

BASECOAT/COLOR COAT

30-0001 [Automotive Nitrocellulose Top Coat Black]

1. GENERAL INFORMATION

high performance Acrylic/Nitrocellulose coating for Automotive coating. It's provide good color strength, easy to spray, good adhesion over primed coated substrate. It's also able to apply direct to plastic such as ABS, PC/ABS. It's can be used in conjunction with 2K clear coat in order to environmental protection.
Packing Size : -

2. MIXING

COMPONENTS

30-0001 (Automotive Nitrocellulose Top Coat Black)
86-104 (Acrylic BBP Thinner)

MIX RATIO	Volume	By weight	Remark
30-0001	100	-	
86-104	120	108.00	
APPLY VISCOSITY	10 - 12 second NK#2		

3. APPLICATION

SURFACE PREPARATION

All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application.

APPLICATION

Number of coats	2 – 3 coats Medium wet coats. Remark : Mixing ratio, Mixing component and environmental are effect to flash off time.		
Dry film thickness	30 - 40		
Theoretical Coverages	30 - 35	per/1 Gallon of ready to spray paint at 20 micron	

APPLICATION EQUIPMENT

GUN SET UP*	Compliant	Gravity Feed	1.3 – 1.6 mm
		Siphon Feed	1.3 – 1.6 mm
	HVLP	Gravity Feed	1.3 – 1.6 mm
		Siphon Feed	1.3 – 1.6 mm
AIR PRESSURE*	Compliant	Gravity Feed	20 – 30 psi at the gun
		Siphon Feed	20 – 30 psi at the gun
	HVLP	Gravity Feed	6 - 8 psi at the cap
		Siphon Feed	6 - 8 psi at the cap

Remark : The listed setups cover the range for standard application equipment.

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4. DRY TIME

AIR DRY @25-30 °C

Touch Dry : 3 - 5 minutes

Dry for wet sanding : 1 - 2 minutes

FORCE DRY at 60-80 °C

Flash off before forcing dry : 5 - 10 minutes

Cycle Time : 10 - 15 minutes

Cool Down : 30 – 40 minutes

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.

Remark : Flash time and Dry times will depends on temperature, humidity and wet film thickness.

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and assume no liability in connection with its use.

5. PHYSICAL PROPERTIES

Specific Gravity : 1 - 1.1 g/cm³

Paint Viscosity : 95 - 105 KU

Total Non-Volatile Solid : 38 - 42 %

6. VOC REGULATION AREAS

These directions refer to the use of products which may be restrictors require special mixing instruction in VOC regulation areas. Follow mixing usage and recommendations in the VOC compliant products Chart for your area.

7. SAFETY AND HANDLING

For professional or trained applicator use only. Not for sale or use by the public. Before use, read and follow all TDS, label, and SDS precautions. Flammable product. Keep outreach of children. Always wear approved organic vapor goggles and a safety mask when using a product. Apply paint in good ventilating area.