
926	2
927	2
928	1½
929	2
930	2
934	2
938	1½
940	2
942	1½
943	1
944	2
946	2
948	2
950	2
951	2
952	2
953	2
954	2
955	2
956	2
957	2
959	2
960	2
961	2
962	2
963	2
964	2
965	2
966	2
967	2
978	2
969	2
971	2
972	2
973	2
974	2
975	2
976	2
977	1½
979	1½
986	2
987	2
989	2
997	2
998	2
999	2