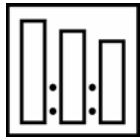


Polybase Plus Basecoat (Low VOC)

FOR PROFESSIONAL USE ONLY

Description

Polybase Plus is a catalyzed basecoat made from polyester and acrylic resins for use in Automotive and Truck refinishing. Polybase Plus can be used on repairs without swelling, lifting or wrinkling. The Basecoat cross-linking provides extremely strong intra-coat adhesion, flexibility and toughness. By utilizing HS 21 Clear Polybase Plus meets 3.5 lbs/gal BC/CC averaging.



4	Polybase Plus
1	A-Base Activator
1	R200 Reducer



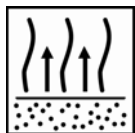
Use U-Tech measuring stick
109



<p>Spray gun set-up: 1.3-1.5 mm HVLP max. 10 psi at air cap</p>	<p>Application pressure: 40-50 psi (3-4 bar) o Check gun manufacturer specification</p>
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Spray one single coat followed by a cross-coat



Between coats
7-12 minutes at 70°F (20°C)



Dry Times	70°F (20°C)	140°F (60°C)
Dry to recoat	20-30 Minutes	N.A.
Maximum recoat window 72 hours		



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

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Product and additives

Product	Polybase Plus Metallic and Pearl color Polybase Plus solid color
Hardener	A-Base Activator
Reducers	R200 Fast: for spot and panel repairs, 60°F–75°F (16°C C –24°). R200 Medium: for panel repairs and large areas, 70°F–85°F (20°C–30°C). R200 Slow: for larger areas and complete paint jobs, 80°F–95°F (27°C–35°C). R200 Extra Slow: for extremely hot temperatures. This may be mixed with R200 Slow. above 100°F (38°C)
Additives	-

Basic raw materials

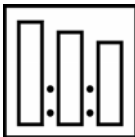
Polybase Plus: Physically drying resins
Activator/Hardener: polyisocyanate

Suitable substrates

NOTE

- OEM 2-step solid and metallic systems and over existing finishes; degreased and sanded with #P500 to #P600 grit paper dry or #P600 to #P800 grit wet
over thermoplastic acrylic lacquers, the entire panel of lacquer must be sealed with a compliant U-Tech undercoat system.
- Any U-Tech preparatory product that is compliant for local regulations

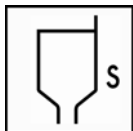
Mixing Ratio



4 parts by volume of Polybase Plus
1 parts by volume of A-Base Activator
1 R200 Reducer

For easy and accurate mixing, use U-Tech measuring stick No. 109

Viscosity



21-28 seconds Zahn cup #2 (15-18 seconds DIN#4) at 70°F (20°C).

Polybase Plus Basecoat (Low VOC)

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Spray gun set-up / application pressure



Spray gun	Fluid tip – set-up	Application pressure	Fluid Pressure
Pressure Feed	1.0–1.2 mm	40–50 psi	8–10 psi
HVLP Siphon	1.8–2.2 mm	max. 10 psi	
HVLP Gravity	1.3–1.5 mm	max. 10 psi	

Application process



Spray one single coat followed by a cross coat or until hiding

For Solid Colors:

Primed areas where extra coverage is required, first apply a single thin coat over repaired area

For Metallic and Pearl Colors:

If it is necessary to even out the metallic pattern spray an additional lighter orientation coat (Drop Coat).

3 Step Metallics: (using tinted clear)

Polybase Plus Metallic (foundation color): Spray 1 -2 single coats (until covered), allowing 7-12 minutes flash-off between coats. If it is necessary to even out the metallic pattern spray an additional lighter orientation coat. (Drop Coat)

Look up the formula for the **Tint Stage 2** (mid coat) in the Utech Color retrieval program – mix this formula in HS 21 Clear. Mix with the activator for the clear at the recommended ratio and spray this transparent clear mixture. It is suggested to do a let down panel to identify exactly how many coats of this tinted clear is necessary to achieve a match.

NOTE: If polishing is planned, a final coat of un-tinted clear is recommended

3 Step Pearls:

Polybase Plus (foundation color): Spray 2–3 single coats (until covered), allowing 5-7 minutes flash-off between coats.

Look up the formula for the **Tint Stage 2** (mid coat) in the U–Tech Color retrieval program – mix this formula and spray 4:1:1. Spray this pearl color with R200 Slow Reducer, applying two to three even light coats. It is suggested to do a let down panel to identify exactly how many coats of pearl is necessary to achieve a match.

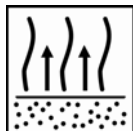
Pot-life

24 hours at 70°F (20°C)

Film thickness

Per coat: .8 - 1 mils. (20-25 µm)

Flash off



7-12 minutes between coats



Polybase Plus Basecoat (Low VOC)

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Drying times



	70°F (20°C)	140°F (60°C)
Dry to recoat	20-30 minutes	N.A.

NOTE: Maximum Recoat Window is 72 hours

Sanding

If sanding is necessary on the basecoat, wet sand with #P600 to #P800 grit.
Then recoat

Recoatable with

U-Tech has one clearcoat for application over Polybase Plus, HS 21 Clear.
This selection is based on **low** VOC regulations. Please refer to the technical data sheet for HS21 Clear

Material usage

With recommended application, the theoretical material usage is ± 250 sq.ft./gl per coat.

- *The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure, method and application circumstances.*

Cleaning of equipment

Clean equipment with solvent borne cleaners

VOC

Polybase Plus Basecoat 6.1 lb/gal 727 g/liter

Product storage

Store products unopened, and used products with closed lids preferably between 60°F-95°F (10°C-35°C)

Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

- Polybase Plus Basecoat: 2 years
- A-Base Activator: 12 months
- R200 Reducers: 2 years



Polybase Plus Basecoat (Low VOC)

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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 writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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