ACRIMATT

Series 3000

1K base coat

TECHNICAL FEATURES

1K solvent-based matt base coat for car refinishing and industrial bodywork for the creation of metallic and solid pastel colors. It is the ideal product if a high quality system is required, the base coat is characterized by fast drying, pleasant aesthetic effect and ease of application, thanks to the correct orientation function of pearls and aluminum.

APPLICATION FIELD

Matt base coat indicated as an intermediate coat in the coating systems for cycles of the car refinish and industrial bodywork sector.

GENERAL INFORMATION

System: *One pack - 1K*
Nature: *Solvent-based*
Packages: *1 l - 4 l*
Tinting Service: *Tinting service with solvent-based colorants Series 0615*
Colors ready in stock: *Aluminium Fine Grain, Aluminium Coarse Grain, Aluminium Medium Grain, White, Black*

Color fans and color cards: *Ral 841 GL, Ral Design, Ncs 1950, ColoradoMix 1040, Colorado Box 2.0, Colorado Met*

SUBSTRATE PREPARATION

The support must be perfectly clean, free of greasiness and previously sanded. It must then be pre-treated with the 2K, acrylic primer Acrifiller Series 3400 to be sanded properly.

APPLICATION

Application conditions

The application of the coating product can be influenced by various factors such as environmental conditions (among which it is necessary to mention temperature, humidity and ventilation), the geometry and laboriousness of the products to be painted, the different type of surface profiles and the thicknesses to be applied. Spray application with HVLP / LVLP gravity gun with 1.2 - 1.4 mm nozzle is recommended.

EQUIPMENT	VISCOSITY	NOOZLE	PRESSURE	NOTES
AIRBRUSH - CUP GUN	18'' - 22 '' Ford Cup 4	1,3 - 1,5 mm	2 - 2.5 bar	-

ENVIRONMENTAL CONDITIONS

ENVIRONMENT TEMPERATURE	SUBSTRATE TEMPERATURE	RELATIVE HUMIDITY	SHELF LIFE
5°C - 35°C	5°C - 35°C	60 %	Store 2 years in original sealed packaging at +5/+35°C.

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TECHNICAL DATA

THEORETICAL AVERAGE SPREADING RATE	APPLICATION	DILUTION	GLOSS	WET FILM THICKNESS EACH COAT	DRY FILM THICKNESS EACH COAT	N° OF COATS	TOTAL DRY FILM THICKNESS	THEORETICAL AVERAGE CONSUMPTION
6,2 m²/l each coat at the dry film thickness of 25 µ	Spray	60% with Unithinner Series 0934	-	160 µ	25 µ	2 coats to achieve the total requested thickness	30 µ	149.5 g/m²

DRYING

OVERCOATING INTERVAL	AIR DRYING	DUST-FREE DRYING	DRY TO TOUCH	DRY THROUGH	FULL CURE	FLASH OFF	STOVING DRYING	RESISTANCE TO TEMPERATURE
20 minutes - 6 hours	20°C	5 - 10 minutes	1 hour	24 hours	1 day	20 minutes at 20°C	-	80°C continuous exposure

WARNINGS AND RECOMMENDATIONS

- *The use of nitro thinners for the application of polyurethane coating systems can create pitting phenomena on the surface of the dried film. Furthermore, the presence of partially reactive solvents can give rise to undesired reactions, reducing the aesthetic and mechanical features of the system. The choice of unsuitable regenerated thinners can create problems of color change, product sedimentation and less effectiveness in reducing viscosity.*
- *The color match is evaluated after the application and drying of the product. It is recommended to carry out practical tests, such as spreading or applying the colored product on small surfaces made of suitable material, before proceeding with the product painting.*
- *After having colored the product with the suitable colorants, mix it in a short time.*
- *In order not to incur financial penalties, after having colored a product with tinting machine, send the MSDS and apply the appropriate legal labelling printable using the Databook P&C tinting software.*
- *For slightly matt colored products (yellow, orange, red) it is recommended to use a suitable white primer.*
- *Being an intermediate coat, the product does not grant anticorrosion properties. To obtain the performance of the coating system, the application of the 2K, acrylic primer and of the 2K acrylic clear topcoat is recommended.*
- *In case of application of the base coat aluminium, apply two coats of the product followed by a light and shaded coat to obtain the correct aluminium orientation and effect.*
- *The overcoating interval refers to the application of the 2K acrylic clearcoat on the base Acrimatt.*

SUPPLY TECHNICAL DATA

Composition: Modified polyester
Reference color: Transparent
% solid content by weight: 20,5 ± 2%
% solid content by volume: 15,5 ± 2%
VOC: 739 ± 2 g/l
VOS: 79 ± 2%

PARAMETER	DATA	TEST METHOD
SPECIFIC WEIGHT	0,9 - 0,95 g/ml	ISCOL 2
VISCOSITY	75 - 85 seconds Ford Cup 4	ISCOL 4

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NOTES

Cleaning tools: *At the end of the application, carefully wash the spray guns, the painting systems and the containers with a suitable thinner and store the tools dry to avoid encrustations.*
Sanitary labelling: *Handle the product with care. Make reference to the MSDS and respect the national and local regulations in force concerning personal and environmental safety.*
Additional notes:

- *The data reported in this data sheet have been obtained using only Franchi&Kim production materials (coatings, hardeners, thinners) applied in accordance with the specifications described. The improper use of thinners and/or hardeners, different from those suggested or not manufactured by Franchi & Kim, can compromise application features, performances and final curing of the product. Therefore, in case of mixed coating systems with Franchi & Kim and other brand products, the conformity of the results with the parameters indicated in the technical data sheet cannot be granted.*
- *The times related to pot life and drying intervals refer to a standard temperature of 20°C, except when it is expressly indicated.*
- *The gloss indicated and tested may change during the application phase because it can be influenced by the following factors: realized color, thickness, number of coats, environmental conditions, thinner and hardener used if different from those listed in the technical data sheet.*
- *The spreading rates are theoretical, indicative and intended per coat as they can be influenced by the color and the application system. Practical application test is suggested.*

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