

TECHNICAL DATA SHEET

NUMIX 1K BASE COAT

PRODUCT DESCRIPTION

Numix 1K Base Coat is a one-component system based on acrylic resin that consists of 39 solid colors, 12 metallic colors, and 27 pearl colors (including 5 Xirallic), with a total of 78 toners. It can be used as a base coat for any Numix clear coat.

FEATURES

- Easy to prepare any OEM based formulations by using basecoat toners.
- Outstanding color accuracy.
- Excellent hiding/opacity power with low consumption.
- Easy to apply and fast drying.
- Excellent metallic/pearl flakes orientation.
- Excellent weather durability.

SUITABLE SUBSTRATES

Numix 1K Base Coat is suitable to apply over 1K Numix Primer, 2K Numix Primer, old or original paint work, all existing OEM finishes.

SURFACE PREPARATION:

Existing paint systems should be sanded, dry and free from salt and other contaminants. For Dry mechanical sanding, use P320 - P400 (finally use P500 for best results). For wet sanding use P800 - P1000. Remove all traces of sanding dust by blowing oil-free compressed air. Apply Numix Degreaser and wipe dry with a degreasing cloth

TECHNICAL NOTES:

	It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.
	Use Numix Degreaser to remove grease, oil and other contaminants. Use clean quality tack rags or wiping towels, one for wetting and one for drying with wipe on wipe off.
	Stir the Numix 1K Base Coat properly before use.
	For color matching check car manufacturing color code. Refer the Numix Software for color formulation & color box for color variations. Before applying on the car panels or body spray the panel to check the color matches.
	Always use filter paper to avoid the risk of dust particles.
	Clean the gun properly after usage with cleaning thinner.
	The VOC content of this product in ready to use form is 600- 700 g/l of VOC

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APPLICATION DETAILS: (Numix 1K Base Coat)

	Mixing Ratio	Product		Mix By Volume		
		Numix 1K Base Coat		100		
		Thinner (202,204,206)		80 - 100		
		The choice of thinner should be made according to application temperature and size of repair.				
	Pot life at 20°C		N/A			
	Spray viscosity at 20°C		FORD 4		17 - 20s	
	Spray equipment	Type of Gun		Nozzle Size	Distance	Pressure
		Gravity Feed/Suction feed		1.3-1.4 mm	15-20 cm	2-3 bar
		HVLP		1.3-1.4 mm	15-20 cm	1.5 bar
	Number of coats		2 - 3 Coats			
	Flash time		3 - 5 min between coats			
	DFT		15 - 20 microns. depends on no. of coats.			
	Drying time @ 20°C	Till flat between coats and before clear coating. Tack rag-free after final coat dry before clear apply.				
		25 mins.				

REMARKS

- Store the paint in proper storage conditions as per the local regulations.
- Keep the paint container in a sealed condition under a shed, away from direct sunlight and extreme temperatures.
- Do not keep paint material near any ignition sources. Do not put back the half or unused material back in the original container, containing the supplied paint to avoid contamination.
- Handle with care. Stir well before use. 48 months @ 30°C, in original sealed container, with proper storage conditions.

NOTE: We warranty the quality of our product and this data sheet represents test results and practical experience obtained under controlled conditions. We reserve the right to change data without prior notice.