

Basecoat WB GT

Basecoats

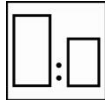
01/08/2019

L1.09.01/L1.09.02

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.

Mixing ratio



Ready For Use (RFU)

-For optimum straining use waterborne suitable paint strainers, size: 125µm.

Mixing stick



In case of high temperatures / low humidity, Lesonal Activator WB can be added up to a maximum of 40%

Equipment



Spray gun set-up HVLP:
1.3-1.4 mm

Application pressure HVLP:
0.7 bar at the aircap

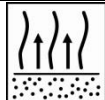
Application



Solids colours
Metallic and pearl colours

2 x 1 coat
2 x 1 coat followed by a mistcoat

Flash-off



Between coats
Dry until mat after each coat

Before clearcoat
Until matt



-2K Clearcoat 228 HS
-Xpress Clear 261
-2K MS Matting

Protection



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator

Read complete TDS for detailed product information

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PRODUCT & ANCILLARY ITEMS

Product	Lesonal Basecoat WB GT. Mixed to formulae (by weight)	
Activator	Basecoat WB GT is ready for use	
	To avoid overspray with painting larger objects or in warmer conditions / lower humidity, Activator WB can be added from 0 up to a maximum of 40%. (The higher the temperature and/or the lower the humidity more Activator WB may be added)	
	Note: Avoid contact with organic solvents	
Chemical Basis	Basecoat WB GT Activator WB	- Physical drying binders - Water/Glycol mixture

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METHOD OF USE

Substrates Original finishes, including thermoplastic acrylic
 Lesonal 1K Multi Plastic Primer (RTS)
 Lesonal 2K Primer 488
 Lesonal 2K Epoxy Primer 440

Note:

All Basecoat WB GT SEC colors except SEC2322 must be applied on 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

Substrate preparation Prior to commencing any sanding work, thoroughly clean the surface with Lesonal Degreaser. Sand with P1000 wet or P500 dry. After sanding work is completed, and just prior to the application of Basecoat WB GT, again degrease thoroughly with Lesonal Degreaser.

Mixing Ratio Basecoat WB GT is Ready for use
 Gently shake WB GT before use for optimum pour viscosity prior to mixing.
 To avoid overspray with painting larger objects or in warmer conditions / lower humidity, Activator WB can be added from 0 up to a maximum of 40%.
 (The higher the temperature and/or the lower the humidity more Activator WB may be added)

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

Potlife All colors 3 months at 20°C

Spraying Pressure	Spray-gun	Fluid tip	Spraying Pressure
	HVLP Gravity Feed	1.3-1.4 mm	0.7 bar (at air cap)*

**Please refer to user manual of spray-gun used*

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APPLICATION TECHNIQUE

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.
If covering is achieved, finish with a mistcoat layer by increasing the distance between spray-gun and object.

Solid colors Apply one full single coat. Allow flash off until the coat is completely matt.
Apply another single coat and again allow this coat to flash off until the coat is completely matt, repeat until covering is achieved, a mist coat is not needed with solid colors

Spot repairs / Fade out areas Toner 25
can be applied as a pure color in 2 single layers with a flash-off in between coats until matt or by 2 light wet coats wet-on-wet

Application When making spot repairs use lower application pressure and apply thin coats until opacity is achieved.
Dry until matt between each coat before fading out well beyond the edges. In case of metallic colors apply a mistcoat (metallic orientation coat) when needed by increasing the spray gun distance

Note:

Fade out of Basecoat WB GT can be done on:

- Existing finish, 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, place them within a minimum 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 spraygun with Lesonal Guncleaner WB directly after use

Tips for spot repairing -Apply a coat of pure tinter 02 as a pre- coat for a better orientation of the metallic color can be applied on flashed off tinter 02 or in a wet layer 02.
(don't use tinter 04 as a pre-coat)
-With metallic 50% of pure 02 can be added to the final (drop)coat
-Do not apply to heavy coats while making a spot repair

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Drying methods	<p>Speeding up flash off times can be achieved by:</p> <ul style="list-style-type: none"> -Acceleration of the air speed by dry-jets -Wind-jets -Build in spray booth systems -Heating up the air <p style="text-align: center;">(please ask your distributor)</p> <p>Note If using air accelerating equipment like windjets, venturi's keep a minimum distance of 1 meter.</p>
Film thickness	10-25 micron
Theoretical usage per ltr/m²	<p>167 m²/liter at a layer thickness of 1 micron (the practical material usage depends on many factors, i.e. shape of the object, roughness of the surface, application method and application circumstances)</p>
Equipment cleaning	Use Lesonal Guncleaner WB.
Recoatibility	<p>Allow to flash off until matt of the final base coat before Basecoat WB GT can be recoated with the following clearcoats:</p> <ul style="list-style-type: none"> -2K Clearcoat 228 HS -Xpress Clear 261 -2K MS Matting
Storage	<p>Product shelf-life is determined when products are stored unopened at 20°C. Avoid too much temperature fluctuation.</p> <ul style="list-style-type: none"> ○ For optimal performance, store opened products at application temperature ○ Maximum transport and storage temperatures between 3°C-35°C. ○ Frost causes gelling / lumps in Basecoat WB GT toners after which they no longer can be used.
Helpful Tips	<ul style="list-style-type: none"> • After 20 minutes flash off at 20°C the basecoat can be masked and a second color can be applied. • For optimum straining use waterborne suitable paint strainers, size 125µm. • If there is a risk of cratering due to the presence of contamination, it is advisable to apply the basecoat in thin layers only, and to extend the normal flash off times between each coat.

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Shelflife

See TDS L9.01.02

VOC**2004/42/IIIB(d)(420)420**

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/liter VOC.

The VOC content of this product in ready to use form is max. 420 g/liter.

PROFESSIONAL USE ONLY

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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