



ProXL H²O - Waterbased Automotive Basecoat

WATERBASED AUTOMOTIVE BASECOAT:

Use **ProXL H²O** and build a future for your business that makes cents. **ProXL H²O** is user friendly and very cost effective. The transition from conventional to **ProXL H²O** is easy. Only minor adjustments and a little training are needed. Furthermore, the investment required is minimal.

ProXL H²O is a premium, high quality Waterbased Automotive Basecoat, which offers outstanding one coat coverage for high performance, achieving fast drying times and excellent holdout. **ProXL H²O** is easy to use and complies with all applicable VOC regulations when properly clear coated.

COMPONENTS

- | | |
|---|--------------|
| ➤ ProXL H²O Basecoat | Base Color |
| ➤ ProXL H²O De-mineralized Water | WS120 |
| ➤ ProXL H²O Basecoat Blending Agent | WS135 |

PHYSICAL DATA

- | | |
|------------------------------------|--|
| ➤ Solids content by weight. (Base) | 65% (average of colors) |
| ➤ Color range | Selected Automotive colors |
| ➤ VOC as Mixed | 0.9 - 3.5 (Max.) lbs/gal; 108 – 420 gr/lit |

SUBSTRATES

Unsuitable Substrates:

1K Primers, NC Lacquers, Acrylic Lacquers

Suitable Substrates:

Original or old Paint – 2K Top-coat & 2K Clear-coat, 2K Primer (**ProXL XLPrime**)

SURFACE PREPARATION

- Degrease with **ProXL H²O WS222** degreaser
- Sand and prime with **ProXL XLPrime** if required
- Finish sand with P800 by hand; P500-600 with orbital sander; wet sand with P800-1000 **Note: Allow surfaces that have been wet-sanded to dry thoroughly before Clean-Wipe and painting.**
- Clean thoroughly with **ProXL H²O WS222** Clean-Wipe to clean substrate free of silicone, dirt, and foreign contaminants. Wipe dry completely before applying color.
- Thoroughly sand the surrounding areas that have not been coated with primer surfacer using a fine sanding pad P1200 wet sand paper.
- Use only special “Base Coat Tack Rags” that leave no sticky trace behind.

MIXING

ProXL H²O tinters should be stirred twice a day.
Plastic containers or cans with special lining must be used.
To avoid excessive foaming, avoid shaking toners on a paint shaker.

Mixing ratio (basecoat color)

Mixing ratio is 1 part **ProXL H²O** Basecoat to 10%-20% **ProXL H²O WS120** de-mineralized water.
Optimum viscosity is 23 sec. Din 4 cup, or 27 sec # 2 Zahn cup, @ 70° F (~ 20 °C)

Strainers with waterproof glue must be used. (125 micron)

Avoid using paint shakers after color is made.
Stir color thoroughly before application.

APPLICATION

Use only spray equipment that have stainless steel components and are set up for water application.

Gun Setup

- | | |
|-------------------------------|-----------------|
| ➤ Gravity Feed HVLP | 1.2 mm – 1.3 mm |
| ➤ Gravity Feed Compliant LVLP | 1.2 mm – 1.3 mm |

Air Pressure

- | | |
|-----------------------------------|------------------------------|
| ➤ Conventional Gravity Feed @ gun | 35 – 45 psi (2.4 – 3 bars) |
| ➤ Conventional Siphon Feed @ gun | 40 – 50 psi (2.8 – 3.4 bars) |
| ➤ LVLP gun @ gun | 23 – 26 psi (1.6 – 1.8 bars) |
| ➤ LVLP gun @ cap | 10 – 12 psi (0.7 – 0.8 bars) |

Paint Application

The application of waterborne products is influenced to a great extent by temperature and air humidity. This may restrict the application or make it more difficult unless certain conditions are fulfilled.

Assuming that in an up-to-date paint shop an application temperature of at least 20°C/68°F is guaranteed, particular measures are required only with regard to the air humidity if it is outside the application range.

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When relative humidity of air is very high:

Excessively high air humidity may cause color deviations, mottling of metallic and effect colors and insufficient settling on upright surfaces. The following measures may be useful.

- Increase temperature in the spray booth as far as acceptable for the staff.
- Choose maximum application viscosity given in Technical data sheet.

When relative humidity of air is very low:

Inadequate air humidity may cause increased over spray and insufficient over-spray absorption. The following measures may be useful.

- Reduce application temperature if possible. Observe the minimum of 65°F/18°C.
- Choose lowest possible application viscosity given in the Technical Data Sheet.

Application Techniques

Two Stage Solid Colors:

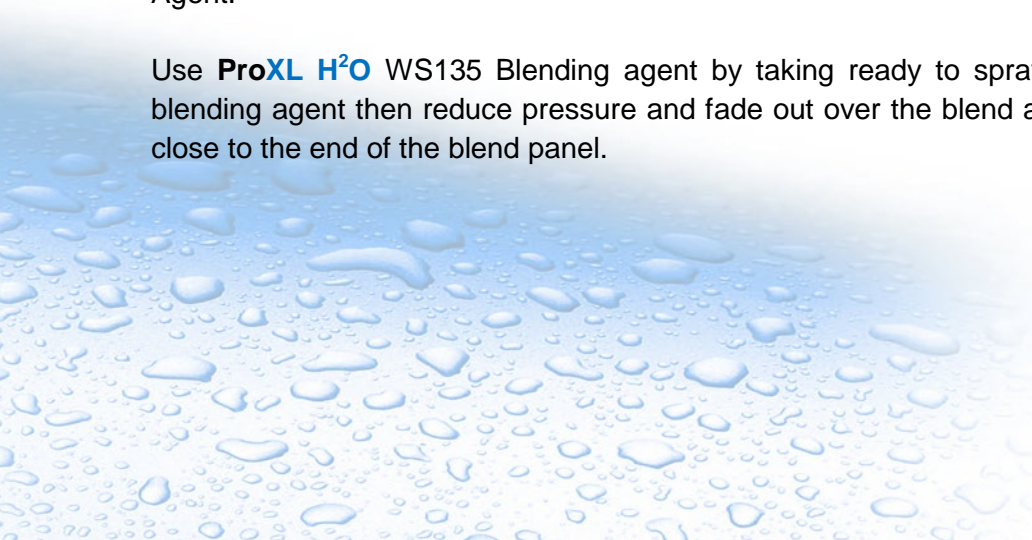
- Apply light tack coat over repaired area to check any impurities.
- Holding Spray Gun 6-8" away from the surface, using a 50-60% overlap, apply base coat to completely cover the repaired area, overlapping slightly onto the original surface at ready to spray viscosity. Spray a wet even coat
- Reduce air pressure and fade out into the blend area. No flash off times between coats

Two Stage Effect Colors "Metallic and Pearls":

- Apply light tack coat over repaired area to check any impurities.
- Holding Spray Gun 6-8" away from the surface, using a 50-70% overlap, apply base coat to completely cover the repaired area, overlapping slightly onto the original surface at ready to spray viscosity. Spray a wet even coat
- Let the coating flash off completely.
- Hold the Spray Gun 12-18 inches away from the painted surface and apply a quick even orientation coat to organize the effect.
- Reduce the air pressure and fade out into the blend area. Generally, no further painting is required, even on those difficult colors!

If you would like to step out your blend with a further reduced color use **ProXL H²O** WS135 Blending Agent.

Use **ProXL H²O** WS135 Blending agent by taking ready to spray color and adding 20%-50% of blending agent then reduce pressure and fade out over the blend area. Be sure to avoid getting too close to the end of the blend panel.



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Over coating

Surface must always be allowed to matte completely before clear coat is applied.

- Apply clear after the basecoat has become a matt finish
- Clear topcoat must be applied after:
 - 5 hours - solid colors at 20°C
 - 48 hours - metallic/pearl colors at 20°C

DRYING PERFORMANCE

Small Areas

Surface matting can be accelerated by blow-drying with air diffuser after a 5 minute flash off time Dry panel by blowing across the plane of the surface working from the back of the panel to the front.

	<u>Air Dry @ 70° F</u>	<u>Blow dry with (air diffuser)</u>
Flash time	20-30 minutes	7-10 minutes
Tape time	45-60 minutes	35-45 minutes
Tack free	20-30 minutes	7-10 minutes
Dust free	20-30 minutes	7-10minutes

Large Areas

Surface matting can be accelerated by using infrared or low bake cycle.

IR Short wave	3-5 minutes
IR medium wave	4-7 minutes
Cooling time	5-7 minutes

For paint booths equipped for baking cycle:

Low bake 140° F/60° C	10 minutes.
Cooling time	5-7 minutes

Note: Longer bake cycles can cause loss of inter-coat adhesion.

Note: Flash and Dry times will vary depending on humidity, airflow in the booth, number of coats applied and ambient temperature in the booth.



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TRANSPORT AND STORAGE

Anyone Handling, Storing or Transporting this product **must insure** that the temperature should not fall below 5°C/42°F or rise above 35°C/95°F. Temperatures above or below this range will lead to loss of product quality.

CLEAN UP

See Technical Data Sheet – **ProXL H²O** Cleaning equipment and spray guns and waste management.

IMPORTANT REGULATORY INFORMATION:

The values depicted below are “as applied regulatory” for the base coat alone. Values have been determined using EPA Test Method 24.

EU - VOC Regulatory Maximum 420g/l

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read all label and MSDS precautions.

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SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

