

## 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	10m <sup>3</sup> /L/20 µm
		405 ft <sup>3</sup> /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](https://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).**

## GENERAL INFORMATION

Prospray intermix Single Stage is a high gloss and durable topcoat system. Colours utilize the current intermix toner system to provide a large range of solid and metallic colours that can be mixed in normal, medium and high level solid options (see Prospray Colour Retrieval System for the solids levels). Thousands of colour formulas are available on the Prospray Colour Retrieval System.

## MIXING RATIO



Normal coverage: 2 : 1 Activator + 15 - 25% Thinner

	HARDENER	SMALL REPAIR	MEDIUM REPAIR	LARGE REPAIR
20°C - 25°C (68°F - 77°F)	ICA 660		√	√
	ICA 690	√	√	
25°C - 30°C (77°F - 86°F)	ICA 660	√	√	√
	ICA 690	√		
>30°C (86°F)	ICA 660	√	√	√
	ICA 690			

High coverage: 3 : 1 Activator + 25% Thinner

	HARDENER	SMALL REPAIR	MEDIUM REPAIR	LARGE REPAIR
20°C - 25°C (68°F - 77°F)	ICA 800			√
	ICA 802		√	
	ICA 803	√	√	
25°C - 30°C (77°F - 86°F)	ICA 800		√	√
	ICA 802	√	√	
	ICA 803	√		
>30°C (86°F)	ICA 800	√	√	√
	ICA 802	√		
	ICA 803			

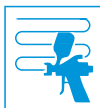
Depending on the required quality two mixing ratio's are available. Use matching thinners.

## GUN SETUP



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

## APPLICATION



Normal coverage: 2 - 3 coat 30 - 40µm (1,2-1,8 mil)  
High coverage: 2 - 3 coat 40 - 60µm (1,8-2,4 mil)

**Apply medium wet coats. Allow 5 - 10 minutes flash off between coats. Single layer metallics may require a mist coat in the wet layer for metallic orientation.**

## FLASH-OFF AND DRY TIMES



	AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	5 - 10 minutes	Flash off	5 - 10 minutes	
Dust free	-	Dust free	-	
Dry to handle	6 - 16 hours	Dry to handle	20 minutes	
Dry to tape	6 - 16 hours	Dry to tape	20 minutes	
Dry to sand	6 - 16 hours	Dry to sand	20 minutes	
Dry to polish	6 - 16 hours	Dry to polish	20 minutes	



## COMPONENTS



ICA-660 Normal Activator  
ICA-690 Express Activator  
ICA-803 M.S. Rapid Activator  
ICA-802 M.S. Express Activator  
ICA-800 M.S. Slow Activator  
A-118 2K Universal Medium Thinner  
A-119 2K Universal Fast Thinner  
ICR-1692 2K H.S. Fast Thinner  
ICR-1693 2K H.S. Medium Thinner  
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**Using slow activator and slow thinner is recommended for best appearance.**

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**Prospray intermix Single Stage can be applied over properly prepared and primed plastic. If the plastic is flexible, the primer must be mixed with P-2020 Plasticising Additive at a ratio of 5 parts primer to 1 part P-2020 Plasticising Additive, then activated and thinned according TDS.**

## POT LIFE AT 20°C (68°F)



120 minutes

## ADDITIVES



P-2020 Plasticising Additive  
**Add before activator.**

## SURFACE PREPARATION



Finish sanding with P400 - P600 remove sanding debris with sanding vacuum. Clean area with W820 Antistatic Degreaser wipe on and wipe dry thoroughly.

**Mask entire vehicle to eliminate unwanted overspray.**



## NEXT LAYER



## PHYSICAL DATA



PHYSICAL DATA		
<b>Chemical Base</b>	Acrylic	
<b>Physical Properties</b>	<b>Viscosity (RTS)</b>	15 - 17 Dincup 4 / 20°C
	<b>Specific Gravity (kg/l)</b>	0,937
	<b>Flash Point Closed Cup</b>	25°C / 77°F
	<b>Volume % Solids</b>	20
	<b>Economy</b>	10m <sup>2</sup> /L/20 µm
		405 ft <sup>2</sup> /qt/0,8 mil
	<b>Gloss</b>	High Gloss
	<b>Colour</b>	-

## PROTECTION



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