

Basecoat WB GT


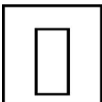


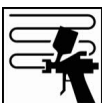
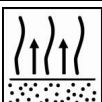


Basecoats

06/11/2019

L1.09.02 UK & Ireland

DESCRIPTION

One component, latest technology waterborne basecoat system. Available in a wide variety of effect colors including metallic, pearls and solids. Specifically designed for the refinishing of passenger cars, but also suitable for refinishing of light commercial vehicles. A full range of ancillary products enables the product to be used successfully on a wide variety of jobs, in most types of application.

		Gently shake each Basecoat WB GT toner prior to use	
Mixing ratio		RFU	Basecoat WB GT
Mixing stick		At high temperatures / low humidity : Lesonal Activator WB : up to 20%	
Equipment		Spray gun set up: 1.2-1.3 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap
Application		Solids colors 2 x 1 coat	Metallic colors 2 x 1 coat + mist coat
Flash-off		Between coats Until completely matt	Before clearcoat Until completely matt
Recoatability		All Lesonal clearcoats	
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator	

Read complete technical data sheet for detailed product information

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PRODUCT AND ADDITIVES

Product	Basecoat WB GT
Thinner	Activator WB (optional)

Chemical Basis	Basecoat WB GT	Physical drying binders
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METHOD OF USE

Substrates	<p>Original finishes, including thermoplastic acrylic</p> <p>2K Universal Plastic Primer</p> <p>1K Multi Plastic Primer (RTS)</p> <p>1K Primer Filler RTS</p> <p>2K HS Primer Filler</p> <p>2K Graphite Filler</p> <p>2K Filler 540 (RTS)</p> <p>2K High Build Filler</p> <p>2K Epoxy Primer</p>
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Note :

All Basecoat WB GT SEC colors except SEC2322 must be applied on 2K Graphite Filler Black, 2K Filler 540 Black, Basecoat WB GT MM 23 Black or fully cured and sanded Black single stage topcoat.

Basecoat WB GT SEC2322 (NIS AV2) should be applied over color NIS1052.

Do not apply directly over etch primers

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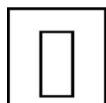
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Substrate preparation Thoroughly clean the surface with Lesonal Degreaser.
Sand with P500 grit dry.
Degrease with Lesonal Degreaser.

Mixing ratio



RFU Basecoat WB GT

For optimum pour viscosity, gently shake Basecoat WB GT before use.
To avoid overspray when painting larger objects or in warmer conditions / lower humidity, Activator WB can be added up to a maximum of 20%.

Spraying viscosity 25-35 sec. DIN Cup 4 at 20°C

Potlife	All colors	3 months at 20°C
	Basecoat WB GT 308NA, NB, ND metallic colors	1 week at 20°C
	Basecoat WB GT 308NA, NB, ND metallic colors containing MM05	1 day at 20°C

Spray gun set up



Spray gun:	Fluid opening:	Spraying pressure:
HVLP Gravity	1.2-1. mm	0.7 bar (at air cap)
LVLP/HR Gravity	1.2-1.3 mm	1.7-2.2 bar (at air inlet)

Refer to user manual spray gun used

APPLICATION TECHNIQUE

Application



Metallic and pearl colors
Apply one single wet coat. Allow flash off until the coat is completely matt.

Apply a following lighter coat and allow to flash off until the coat is completely matt.
When covering is achieved, finish with a mist coat layer by increasing the distance to the object.

Solid colors
Apply one full single coat. Allow flash off until completely matt.
Apply another single coat and allow to flash off until completely matt.
If needed, repeat until covering is achieved.

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Application



Spot repairs / Fade out areas

When making spot repairs use lower application pressure and apply thin coats until opacity is achieved.

Dry until matt after each coat before fading out well beyond the edges.

In case of metallic colors apply a mist coat when needed by increasing the spray gun distance

Note:

Fade out of Basecoat WB GT can be done on:

- Existing finishes, prepared according to TDS L8.01.01
- A wet coat of MM02 / MM04 (60:40)
- A dried coat of MM02

Working time can be reduced by acceleration of the air speed, by using dry-jets, positioned at a minimum distance of 1 meter from the object.

Note

While making a spot repair, it's not necessary to tag-rag between coats.

- If a pure Basecoat WB GT metallic tinter will be applied, always mix:
55% Basecoat WB GT metallic with 45% tinter 04
- Clean spray gun with Lesonal Guncleaner WB directly after use

Equipment cleaning

Use Lesonal Guncleaner WB

Layer thickness

10 - 25 microns

Material usage

Ready for use mixture at 1 µm layer thickness :

167 m²/liter

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

Recoatability

Basecoat WB GT can be recoated with all Lesonal clearcoats

Product storage

Avoid too much temperature fluctuation.

- o For optimal performance, store opened products at application temperature
- o Maximum transport and storage temperatures between 3°C-35°C.
- o Frost causes gelling / lumps in Basecoat WB GT toners after which they no longer can be used.

Shelf life

See TDS L9.01.02

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VOC	2004/42/IIB(d)(420)420 The EU limit value for this product (product category : IIB.d) in ready to use form is max. 420 g/l VOC. The VOC content of this product in ready to use form is max. 420 g/litre.
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