






# Metacryl FB – 3.5 VOC Basecoat




FB – 3.5 VOC Basecoat  
7360, 7361, 7362 or 7363 Hardener  
COMPONENTS 7370, 7371, 7372 or 7373 Reducer




APPLICATION  
2 medium wet coats  
Cross-coated with no flash or  
5-10 minute flash time  
between coats




MIX RATIO  
3 : 1 : 2 – 5%



DRY TIME  
Hand Slick: 10 Minutes  
Dust Free: 20 Minutes  
Dry to Clearcoat: 30 Minutes  
Dry to Handle: Overnight



VISCOSITY  
ZAHN #3  
10 – 18 Seconds



VOC  
3.5 lbs/gal  
419 g/L



## GENERAL

### DESCRIPTION

Metacryl FB 3.5 VOC Basecoat is a polyurethane basecoat that when used with Metacryl clearcoats provides maximum durability, gloss, and chemical resistance. Metacryl FB offers a single cross-coat application to achieve hiding and proper coverage. Metacryl FB offers numerous color matches in solid, metallic and effect colors to meet all of your fleet and manufacturing needs.

### COMPATIBLE SUBSTRATES

- All Metacryl 2K Primers and Sealers
- Properly prepared OEM or aged finishes

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



## MIXING

### COMPONENTS

Mix 3 parts FB 3.5 VOC Basecoat to 1 part 7360, 7361, 7362 or 7363 Hardener to 2 – 5% 7370, 7371, 7372 or 7373\* Reducer.

\*May be added to aid application.

Component	Volume
Metacryl FB 3.5 VOC Basecoat	3
Metacryl 7360, 7361, 7362 or 7363 Hardener	1
Metacryl 7370, 7371, 7372 or 7373 Reducer	2 – 5%



**HARDENER SELECTION**

- 7360 Fast 65 – 75°F/18 – 24°C
- 7361 Medium 75 – 85°F/24 – 29°C
- 7362 Slow 85 – 95°F/29 – 35°C
- 7363 Extra Slow 85°F+/29°C

**SPECIALTY COMPONENTS**

7377 Accelerator: 1 – 3%  
 7376 Fisheye Eliminator: Max 2%

**POT LIFE**

2 Hours at 77°F/24°C / 50% R.H.



**APPLICATION**

**APPLICATION EQUIPMENT**

HVLP Gravity	1.3 – 1.5 mm	6 – 10 PSI	*At the cap
High Efficiency	1.3 – 1.5 mm	30 PSI	At gauge
Pressure Pot	1.0 – 1.1 mm	6 - 10 PSI	*At the pot

NOTE: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

**APPLICATION**

Spray 2 medium wet coats, can be cross-coated with no flash, or allow 5 – 10 minutes flash time between coats. Metallic colors may require a mist or drop coat to even the appearance and reduce mottling.

**CLEAN-UP**

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner. Dispose of all paint and paint related materials in accordance with state and local regulations.

**DRY TIMES**



**AIR DRY  
 @ 75°F/23°C**

Hand Slick	10 Minutes
Dust Free	20 Minutes
Tape Free	2 – 4 Hours
To Clearcoat	30 Minutes
To Handle	Overnight
Flash Before Force Dry	None
Force Dry Time	30 Minutes at 140°F/60°C
To Sand/Buf	After Cool Down (1 – 2 Hours)



**PHYSICAL PROPERTIES**

RTS VOC	3.5 lbs/gallon
RTS Volume Solids	50.0 – 55.0% (Average)
ZAHN #3 Viscosity	10 – 18 Seconds
DFT per Coat	Approximately 1.0 mil
Theoretical Coverage	Approx. 800 SqFt at 1 Mil DFT/mixed gallon
Solvent Resistance	MEK pass 100 rubs Xylene pass 1000 rubs
Chemical Resistance	Acid (HCl) – No effect, 6hr Base (NaOH) – No effect, 6hr Skydrol – No effect, 6hr
Flexibility	Pass Conical Mandrel



Direct Impact	100 in/lbs
Reverse Impact	80 in/lbs
Product Class	Basecoat

### STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).

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### VOC REGULATED AREAS

VOC as Applied 419 grams/liter | 3.5 lbs/gallon

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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### SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States and Canada:  
**1.855.6.AXALTA**  
**metacryl.us**

