




Metalux™ Basecoat




COMPONENTS
Metalux Basecoat Color Reducers 1156, 1157, 1158



APPLICATION
2 - 3 coats
4 - 8 minute flash between coats




MIX RATIO
2 : 1



DRY TIME
15 - 20 Minutes



VISCOSITY
Ford #4
16 seconds



VOC
779 grams / liter
6.5 lbs / gallon



GENERAL

DESCRIPTION

A 6.5 lbs/gal | 779 grams/liter VOC basecoat system designed for use on cars, commercial vehicles and equipment; as well as for repairs to existing OEM two and three stage systems and design work. The basecoat has been formulated with a high quality range of light fast pigments to meet the OEM color standards. Good coverage and ease of application provide the refinisher with a quality product.

NOT RECOMMENDED FOR

Use over 1K substrates

COMPATIBLE COATINGS

Compatible with Metalux primer, sealer, and clearcoat products

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



MIXING

COMPONENTS

Mix 2 parts Metalux Basecoat Color to 1 part Metalux Universal Reducer. Thin to spray viscosity of 16 secs with #4 Ford @ 77°F/25°C for spraying.

Option for longer re-coating: Add 5% MS hardener to premixed basecoat

Component	Volume
Metalux Basecoat Color	2
Metalux Universal Reducers (1156 Fast, 1157 Medium, 1158 Slow)	1



Package Sizes

- 1 Gallon (3.75 Liters)
- 1 Liter (1 Liter)
- 0.5 Liter (0.5 Liters)

INITIAL APPLICATION VISCOSITY

Ford #4 Viscosity 16 seconds



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 -1.4 mm	1.0 - 1.5 (Bar)	6-8 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	1.0 - 1.5 (Bar)	17-19 PSI	At gauge

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

APPLICATION

Apply 2 to 3 single coats with 4 - 8 minute flash off between coats. An additional coat may be required with colors difficult to cover. Not recommended over 1K substrates.

Option for metallics and blending basecoat: After the final coat of color, adjust the air pressure and apply a final medium-wet drop coat. (**Do not** dry spray color.) Flash off for 15 - 20 minutes before applying clear.

NOTE: Underhood and jambs.

METHOD 1: As an underhood color, the basecoat can be sprayed by adding 5% MS hardener to the mix without the need of clear coating. This matches many of the OEM hood colors.

METHOD 2: Integrate 20 - 50% hardened clear Metalux 9700 Clearcoat or Metalux 9701 Clearcoat into your already properly thinned basecoat. This provides more durability than Method 1M and is ideal when spraying jambs.

****IMPORTANT TECHNICAL NOTES:** To prevent white peeling when un-tapping, the best practice recommendation is when two-toning with white; slightly over-reduce, using a slower solvent AND 5% Metalux 9091 Fast hardener. Allow a 10 minute flash between coats, then a 20 minute minimum wait to unmask two-toned color and clear. When pulling the tape away AFTER the 20 minute minimum wait, pull the tape at a 45° angle using extreme care. Always spray white over P400-P500 grit sandpaper scratch. Do **not** apply Metalux White basecoat over adhesion promoter, as peeling does occur when using either on all panels that have been tested.

RECOAT

Must be recoated with clear after 15 minutes and before 12 hours or 24 hours when MS Hardener is added to the basecoat. Allow basecoat to properly flash before applying clearcoat. Cooler temperatures may require longer flash times.



DRY TIMES

AIR DRY

75°F (23°C) & 50% RH at recommended film thickness

Hand Slick	5 Minutes
Dust Free	5 Minutes
Tape Free	20 Minutes
To Clearcoat	15 - 20 Minutes
Dry to Handle	Overnight (after clear)
Flash Before Force Dry	N/A
To Sand/Buf	N/A



PHYSICAL PROPERTIES

Recommended Film Thickness	± 10 Micron / .mils
Mixed Volume Solids	11-13% (Average)
Theoretical Coverage	200.432 Sq. Ft. @ 1 Mil DFT/mixed gallon
Recommended Coats	2-3 (x1)
DFT per Coat	Approximately 0.5 mil

MAXIMUM SERVICE TEMPERATURE

200°F (93°C)

STORAGE CONDITIONS

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

VOC REGULATED AREAS

VOC as Applied 779 grams/liter | 6.5 lbs/gallon (RFU)

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.

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 MSDS/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:

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