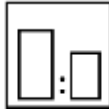


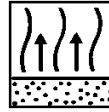
WATERBORNE BASECOAT SYSTEM



2.1 with Reducer



2 to 3 single wet



Flash off until matt



1.2 - 1.3 mm Ø
0.6 - 0.7 BAR
9 - 10 PSI

Description:	<p>HYDROLUX is a one component acrylic based waterborne basecoat system designed for use in automotive refinishing. These basecoats have been formulated with the highest quality range of light fast pigments to meet the OEM colour standards (solids, metallics and pearls). Good coverage, flow and ease of application provide the refinisher with a quality product. Note: HYDROLUX basecoat <u>must</u> be overcoated with a clearcoat.</p>							
Product and Additives:	<p>HYDROLUX Basecoat HYDROLUX Reducer, 9991 HYDROLUX 2K Binder, 9998 HYDROLUX 2K Hardener, 9993 HYDROLUX Blender</p>							
Suitable Substrates:	<p>HYDROLUX Basecoat can be applied over:</p> <ul style="list-style-type: none"> - Existing Finishes except Thermoplastic Acrylics and NC products - METALUX 2 undercoats with exception of lacquer and etch primers. - Ideal over METALUX 2 2K HS Filler Primers. 							
Surface Preparations:	<p>Degrease then wet flat P800 – P1000 grit or dry flat P400 – P600 grit (DA). Re-clean surface after sanding.</p>							
Mixing Ratio:	<p><u>For Metallic, Pearl and Special Effect Colours:</u> 2 parts by volume HYDROLUX 50% by volume HYDROLUX Reducer</p> <p><u>For Solid Colours:</u> 2 parts by volume HYDROLUX 60-70% by volume HYDROLUX Reducer</p> <p>Important: - Stir thoroughly before adding reducer. Always strain after mixing. - Never use an internal gun strainer when applying metallic and pearlescent colors.</p> <p>Note: RFU <u>VOC</u> is below 420 g/l.</p>							
Process:	<p>Apply 2 single wet coats allowing flash off until matt after each spraycoat. An additional coat may be required with colors difficult to cover. Drying time depends on climatic conditions and equipment. Additional air flow will speed up the process, allowing 3 to 5 minutes flash off between coats. Taping times on HYDROLUX is 15 to 20 minutes.</p> <p><u>Option for metallic's and blending basecoat:</u> After the final coat of color, lower the air pressure and apply a final medium-wet mist coat. <u>Do Not</u> dry spray.</p> <p><u>Option for underbody or underhood colours:</u></p> <table border="0"> <tr> <td>Step one – Reduce the Colour</td> <td>Step two – Catalyze the 2K Binder</td> </tr> <tr> <td> 2 part by volume Colour</td> <td> 2 part by volume 2K Binder</td> </tr> <tr> <td> 1 part by volume Reducer</td> <td> 1 part by volume 2K Hardener</td> </tr> </table> <p>Step three – Mix the Colour and the Binder</p> <p> 2 part by volume reduced Colour 1 part by volume catalyzed Binder</p>		Step one – Reduce the Colour	Step two – Catalyze the 2K Binder	2 part by volume Colour	2 part by volume 2K Binder	1 part by volume Reducer	1 part by volume 2K Hardener
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HYDROLUX™ WATERBORNE BASECOAT SYSTEM



www.chemspecpaint.com

Spray Gun Settings: HVLP Gravity: 1.2 – 1.4mm 0.6 – 0.7 BAR / 9 – 10 PSI At the cap
High Efficiency: 1.2 – 1.4mm 1.5 – 2.5 BAR / 22 – 36 PSI Inlet pressure

Note: Refer to spray gun manufacturer for further information regarding inlet pressures.

Film Thickness: ± 10 - 15 micron / 0.4 - 0.6 mil per coat Metallic colours.
± 15 - 25 micron / 0.6 - 1.0 mil per coat Solid colours.

Recommended Flattening: Dust nibs can be removed with P1000-P1500 dry only.

Recoatibility: Must be recoated with clear before 8 hours. Allow basecoat to properly flash before applying clearcoat. Cooler temperatures may require longer flash times. If basecoat is not recoated within the proper recoat time, remove or scuff sand the basecoat and then reapply basecoat to avoid clearcoat peeling.

Cleaning of Equipment: Clean equipment immediately with waterbased gunwasher.

Other Information: Equipment needed - We recommend the use of stirring lids for waterborne products.
- Spray guns must be stainless steel.
- Use plastic cans and plastic stirring rods to mix **HYDROLUX**.

Stock requirements: - Mixing bases and Reducer are frost-resistant.
- Binder and Blending additive have to be stored above 4°C / 39°F.
- Material has to be at room temperature (18-25°C / 65-77°F) before use.

Waste disposal: - Waste from water borne paints should never be flushed down the drain. The shop needs to check with their local waste handler to see if the water waste needs to be kept separate from the solvent waste.

Stirring: - NB: stir all toners well before placing onto the mixing bank.

Health & Safety: Ref to text on label and MSDS. Flammable – keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.