

55 Line

Basecoat Metallic / Solid - with hardener



A brand of BASF –
We create chemistry

Application:





Basecoat/Clearcoat (BC/CC). Wet-on-wet process with clear 923-

Remarks:

- Be sure to observe flash-off times between spray coats.
- Clearcoat as soon as possible (after proper flash-off) to minimize dirt or other substances landing on the basecoat.
- New tinting bases must be shaken for 15 minutes on a mechanical paint shaker before placing on a mixing machine. To ensure good color match, agitate tinting bases on a mixing machine for 15 minutes at the beginning of the day, and every 4 hours during the work day.
- When completing a repair, it may not be possible to obtain an exact panel-to-panel color match. Where color variations are expected, or where there is no natural break (such as a seam or trim strip), it is more practical to blend the color into the areas surrounding the repair. Blending in can be more economical and efficient than time-consuming color tinting.

VOC ready for use	865 g/l	7.2 lb/gal
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10:1:4

	Mixing Ratio	100 parts by volume	55 Line
	Hardener	10 parts by volume	355-55
	Reducer	40 parts by volume	352-50, -91, -216
	Spray viscosity at 68°F / 20°C	DIN 4:	17-22 s
	Potlife at 68°F / 20°C	24 h	

Safety advice:


Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous and should be used according to label directions and technical data information. Appropriate respiratory protection should be worn at all times while products are in use - read product label and Safety Data Sheet (SDS) for specific details. Statements and methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only and are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.

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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
Nozzle pressure		10 psi
Nozzle size		1.2-1.4 mm
Number of spraycoats	2 (to hiding) plus 1/2 to match effect	
Flash-off at 68°F / 20°C	5 - 10 mins. between coats 10 mins. or until matte before next step	
Film thickness	0.6-0.8 mil (1.5 mils max.)	

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document

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