Technical Datasheet

Jul. 2019



TDS 30-1-1

Cardea® Basecoat

Description		Cardea® Basecoats are prepared by using Cardea® MM System tinters. These acrylic basecoats are available in solid colors and special effects (metallic or pearlescent).			
Related Products		Cardea® MM Tinters Cardea® 2K Acrylic Hardener Cardea® Universal Thinners	TDS no: 40-2- TDS no: 50-2-	1 (in 3 coats systems)	
Substrate		Cardea® Primers and Fillers, old acrylic painted surfaces. Note: Do not apply on thermoplastic acrylic surfaces.			
Surface Preparation		Degrease with Cardea® U-Clean 300 by clean cloth.			
		Dry sanding - P400/P500 sand Wet sanding - P800/P1000 sar			
		Clean with Cardea® U-Clean 300 by clean cloth. Wipe the surface with a tack cloth and blow air.			
Mixing		2 Coats Systems	By Volume	By Weight	
MINITE	│	Cardea® Basecoat	100	100	
		Cardea® Universal Thinners	90 - 130	80 – 120	
	Ппп	3 Coats Systems First coat			
		Cardea® Basecoat	100	100	
		Cardea® 2K Acrylic Hardener	20	20	
		Cardea [®] Universal Thinners <u>Second coat</u>	80 - 100	70 - 90	
		Cardea® Basecoat	100	100	
		Cardea [®] Universal Thinners	90 - 130	80 - 120	
Viscosity	s	13 - 16 s / 20°C (DIN 4)			
Pot Life		12 hours (at 20°C)			



The effectiveness of our systems is based on many years' practical experience and laboratory research. We guarantee that the quality of the work performed in accordance with our systems meets the Kansai Altan standards, provided that our instructions are followed carefully and the work is performed in accordance with the requirements as to good craftsmanship. We decline any responsibility, if the final result is affected by factors beyond our control. The customer has to determine the suitability of the delivered products for the intended application by using the means which normally are at his disposal.





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Spray Gun Parameters		Gun Type Suction feed spray gun Gravity feed spray gun HVLP Suction feed spray gun HVLP Gravity feed spray gun	Nozzle size 1,4-1,6 mm 1,3-1,5 mm 1,4-1,6 mm 1,2-1,5 mm	Air pressure 3 - 4 bars 3 - 4 bars 2 - 2,2 bars 2 - 2,2 bars
Application		2 Coats Systems: Solid Colors: Spray 2 - 3 wet coats. Allow 5-10 minutes flash-off between coats. Metallic/Pearl Colors: Spray 2 - 3 wet coats. Allow 5-10 minutes flash-off between coats. If necessary spray last coat by keeping a gun distance slightly longer. 3 Coats Systems: First coat: Spray 2 - 3 wet coats. Allow 5-10 minutes flash-off between coats until full hiding. Second coat: Apply several semi gloss coats from a slightly longer distance. Allow 5-10 minutes flash-off between coats.		
Flash-off Time	<u>/†/†/</u>	Approximately 5 - 10 minutes (at 20 $^{\circ}$ C) until touch dry.		
Dry Film Thickness		15 - 25 μm (depending on color)		
Theoretical Coverage		7 - 15 m²/l at 15 μm (depending on o	color)	
Next Coat	***	Cardea® 2K Acrylic Clearcoats. See T	DS No: 30-2-1, 30-	2-2







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Equipment Cleaning	Use acrylic or cellulosic thinners.		
Package	Cardea® MM Tinters : 0,9 L; 3,5 L Cardea® 2K Acrylic Hardener : 0,5 L; 1 L		
Color	See KANSAI PAINT Global Color Navigator Cardea® Tinting Guide Cardea® Tinting Chart		
Safety	Professional use only. See Material Safety Data Sheet.		



