

Product Information

Water thinnable two coat basecoat for the complete finishing of alloy wheel Manufacturing, repairs or refurbishing. Overcoating with Wheelpaints clearcoat wet and powdercoat systems is recommended to give a weather resistant surface of brilliant appearance.

All colours are lead and chromate free.

Consumption: 7 - 9 m² / liter (by approx. 20 µm dry film thickness).

Colour availability	Colour System		
Mixing ratio	10 - 20 % WHEELPAINTS WBC-Thinner		
Thinner	WBC-Thinner		
Spraying viscosity 20° C	20 - 25 s 4 mm DIN		
Application	Spraying pressure	Spraying nozzle	Spraying operations
HVLP	2 - 2.5 bar	1.3 - 1.4 mm	2.5
Coat thickness / dry film	15 - 20 µm		
Curing time /Flash off time	5 - 8 min. between the spraying operations		
Dry	Recoatable with WHEELPAINTS Clearcoat Systems		
Object temp. 20° C:	20 min. (surface has to be completely satin gloss dried)		
Object temp. 60 °C	7 min. + allow 5 min cooling time		
with IR-drying (short wave)	2 min. + allow 5 min. cooling time		
with blower:	7 min.		
VOC content	EU limiting value for the product (cat. B/d): 420 g/l (2007) This product contains max. 420 g/l VOC [3.5 lbs/gal]		

Processing conditions:

From +10°C and up to 75% relative air humidity. Insure suitable ventilation.

Special recommendations :

Fast drying by higher air speed and lower relative air humidity conditions. By using a blower, the drying time will be accelerated with approx. 50 %. Storage protected against frost. Put on the pouring device only by necessity. Shake thoroughly for about 20 - 30 s before use.

Optimal processing conditions:

Air temperature: 20 - 25 °C; object temperature > 15 °C; rel. air humidity: 40 - 60 %, air speed: > 0.4 m/s

Process recommendations:

Apply the first coat as a thin film, not too wet, allow to flash off and apply a second heavy coat which will obtained a complete covering in most situations. To ensure a perfect distribution of the aluminium pigments across the surface, a third drop coat is necessary (spraying mist technique). Spray as a mist the basecoat from a longer distance by using a reduced spraying pressure. To get the best results it is advisable to follow the above technique.

Clearcoats:

Wheelpaints WBC. Basecoat can be recoated with all Wheelpaints Clearcoat Systems for VOC-limit values, use Wheelpaints Premium Lak 2K HS clearcoat .