

VERSION

Version 1
Date 4 February, 2020

PHYSICAL PROPERTIES

Supply viscosity	16 – 18 second by ford cup No.4 [30-8002 : T-AKL 1:1 by weight]
Specific gravity	0.89 – 0.90 g/cm ³
Gloss	10 – 12 GU at 20°
Shelf life	1 Year Store in average temperature between 40 – 95 °F (5 – 35 °C). Avoid too much temperature fluctuation or direct contact with sunlight. Suitable storage temperature is 70 °F or 21°C

PRODUCT DESCRIPTION

30-line is 1K high performance 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.

APPLICATION PARAMETERS

Mixing ratio	Basecoat paint : Thinner 1:1-1.5 % By Volume		
Reducer Thinner	Standard Thinner-Premium # 86-100 Standard Thinner-Economic #86-158		
Coverage	45-50 m ² / Gallon at dry film 15-20 micron By using the recommended application, the theoretical material coverage <i>Note. The practice material usage depends on many factors i.e. shape of object, roughness of the surface, application techniques, pressure and application circumstances.</i>		
Spray viscosity	Ford cup No. 4	10-15 seconds	
Spray condition	Gravity feed	1.2 – 1.4 mm	
	Air pressure	1.7 -2.2 bar 28 – 30 psi HVLP max 0.6 – 0.7 bar (8-10 psi) at the air cap	
Number of coats	2 coats	Dry film thickness 30 - 40 micron.	
Flash time	20 – 25 mins	at 25 – 30 °C	
Dry time		20 °C	30 °C
	Dust free time [min.]	7-10	5-7
	Dry to handle [min.]	45-60	30-40

KEY CHARACTERISTICS

- 1K High Gloss paint
- 1K Acrylic paint
- High gloss paint
- Paint for automotive
- Good weathering basecoat

PRECAUTION

Warning	For professional or trained applicator use only. Not for sale or use by the general public. before use, read and follow all TDS, label, and SDS precautions. Flammable product. Keep out reach of children. Always wear approved organic vapor goggle and safety mask when using product. Apply paint in good ventilating area.
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This product data sheet is intended to describe Big-Ben's product application. It should not be therefore be constructed as guarantee in any specific property of the product. We assume no liability in connection with its use.