

Basecoat SB MM 120

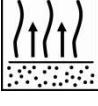
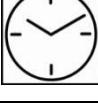
Basecoat

24/10/2019

L5.01.04 AUS

DESCRIPTION

Basecoat SM MM 120 is a one component, mixing machine based, basecoat system. Available in a wide variety of colors including metallics, pearls and solids. Based on the latest refinish technology and providing easy application and an excellent color match. Designed for the refinishing of passenger cars, but also suitable for refinishing of light commercial vehicles. Full range of ancillary products that enable the product to be used successfully on a wide variety of jobs, in most types of application.

Mixing ratio		2 Basecoat SB 120	
		1 Multi Thinner 810 (any)	
Equipment		Spray gun set-up: 1.3-1.5 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap
Application		2 x 1 coat Apply two coats, allow to become touch dry between each coat.	
Flash-off		Between coats 2-5 minutes at 20°C	Before clearcoat 15-20 minutes at 20°C
Drying times			20°C 15-20 minutes, max 6 hours
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator	
Read complete TDS for detailed product information			

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PRODCTU AND ADDITIVES

Product	Lesonal Basecoat SB 120	Mixed to formula (by weight) using Lesonal Basecoat SB 120 MM toners
	Thinner Lesonal Multi Thinner 810-C	Lesonal Multi Thinner Standard Fast 810-B Lesonal Multi Thinner HT 810-CC
Basic raw materials	Basecoat SB 120; Physical drying binders Multi Thinner 810 (any); A blend of organic solvents	

METHOD OF USE

Suitable substrates	Original finishes, with the exception of thermoplastic acrylic. Polyester laminates 1K Multi Plastic Primer 2K Primer 488 EP Primer 440
Substrate preparation	Prior to any sanding work, thoroughly clean the surface of any grease or wax with AkzoNobel Wax and Grease Remover. Apply using two clean cloths in a wipe on, wipe off process. Sand with P1000 wet or P400-P500 dry. After sanding work is completed, and just prior to the application of Basecoat SB 120, degrease again thoroughly with AkzoNobel Wax and Grease Remover.

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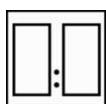
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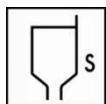
Mixing 2 Basecoat SB 120

1 Multi Thinner 810 (any)

Mix in a parallel-sided container and stir well before use.



Viscosity 14-16 sec DIN cup 4 at 20°C.



Spray gun set-up / application pressure

Spray gun Gravity feed

Fluid tip-set-up 1.3-1.5 mm

Application pressure
1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

APPLICATION TECHNIQUE



Solid colors

Apply 2-3 single coats or until opacity is achieved.

Allow for a 2-5 minutes flash-off time at 20°C between coats or until the basecoat is completely matt.

Allow for a flash off time of 15-20 minutes before clear coat

Metallic colors

Apply 2 single coats* or until opacity is achieved.

*Allow for a 2-5 minutes flash-off time at 20°C between coats or until the basecoat is completely matt.

When needed, apply a drop coat by reducing the pressure with a ½ bar at the gun inlet.
Apply the drop coat with full trigger, increase the distance to approximately 30- 40cm.

Allow for a flash off time of 15-20 minutes

Spot repairs:

When making spot repairs use lower application pressure and apply thin coats* until reaching opacity.

*Allow for a 2-5 minutes flash-off time at 20°C between coats.

Next, fade out, by extending beyond the edges, using similar application pressure.

In case of metallic colors, apply a drop coat when needed by increasing the spray gun distance.

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Allow for a flash off time of 15-20 minutes

Pot-life	After mixing the product must be used within 24 hrs at 20°C. After extended or long storage paint requires thorough stirring and mixing before use. Solid and Metallic: 6 months at 20°C. Pearl (3-stage) 24 hours at 20°C.
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Theoretical coverage	By using the recommended application, the theoretical material usage is ± 12-14m ² per liter for one single coat. The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.
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Cleaning of equipment	Use Lesonal Multi Thinner 810 (any).
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Helpful tips	After 20 minutes at 20°C Lesonal Basecoat SB may be masked upon and a second color can be applied.
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If Lesonal Basecoat SB Metallic is to be left longer than 24 hours (5 hours for solid) before applying a Lesonal clearcoat, 10% of Lesonal Hardener 728 should be added into the basecoat before mixing with thinner. Do not use 728 B in Basecoat SB MM 120.

If there is a risk of cratering due to the presence of contamination, it is advisable to apply the basecoat in thin layers only, and to extend the normal flash off time between each coat.

New cans of toners should be placed 20 minutes on the mixing machine or 10 minutes in the paint shaker before use.

NOTE: As an option when fading out or applying in cold/poor airflow environments, an additional 10% of Lesonal Multi Thinner 810 maybe added in to Lesonal Basecoat SB 120. This will make the application easier and faster flash off time.

Denibbing	Dust particles can be denibbed with P1000 grit wet paper after 20 minutes at 20°C. Then proceed with the application of Lesonal Basecoat SB 120.
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Recoatable with	Lesonal 288 HS Clearcoat Lesonal 261 Clearcoat Lesonal 1021 HG Clearcoat
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Product storage	Product shelf-life is determined when products are stored unopened at 20°C. Avoid extreme temperature fluctuation. Product shelf life data see TDS S9.02.01
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