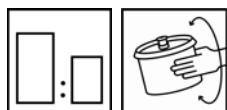


Serie 900 WaterBase MM 900 - 999

APPLICATION DATA



Mixing Ratio

: (Only for USA 3.5 VOC Base Coat)
 Topple packaging before use for 10 sec.
 Use the Paint pusher.

Custom made formulas: add 10% Thinner 9-151/ 9-161.



Application viscosity DINCUP 4mm/20°C(70°F)

: Airspray (sec) : -
 Pressure tank (sec) : -
 Airless (sec) : -

(*) Application Method 1 and Application Method 2:
 See APPENDIX 1



Gravity feed
 Suction feed
 Pressure tank
 Airless
 HVLP
 HE

Nozzle diameter (mm)

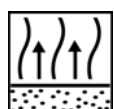
Spraying pressure (bar/psi)

-	-
-	-
-	-
-	-
1,3	See Info Manufacturer
1,3	See Info Manufacturer



Spray coats / Layer thickness (µm)

: (*) / 15-20µm (0.6-0.8mil)



Flash-off (min)

20°C/70°F : -



Drying time (min)

20°C/70°F : (*)
 60°C/140°F : -
 Obj.



Potlife (min)

20°C/70°F : 6 months

Serie 900 WaterBase MM 900 - 999



PRODUCT INFO

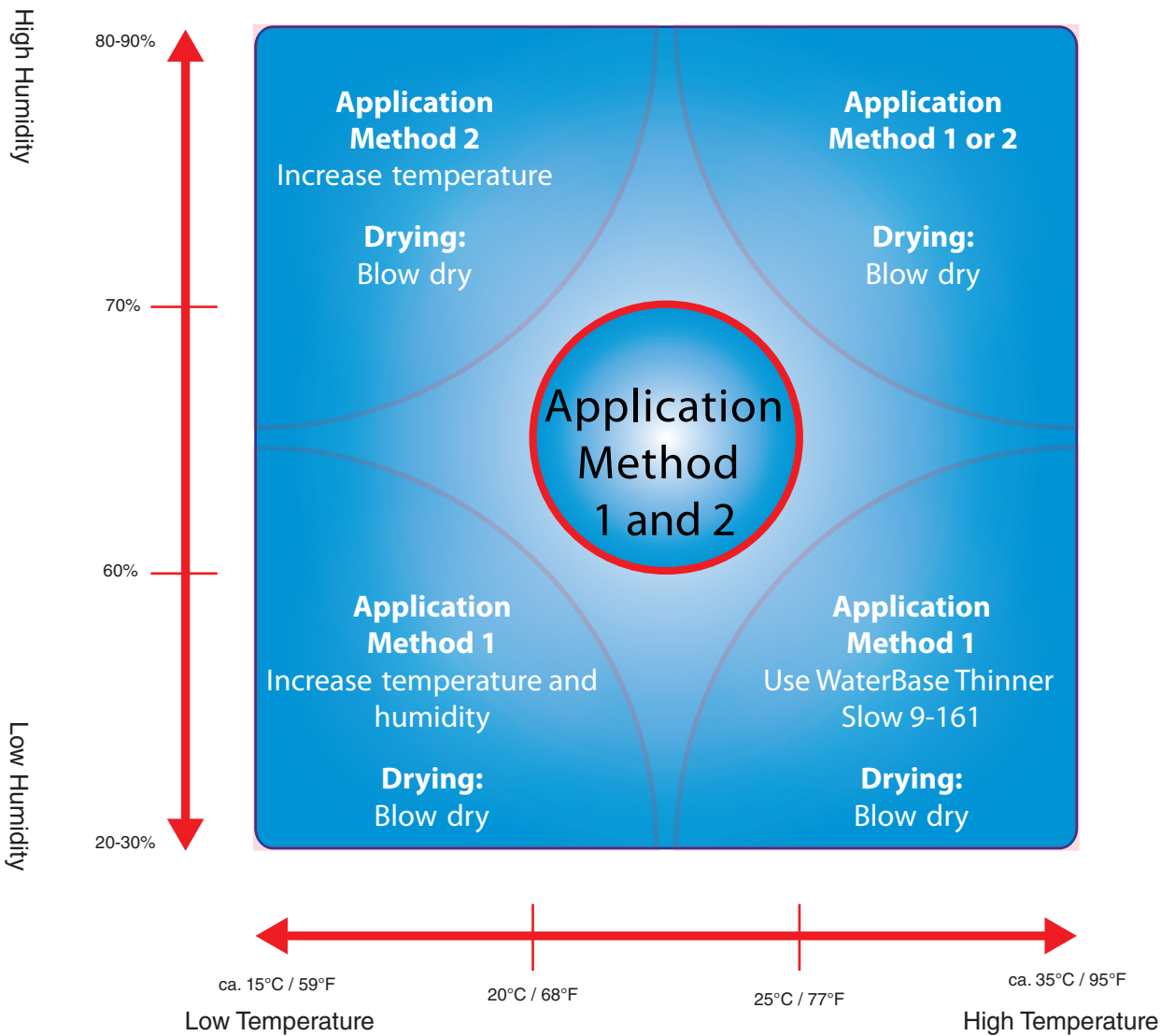
- Area of application** : Waterbased base-coat layer in a clear-over-base system. Suitable for passenger cars, touring cars, trucks etc.
- Chemical base** : Acrylic dispersion.
- General qualities** : Waterbase Serie is a base-coat which has to be finished with a HS Clear Coat.
- Auxiliary materials** : 9-151/ 9-161

Physical properties	Specific gravity (kg/l)	: 0.992 to 1.103
	Flash point	: Closed cup: >61°C (>141.8°F)
	Vol.% solids	: 15-35
	Economy	: 15 m ² /L/20 µm (0.8 mil)
	Gloss	:
	Colour	: Not available.

- Substrates** : See undercoats
- Undercoats** : 8-145, 8-149 (Sanding), 30-746, 1-7510/1-7520, (80-221 only for USA)
- Finishing materials** : 8-104, 8-214, 8-314, 8-414, (80-121 only for USA)
- Cleaning the equipment** : 9-852 WaterBase Gun Cleaner
- Storage life (years)** : min. 1- 2 (>5°C - <25°C) (see appendix)
(Under normal storage conditions and unopened tins).

APPENDIX 1

WATER BASECOAT APPLICATION FOR DIFFERENT HUMIDITY AND TEMPERATURE



Application Method 1:

- One mist coat 2 Bar / 29 psi
- Blow dry *
- Two single wet coats, wet on wet to cover 2 Bar / 29 psi
- Blow dry *
- Drop coat (effect colours only) 1 Bar / 14.5 psi
- Blow dry *

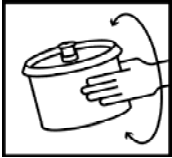
Application Method 2: **

- One mist coat 2 Bar / 29 PSI
- Blow dry *
- First single wet coat 2 Bar / 29 PSI
- Blow dry *
- Second single wet coat 2 Bar / 29 PSI
- Blow dry *
- Drop coat (effect colours only) 1 Bar / 14.5 PSI
- Blow dry *

At temperatures between 20 -25 ° C and a relative humidity between 60-70%, both Application Methods 1 and 2 are recommended.

*** Blow dry until matt at 30-35°C / 85-95°F**

**** Application 2 is preferred for deep black solid colours to achieve the darkest shade.**



Topple packaging before use for 10 sec.
Use the Paint pusher.

Storage life / Shelf life Serie 900 WaterBase MM 900 - 999

Under normal storage conditions, constant temperature and unopened packaging (>5°C-<25°C)=(>41°F-<77°F)

900	
WaterBase	
MM	Storage life (years)
900	2
901	1½
902	1½
903	1½
904	2
905	2
906	2
911	1½
912	2
913	2
913B	2
913C	2
913VC	2
913VF	2
919	2
921	1½
922	1½
924	2
926	2
927	2
928	1½
929	2
930	2
934	2
938	1½
940	2
942	1½
943	1
944	2
946	2
948	2
950	2
951	2
952	2
953	2
954	2
955	2
956	2
957	2
959	2
960	2
961	2
962	2
963	2
964	2
965	2
966	2
967	2
968/ 978	2
969	2
971	2
972	2
973	2
974	2
975	2
976	2
977	1½
979	1½
986	2
987	2
989	2
997	2
998	2
999	2