

Basecoat WB[®]

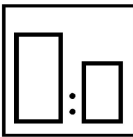
FOR PROFESSIONAL USE ONLY

Description

Basecoat WB waterborne basecoat provides excellent coverage, metallic control and sprayability when used to duplicate OEM solid, metallic and pearl color effects. Basecoat WB must be used in conjunction with an appropriate Lesonal clearcoat in order to provide protection from the environment.



Agitate / gently shake the Basecoat WB can prior to use



100 Basecoat WB
0-40 Activator WB

o Stir color thoroughly prior to adding Activator WB



Use Lesonal Measuring Stick #9



Spray gun set-up:
1.4 – 1.5 mm

Application pressure:

29 psi(spray gun air inlet)

HVLP max. 10 psi at air cap

o Check gun manufacturer specification

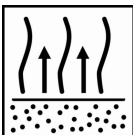


Application; metallic colors:
3 X 1 coat

Application; solid colors:

2-3 X 1 coat

Full coat – Intermediate coat – Orientation coat



Between coats:
Until completely matt at 75°F
(24°C).

Prior to clearcoat application:
15 minutes at 75°F (24°C).



Clearcoat application

Mix and apply clear coat per technical data sheet specification.



Use suitable respiratory protection

Akzo Nobel Car Refinishes Inc. recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

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Suitable substrates

- All Existing OEM finishes, excluding thermoplastic acrylic finishes.
- All current Lesonal preparatory products. With the exception of direct application on acid containing washprimers and Lesonal aerosol Spot Primers.

Product and additives

- Product:** Basecoat WB MM (Mixing Machine) toner colors
- Hardener:** Hardener WB is suitable for use in Lesonal WB. Addition of 5% is sufficient to improve system robustness (stone chip resistance, adhesion and system hardness) or in case multilayer systems are applied and the recommended layer thickness is exceeded
- Activator:** Activator WB, the Basecoat WB waterborne basecoat activator to use for all repair sizes and all application conditions. (Approximately 70°F (20°C) and higher with a relative humidity range between 20% to 80%).
- Additives:**
- Ready Mixed Additive, to extend the pot-life of Basecoat WB metallic color formulas to a maximum of 3 months.
 - o Add 5% of Ready Mixed Additive by weight to the Basecoat WB, before adding any Activator WB
 - Lesonal Guncleaner WB
 - Separator WB
 - o No plasticizer required for application on plastic car parts.

Basic raw materials

Basecoat WB: Physical drying binders

Surface preparation



Dry sanding with final sanding step #P500 to #P600

- o Initial sanding steps may be executed with a coarser sanding grit; for example, #P360 - #P400
- o Respect a maximum 100 sanding grit step difference or less throughout the taken sanding steps.



Wet sanding with final sanding step #P800 to #P1000

- o Initial sanding steps may be executed with a coarser sanding grit #P600
- o Respect a maximum 200 sanding grit step difference or less throughout the sanding steps.



Surface Cleaning:

Prior to commencing any preparation, thoroughly clean the surface and remove any surface contamination prior to topcoat application using appropriate surface cleaners

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Material preparation and mixing

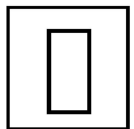


Agitate/ gently shake Basecoat WB several times before use for optimal pour viscosity of the MM toners prior to mixing.

- The following Basecoat WB MM toners must be shaken or stirred thoroughly before using for the first time; thereafter they should be agitated / shaken as recommended for all other MM toners: 25, 190M, 191M, 192M, 193M, 194M, 195M.

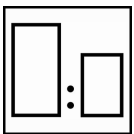


The Basecoat WB MM colors must be stirred thoroughly, directly after mixing the formula. And before adding Activator WB.



Ready to spray.
Basecoat WB is ready for use.

Once the Basecoat WB formula color has been thoroughly stirred the product is ready to apply.



Climate condition; high temperature / low humidity
(humidity is considered low @ RH 40% or less)

Add 10 to 30 parts Lesonal Activator WB to all Basecoat WB colors.

For accurate mixing always use the Lesonal measuring stick # 8 or mix on the scale using Addit.

- Mix Deep Black, MM25 with up to a maximum of 5 parts Activator WB.
- Add up to 30 parts of Activator WB to Basecoat WB metallic colors for optimal sprayability.
- Do not add more than a maximum of 10 parts Activator WB to Basecoat WB solid colors.

Color mixing by hand: If a pure Basecoat WB Metallic toner is used for application, mix 1 part of the metallic toner with 4 parts MM02.

Basecoat WB MM solid colors do not require the addition of binder for application.

Points of attention

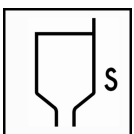
Filtering:

Use waterborne suitable paint strainers for optimal filtering, use a 125 micron filter. (125µm).

Solvents:

Avoid contact between waterborne products and any conventional solvents.

Spray viscosity



25–35 seconds DIN cup #4 at 70°F (20°C).

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Spray gun set-up / application pressure



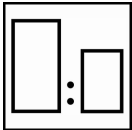
Spray gun	Fluid tip –set up	Application pressure
HVLP Gravity feed	1.4 – 1.5mm	HVLP. Max. 10 psi at air cap
High transfer Gravity feed	1.4 – 1.5mm	*29 to 36 psi at air inlet
Conventional Gravity feed	1.4 – 1.5mm	45 psi at air inlet

*Check gun manufacturer specification

Pot-life

All mixed solid and pearl Basecoat WB colors:	3 months at 70°F (20° C).
Basecoat WB Metallic colors, containing toner MM03:	1 day at 70°F (20° C).
Basecoat WB Metallic colors not containing toner MM03:	1 week at 70°F (20° C).

To obtain a 3 month pot-life for all Basecoat WB Metallic colors add 5% (by weight) Ready Mixed Additive.



Adding Basecoat WB Ready Mixed Additive: Thoroughly stir the MM toners after mixing the formula, then add 5 parts (by weight) Basecoat WB Ready Mixed Additive. Stir thoroughly before adding Activator WB, stir once more prior to use.

Do not use Ready Mixed Additive in solid colors.

Application process



Solid colors

Apply 2 single coats or until opacity is achieved. Flash off between coats by increasing airflow and or heat until the basecoat dries completely to a matt finish. If necessary allow the surface to cool. Dry for a minimum of 15 minutes (max. 24 hours) at 75°F (24° C) prior to clearcoat application.

Metallic / pearl colors

Apply 1 full coat, 100 % closed coat,. Next apply an intermediate coat, 80 % of the first coat, Flash off between coats by increasing airflow and or heat until the basecoat dries completely to a matt finish. If necessary allow the surface to cool.

When needed, apply an orientation coat . Increase the distance to approximately 12 to 14 inches and apply a light coat with no wet areas.

Dry for a minimum of 15 minutes (max. 24 hours) at 75°F (24° C) prior to clearcoat application.

- o Thorough drying after basecoat application is necessary.

Spot repairs / fade out areas

When making spot repairs apply thin coats until opacity is achieved. Dry until matt between each coat before fading out well beyond the edges.

In case of metallic colors lower air pressure may be needed for color control . Extend each coat until coverage is obtained. Finally apply an orientation coats fading out well beyond the coverage coats.

- o *In the case of high hiding colors and fading out, the color transparency can be increased by adding MM 02 RTS to the RTS mixed color, at a ratio of 100 parts color and 50 parts MM02.*
- o *MM toner 02 may also be used as a clear foundation coat before commencing the spot repair. Apply one single coat of this first layer to allow for an easier orientation of*

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metallic particles during the fade out

Drying and air acceleration

Humidity and airflow will influence the Basecoat WB flash off and drying times. These times can be reduced to a minimum by using air accelerator systems with a distance of 3 feet from the object, thus increasing the airflow over the object.

When heat is used for drying, allow object to cool down to application temperature before proceeding with color or clearcoat application.

Film thickness

Basecoat WB solid, metallic and pearl colors: 0.4-0.9 mils. (10-20 μ m)
The total dry layer thickness of Basecoat WB should never exceed 1.2 mils. (30 μ m)

Masking

Basecoat WB colors can be taped (i.e. two toning) after 20 minutes flash-off at 75°F (24°C).

- *Increasing temperature especially in combination with air movement improves the ability to apply masking on Basecoat WB.*
- *Let the object cool down to ambient temperature before masking.*

Denibbing

Allow Basecoat WB to dry sufficiently, at least 20 minutes at 75°F (24°C). Then lightly dry sand the damaged area with #P600 to #P1000 free-cut sanding paper. Thoroughly remove sanding dust residue before continuing Basecoat WB application.

Recoatable with

- Lesonal LV Clear.
 - Mix and apply clear coat per technical data sheet specification.
- Proair Clear and Glamour Clear (National Rule)

Recoat time

Prior to clearcoat application:

Minimum 20 minutes at 70°F (20°C)

Minimum 15 minutes at 75°F (24°C).

Maximum 24 hours at 75°F (24°C).

- *After the final coat has normally flashed off, increase airflow for the 15 minutes at 75°F (24°C)*
- *Thorough drying after basecoat application is necessary.*

Should this maximum time be exceeded, abrade the surface and apply another coat.



Material usage

Theoretical material usage is \pm 64 sq.ft./litre RTS mixture. at a film thickness of 0.9 mils

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

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Clean and rinse the spray gun thoroughly after use with Lesonal Guncleaner WB.

Purge the spray gun with Lesonal Activator WB prior to Basecoat WB use.

- o *Do not use any conventional thinner unless removing dried Basecoat WB deposits.*

Do not soak the spray gun for long periods either with Lesonal Guncleaner WB. or Activator WB.

VOC

The VOC content of this product in ready to use form is <3.4 lb. /gallon. (<407 g./liter)

Storage

Product shelf-life is determined when products are stored unopened at 70°F (20° C).

Avoid too much temperature fluctuation.



- o *For optimal performance, allow the ready to spray material to reach the application temperature before application*
- o *Maximum transport and storage temperatures between 36°F-95°F (2 °C and 35 °C).*
- o *Frozen Basecoat WB toners causes gelling / lumps after which these toners can no longer be used.*
- o *Product shelf life 1 – 4 years unopened.*

AkzoNobel Car Refinishes Inc. North America

Address: 3587 Parkway Lane, Norcross. GA 30092 USA

Tel: 770-662-8464

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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Head Office

Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.lesonalcr.com