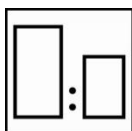


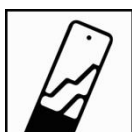
## Description

One component, mixing machine water based basecoat system. Available in a wide variety of colours including metallic, pearls and solids. Specifically designed for the refinishing of passenger cars, but also suitable for refinishing of light commercial vehicles. Full range of ancillary products enables the product to be used successfully on a wide variety of jobs, in most types of application.



### Ready For Use (RFU)

For optimum straining use waterborne suitable paint strainers, size: 125µm



Activator WB can be added up to a maximum of 20%.

Mixed colours must be stirred thoroughly directly after mixing, prior adding Activator WB



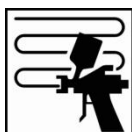
Spray gun set-up:

1.2-1.4 mm

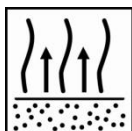
Application pressure:

2 – 2.5 bar\*

\*Advise user manual spraygun used



2 x 1 coat



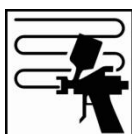
Between coats

Dry until mat after each coat

Before clear coat

15 minutes at 25°C

20 minutes at 20°C



-2K HS Extra Clear RTS

-2K HS Premium Clear 420

-2K HS Fast Clear 420



Use suitable respiratory protection

Read complete TDS for detailed product information

# Basecoat WB

**LESONAL**

Technical Data Sheet

24 / 05 / 2012

L1.09.01

Basecoats

**Description**

One component, mixing machine based, basecoat system. Available in a wide variety of colours including metallic, pearls and solids. Specifically designed for the refinishing of passenger cars, but also suitable for refinishing of light commercial vehicles. Full range of ancillary products enables the product to be used successfully on a wide variety of jobs, in most types of application.

**Product & ancillary items****Product**

Lesonal Basecoat WB.  
Mixed to formulae (by weight) using Lesonal Basecoat WB Tinters.

**Thinners**

Basecoat WB is ready for use

To avoid overspray with painting larger objects or in warmer conditions, Activator WB can be added up to a maximum of 20%.

Mixed colours must be stirred thoroughly directly after mixing, prior adding Activator WB

Note: Avoid contact with organic solvents

**Chemical Basis**

Basecoat WB - Physical drying binders

**Method of use****Substrates**

Sound original finishes, including thermoplastic acrylic  
Polyester laminates

Lesonal 2K Universal Plastic Primer

Lesonal 1K Multi Plastic Primer

Lesonal 1K Multi Plastic Primer (RTS) Aerosol

Lesonal 1K Primer Filler RTS

Lesonal 2K HS Primer Filler

Lesonal 2K Filler 540 (RTS)

Lesonal 2K High Build Filler

Lesonal 1K Plastic Primer( RTS)

Lesonal 2K Epoxy Primer

Note:

Do not apply directly over etch primers

**Substrate preparation**

Prior to commencing any sanding work, thoroughly clean the surface with Lesonal Degreaser. Sand with P1000 wet or P500 dry. After sanding work is completed, and just prior to the application of Basecoat WB, again degrease thoroughly with Lesonal Degreaser.

**Mixing Ratio**

Basecoat WB is Ready for use

<b>Spraying Viscosity</b>		25-35 sec. DIN Cup 4 at 20°C	
<b>Potlife</b> (without Ready mixed additive)	Solid and pearl colors	3 months at 20°C	
	Metallic colors which do not contain tinter 03	1 week at 20°C	
	Metallic colors which do contain tinter 03	1 day at 20°C	
<b>Spraying Pressure</b>		Fluid opening	Spraying Pressure
	Spraygun		
	HVLP Gravity Feed	1.2-1.4 mm	0.7 bar (at air cap)*
	LVLP (HR) Gravity Feed	1.2-1.4 mm	2-2.5 bar (at air inlet)*
	Conventional Gravity Feed	1.2-1.4 mm	2-2.5 bar (at air inlet)*
<i>*Please refer to spraygun manual used</i>			
<b>Application Technique</b>			
<b>Metallic and pearl colors</b>	Apply one single coat (100%). Allow flash off until the coat is completely dried (mat).  Apply a following lighter coat (80%) repeat till covering is achieved. If covering is achieved, finish with a mist coat (20%) layer by reducing the working pressure by 0,5 to 1 bar at the air inlet and increase the distance between spraygun and object.		
<b>Solid colors</b>	Apply one full single coat (100%). Allow flash off until the coat is completely dried (mat).  Apply another single coat (100%) and again allow this coat to flash off until mat, repeat until covering is achieved, a mist coat is not needed with solid colors.		
<b>Spot repairs / Fade out areas</b>	<b>Application</b>		
	Apply the basecoat in thin (overlapping) coats with the spraygun fully triggered at a spraying pressure of 1.5 – 2 bar until opacity is achieved. Allow to flash off until matt between coats, than fade out twice into remaining area (only metallic colours), again using a spraying pressure of 1.5 – 2 bar.  <i>Working time can be reduced by acceleration of the air speed, by using dry-jets.</i>		
	<u>Note-</u> While making a spot repair, it's not necessary to tag-rag between coats. -If a pure Basecoat WB metallic mixing color will be applied, always add Basecoat WB tinter 02 in the mixing ratio 1:4 -Clean spraygun with Lesonal Gun cleaner WB directly after use		
<b>Tips for making a spot repair</b>	-Apply a full coat of pure 02 as a first coat for a better orientation of the metallic -With metallic 50% of pure 02 can be added to the final (drop)coat -Do not apply to heavy coats while making a spot repair		

<b>Drying methods</b>	<p>Speeding up flash off times can be achieved by:</p> <ul style="list-style-type: none"><li>-acceleration of the air speed by dry-jets</li><li>-Wind-jets</li><li>-(Build in) spray booth systems</li><li>-Heating up the air <i>(please ask your distributor)</i></li></ul> <p><b>Note:</b> Lesonal toner Basecoat WB 25 can be applied as a pure color in 2 single layers with a flash-off between coats, or by 2 light wet coats (wet-on-wet)</p> <p>If using air accelerating equipment, like wind jets or venturi's, keep a minimum distance of 1 meter.</p>
<b>Film thickness</b>	10-25 micron
<b>Theoretical usage per ltr/m<sup>2</sup></b>	167 m <sup>2</sup> at a layer thickness of 1 micron (the practical material usage depends on many factors, i.e. shape of the object, roughness of the surface, application method and application circumstances)
<b>Equipment cleaning</b>	Use Lesonal Gun cleaner WB.
<b>Recoatibility</b>	20 minutes 20°C (or 15 min 25°C) after becoming mat of the final coat, Basecoat WB can be recoated with the following clearcoats: Lesonal 2K HS Fast Clear 420 Lesonal 2K HS Premium Clear 420 Lesonal 2K HS Extra Clear (RTS)
<b>Helpful Tips:</b>	<ul style="list-style-type: none"><li>• The basecoat may be masked upon and a second colour applied after 20 minutes at 20°C.</li><li>• For optimum straining use waterborne suitable paint strainers, size 125µm</li><li>• 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 times between each coat.</li><li>• Metallic tinters should always be placed in the paint shaker or thoroughly stirred</li></ul>
<b>Shelf life</b>	See TDS L9.01.02
<b>VOC</b>	<b>2004/42/IIB(d)(420)407</b> The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/litre VOC. The VOC content of this product in ready to use form is max. 407 g/litre.

## Basecoat WB ancillaries

### Ready Mixed Additive

Additive to extend the pot life of Basecoat WB color formulas to a maximum of 3 months. (by adding 5%)

Do not add Ready Mixed Additive in Pearl and Solid color formulas

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#### **PROFESSIONAL USE ONLY**

**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in

# Basecoat WB

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**LESONAL**

Basecoats

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