

Technical Data Sheet

Basecoat KO1808H / RRS S07

H= different colours
Not ready for application!

- coloured baking base coat with solvent
- for multi-coat system
- wet on wet application
- suited to motor-car accessories e.g. light metal wheels

| | | |
|-----------------------------------|--|--|
| Technicalb / Physical data | Resin/ binder | acylate - melamin resin |
| | Colour | different colours shades acc. to the automobile industrie other colour shades on request |
| | Gloss visually | semigloss to gloss |
| | Original viscosity DIN 53211 AFNOR | 25 to 35 sec. / 4 mm cup 26 to 40 sec. / 4 mm cup |
| | Thinner | RRS SOLV 4320 |
| | Density calculated | 1,1 g / ml + / - 0,15 |
| | Solid content calculated | 35 % + / - 10 |
| | Solid content in volume Calculated by weight | 250 ml / kg + / - 50 |
| | Spreading rate calculated in original viscosity, without application loss | 50 to 125 g / m ² dry film thickness 15 to 25 µm see „Special remarks“ |
| | Electrical resistance of paint acc. to "Ransburg-methode" acc. to "Sames-methode" | 250 to 800 K-Ohm 15 to 60 M-Ohm x cm |

Storability

Approx. 9 month in original packings at an ambient temperature of 5 to 25 °C, in case the original packings are tightly closed. Opened packing must be used very shortly. The minimum storage stability of each batch is mentioned on the product label. A storage time beyond the mentioned date doesn't necessarily mean that the material is unusable. In this case a check of the qualities which are important for the respective usage is essential due to quality guaranty reasons.

Processing and application**Application**

Components are to be mixed homogeneously (e.g. with high-speed mixer).

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|-------------------------------|---|
| pneumatic-spraying: | after viscosity adjustment to 16 to 18 sec. nozzle: 1,2 mm spraying pressure: 3 to 4 bar |
| low pressure spraying (HVLP): | after viscosity adjustment to 16 to 18 sec. |
| electrostatic-spraying: | e.g. high-rotation process, bell-type equipment after viscosity adjustment to 16 sec. |

Substrates

light metal weels

Pretreatment

The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust and surfactant. According to the requirements we recommend to apply the suited chemical (e.g. phosphatizing, chromating) or / and mechanical (e.g. shot blasting) pretreatment.

Proposal for a coating system

| | |
|---------------|---------------|
| primer: | RRS PRIMER |
| base laquer: | RRS S07 |
| clear laquer: | RRS CLEARCOAT |

Application temperature

above 15 °C

Drying

oven drying: minimum 10 min. / 150 °C (object temperature)

Cleaning of working equipment

Thinner RRS SOLV 4320

Advise for safety protection and protection of health

The usual precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

Special remarks**Test condition**

*Indication of the delivery viscosity according to DIN 53211:
DIN 53211 was withdrawn in October 1996. On request the value is available according to DIN EN ISO 2431.

The statements concerning efficiency and drying depend on colour shade.
The values mentioned in this data sheet are based on RRS S07, blanc aixam.

All information is based on a standard climate 20/65 DIN 50014.

For the calculation of the practical consumption loss additions have to be considered.
Indications to this are the practical experience and advices given in DIN 53220.

All information are based on our product knowledge and experience. To the application we have no direct influence. For further information please do not hesitate to contact us.

The information mentioned herein are reference values and are not given as specification.