

### BASECOAT/COLOR COAT

#### 56-AL8 [ Acrylic Top Coat Coarse Bronze ]

##### 1. GENERAL INFORMATION

High performance Acrylic basecoat 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 must be used in conjunction with 2K clear coat in order to provide protection from environment.  
Packing Size : 1 Litter / 1 Gallon

##### 2. MIXING

###### COMPONENTS

56-AL8 ( Acrylic Top Coat Coarse Bronze )

86-104 ( Acrylic Thinner )

| MIX RATIO       | Volume                | By weight | Remark |
|-----------------|-----------------------|-----------|--------|
| 56-AL8          | 1.0                   | 100       |        |
| 86-104          | 1.0                   | 130       |        |
| APPLY VISCOSITY | 11-13 seconds by 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<br>Medium wet coats.<br>Remark: Mixing ratio, Mixing component and environmental effect to flash off time. |                                                                       |  |
| Dry film thickness    | 20 – 30 microns                                                                                                        |                                                                       |  |
| Theoretical Coverages | 9 - 10                                                                                                                 | m <sup>2</sup> /1 Liter of ready to spray paint at dry film 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

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AIR DRY @25-30 °C

Touch Dry : 3 – 7 minutes

Dry for Topcoat : 10 – 15 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 setting up recommendations.

#### 5. PHYSICAL PROPERTIES

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Specific Gravity : 1.00 - 1.30 g/cm<sup>3</sup>

#### 6. VOC REGULATION AREAS

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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

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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.

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 assumes no liability in connection with its use.