

GENERAL INFORMATION

Prospray intermix Basecoat can be mixed using a high - solid, normal - solid, or low - solid level. This level is adjusted on the Prospray Colour Retrieval System. Mixing ratio is 1 : 1 with thinners or, as an option, activate with activators. Following full coverage using mist coat on metallic and effect colours may be required to harmonize metallic and effect particles. NOTE: hand stir all new toners for a minimum of five minutes before inserting mixing lid and placing on machine.

MIXING RATIO



Standard: 1 : 1 Optional: 8 : 1 : M.S. Activator + 100% H.S. Thinner

	HARDENER	SMALL REPAIR	MEDIUM REPAIR	LARGE REPAIR
20°C - 25°C (68°F - 77°F)	ICA 800			✓
	ICA 801		✓	
	ICA 802	✓		
25°C - 30°C (77°F - 86°F)	ICA 800		✓	✓
	ICA 801	✓		
	ICA 802			
>30°C (86°F)	ICA 800	✓	✓	✓
	ICA 801			
	ICA 802			

Use matching thinners. For improved stone chip resistance and maximum adhesion, activate solvent basecoat at the above recommended ratio. Add one part activator to 8 parts basecoat, after mixing add 9 parts thinner.

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,2-1,4	2/29
HE	1,2-1,4	2/29

APPLICATION



1 - 3 coat 20 - 25 µm (0,8-1 mil)

Apply medium coats until full coverage is achieved. Use a mist coat @ 1.5 bar on metallic for effect harmonizing.

FLASH-OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	3 - 5 minutes	Flash off	-
Dust free	10 - 20 minutes	Dust free	-
Dry to handle	-	Dry to handle	-
Dry to tape	-	Dry to tape	-
Dry to sand	-	Dry to sand	-
Dry to polish	-	Dry to polish	-

10 - 20 minutes before clear coat application.

SUBSTRATES



A-500 Extra Build-Easy Sand Primer Grey, A-700 2K H.S. Extra Build / Easy Sand Primer Surfacer - Grey, A-702 2K H.S. Extra Build / Easy Sand Primer Surfacer - White, A-704 2K H.S. Extra Build / Easy Sand Primer Surfacer - Black, EBA-50 Engine Bay Adjuster, EBB-20 Engine Bay Binder, R-6028 Basecoat Blender or properly prepared OEM finishes.

Basecoat should be fully dry.

POT LIFE AT 20°C (68°F)



4 hours

COMPONENTS



ICA-800 M.S. Slow Activator
ICA-801 M.S. Normal Activator
ICA-802 M.S. Express Activator
ICR-1692 2K H.S. Fast Thinner
ICR-1693 2K H.S. Medium Thinner
ICR-1694 2K H.S. Slow Thinner
A-116 Medium Basecoat Thinners
A-118 2K Universal Medium Thinner
A-119 2K Universal Fast Thinner

ADDITIVES



R-6028 Basecoat Blender

For easy basecoat blending use R-6028 Basecoat Blender, this product is ready for use.

SURFACE PREPARATION



Finish sand with P500 - P800. Clean area with W820 Antistatic Degreaser wipe on and wipe dry thoroughly.

Mask entire vehicle to eliminate unwanted overspray.



NEXT LAYER



All compatible clear coats

PHYSICAL DATA



PHYSICAL DATA		
Chemical Base	Acrylic	
Physical Properties	Viscosity (RTS)	14 - 15 Dincup 4 / 20°C
	Specific Gravity (kg/l)	0,922
	Flash Point Closed Cup	25°C / 77°F
	Volume % Solids	20
	Economy	10m³/L/20 µm 405 ft³/qt/0,8 mil
	Gloss	-
	Colour	-

PROTECTION



Use suitable respiratory protection (**we recommend the use of a fresh air supply respirator**).

For more detailed information please visit the following link for the **Safety Data Sheet**:

sds.prospray.eu

CLEANUP



Clean equipment after use with a cleaning solvent.

Dispose of solvent according to local regulations.

STORAGE / SHELF LIFE



Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES



Specific information for use in Europe (EU): This product (ready for use) is not VOC compliant. Please refer to VOC declaration (2004/42/EC).