

Basecoat SB MM 120

Basecoat

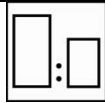
01/08/2019

L5.01.04 APAC

DESCRIPTION

Basecoat SM MM 120 is a one component, mixing machine based, basecoat system. Available in a wide variety of colors including metallics, pearls and solids. Based on the latest refinish technology and providing easy application and an excellent color match. Designed for the refinishing of passenger cars, but also suitable for refinishing of light commercial vehicles. Full range of ancillary products that enable the product to be used successfully on a wide variety of jobs, in most types of application.

Mixing ratio



2 Basecoat SB 120
1 Multi Thinner 810 (any)

Equipment



Spray gun set-up:
1.3-1.5 mm

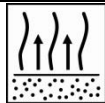
Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap

Application



2 x 1 coat
Apply two coats, allow to become touch dry between each coat.

Flash-off



Between coats
2-5 minutes at 20°C

Before clearcoat
15-20 minutes at 20°C

Drying times



20°C
15-20 minutes, max 6 hours

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 AND ADDITIVES

Product	Lesonal Basecoat SB 120	Mixed to formula (by weight) using Lesonal Basecoat SB 120 MM toners
	Thinners	Lesonal Multi Thinner Standard Fast 810-B
	Lesonal Multi Thinner 810-C	Lesonal Multi Thinner HT 810-CC

Basic raw materials	Basecoat SB 120; Physical drying binders Multi Thinner 810 (any); A blend of organic solvents
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METHOD OF USE

Suitable substrates	Original finishes, with the exception of thermoplastic acrylic. Polyester laminates 1K Multi Plastic Primer 2K Primer 488 EP Primer 440
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Substrate preparation	<p>Prior to any sanding work, thoroughly clean the surface of any grease or wax with Lesonal Degreaser 910. Apply using two clean cloths in a wipe on, wipe off process.</p> <p>Sand with P1000 wet or P400-P500 dry.</p> <p>After sanding work is completed, and just prior to the application of Basecoat SB 120, degrease again thoroughly with Lesonal Degreaser 910.</p>
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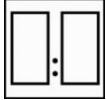
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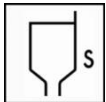
Mixing

2 Basecoat SB 120
 1 Multi Thinner 810 (any)
 Mix in a parallel-sided container and stir well before use.



Viscosity

14-16 sec DIN cup 4 at 20°C.



Spray gun set-up / application pressure

Spray gun	Fluid tip-set-up	Application pressure
Gravity feed	1.3-1.5 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap



APPLICATION TECHNIQUE



Solid colors

Apply 2-3 single coats or until opacity is achieved.
 Allow for a 2-5 minutes flash-off time at 20°C between coats or until the basecoat is completely matt.

Allow for a flash off time of 15-20 minutes before clear coat

Metallic colors

Apply 2 single coats* or until opacity is achieved.
 *Allow for a 2-5 minutes flash-off time at 20°C between coats or until the basecoat is completely matt.

When needed, apply a drop coat by reducing the pressure with a ½ bar at the gun inlet.
 Apply the drop coat with full trigger, increase the distance to approximately 30- 40cm.

Allow for a flash off time of 15-20 minutes

Spot repairs:

When making spot repairs use lower application pressure and apply thin coats* until reaching opacity.

*Allow for a 2-5 minutes flash-off time at 20°C between coats.

Next, fade out, by extending beyond the edges, using similar application pressure.

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

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Allow for a flash off time of 15-20 minutes

Pot-life

After mixing the product must be used within 24 hrs at 20°C. After extended or long storage paint requires thorough stirring and mixing before use.

Solid and Metallic: 6 months at 20°C.

Pearl (3-stage) 24 hours at 20°C.

Theoretical coverage

By using the recommended application, the theoretical material usage is ± 12-14m² per liter for one single coat.

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

Cleaning of equipment

Use Lesonal Multi Thinner 810 (any) or Lesonal NC Thinner 820.

Helpful tips

After 20 minutes at 20°C Lesonal Basecoat SB may be masked upon and a second color can be applied.

If Lesonal Basecoat SB is to be left longer than 6 hours before applying a Lesonal clearcoat, 10% of Lesonal Hardener (720 or 728) should be added into the basecoat before mixing with thinner

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 time between each coat.

New cans of toners should be placed 20 minutes on the mixing machine or 10 minutes in the paint shaker before use.

NOTE: As an option when fading out or applying in cold/poor airflow environments, an additional 10% of Lesonal Multi Thinner 810 maybe added in to Lesonal Basecoat SB 120. This will make the application easier and faster flash off time.

Denibbing

Dust particles can be denibbed with P1000 grit wet paper after 20 minutes at 20°C. Then proceed with the application of Lesonal Basecoat SB 120.

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.

Avoid extreme temperature fluctuation.

Product shelf life data see TDS S9.02.01

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Akzo Nobel Car Refinishes (Singapore) Pte Ltd**Address: 3 Changi Business Park Vista, #05-01 Akzo Nobel House, Singapore 486051****Tel: +65 6635 5262****FOR 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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