



# COLOR SOLUTIONS

## AQUA BASECOAT MIX SYSTEM

Technical Data Sheet No 613

A high performance Waterborne Basecoat mix system for motor vehicles

Excellent coverage

VOC compliant with the regulations

### General Technical Description



Reduce with 10-15% AQUA BASECOAT SPRAYING SOLVENT



Shake well before use



Paper filter 125µm



Ready to spray:  
20-28 s / 23°C (73°F)  
Cup 4 - DIN 53211



Final flash off time until matt and touch-free for 15-30 microns total thickness. To minimize the flash off time required use air blower. If total thickness is over 30 microns dry 10 min / 60°C (140°F)

### Surface

On sanded HB Body primed surfaces

On sanded OEM surfaces

### Pretreatment / Cleaning of substrate



Clean substrate using a soft cloth and AQUA BASECOAT DEGREASER

Make sure the surface is first wiped dry and then air dried



Make sure you always use appropriate face protection and good ventilation

**Product Application:** Apply 2 coats on solid shades plus an effect coat on effect shades. Keep flash off times until matt and touch-free between coats. Application thickness must not exceed 15-30 microns. If application thickness is exceeded use force drying.



Shake well before use



Flash off time until matt and touch-free. To minimize the flash off time required use air blower

**Flash Point:**  
n.a.

**Specific Gravity:**  
1.0 - 1.2 g/cm<sup>3</sup> \*

**Solid Content (No thinner):**  
18-34% Weight

**VOC (2001/42/EC)**  
This product is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 420 g/L. The VOC content in the ready for use form of this product is 400 g/L.  
2004/42/IIB(d)(420)400

**Theoretical Coverage:**  
9 - 12 m<sup>2</sup> / l at 30µm dry film thickness

**Cleaning of equipment:**  
Clean after final use with AQUA BASECOAT DEGREASER

### Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with AQUA BASECOAT SPRAYING SOLVENT
- After preparing the area to be painted ensure it is free from dirt, wax, oil etc.
- It can be used by countries that do not adopt the VOC legislation as well.
- Application temperature from +15°C to +35°C (60°F-95°F)

### Storage shelf life:

- Store in a cool place (+5°C - +25°C) (41°F - 77°F) and use within 12 months for best results. Guaranteed shelf life of 18 months in unused original containers.

\*Specific gravity values lie within a range and depend on the color shade



Paper filter 125µm



Final flash off time until matt and touch-free for 15-30 microns total thickness. To minimize the flash off time required use air blower. If total thickness is over 30 microns dry 10 min / 60°C (140°F)



Reduce with 10-15% AQUA BASECOAT SPRAYING SOLVENT



For interior use without clearcoat, mix with 15% AQUA BASECOAT HARDENER



Ready to spray:  
20-28 s / 23°C (73°F)  
Cup 4 - DIN 53211



Always wear protective equipment



HVLP 1.3 mm  
1.7-2 bar (25-30 psi)  
inlet pressure  
0.7 bar (10 psi)  
drop pressure  
Effect coat 1.5 bar (22 psi)  
inlet pressure  
2-2.5 coats= 15-30 µm  
(0.6-0.8 mil)



5 - 25°C (41 - 77°F)



Follow the application instructions mentioned in this TDS

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