


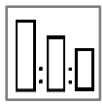

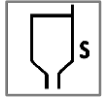




TDS 30-1-1



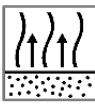

Cardea® Basecoat

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	TDS no: 40-2-1 (in 3 coats systems)
	Cardea® Universal Thinners		TDS no: 50-2-1
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 sanding paper Wet sanding - P800/P1000 sanding paper	
		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
		Cardea® Basecoat	100 100
		Cardea® Universal Thinners	90 - 130 80 – 120
		3 Coats Systems	
		<i>First coat</i>	
		Cardea® Basecoat	100 100
		Cardea® 2K Acrylic Hardener	20 20
		Cardea® Universal Thinners	80 - 100 70 - 90
		<i>Second coat</i>	
		Cardea® Basecoat	100 100
		Cardea® Universal Thinners	90 - 130 80 - 120
Viscosity		13 - 16 s / 20°C (DIN 4)	
Pot Life	12 hours (at 20°C)		



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



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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.