



GLOBAL PAINT COMPANY



## METALUX BASECOAT

### Description:

One-pack basecoat system designed for private cars, commercial vehicles and equipment; as well as for repair to existing OEM two and three coat systems, as well as design work. These basecoats have been formulated with the highest quality range of light fast pigments to meet the OEM colour standards. Good coverage, flow and ease of application provide the refinisher with a quality product.

### Product and Additives

METALUX 2 Basecoat  
METALUX 2 Basecoat Thinners Fast, 1154 / Normal, 1155 / Slow, 1153.

### Basic Raw Materials

Note: 1153 Slow Thinner is recommended only for large vehicles and temperatures above 35°C / 95°F.

### Suitable Substrates

Base: Polyester convertible binders  
Note: METALUX 2 basecoats must be overcoated with a clearcoat.

### Surface Preparation

METALUX 2 Basecoat can be applied over:  
- Existing Finishes except Thermoplastic Acrylics and NC products  
- METALUX 2 undercoats with exception of lacquer and etch primers.  
- Ideal over METALUX 2 2K HS Filler Primers

Degrease then wet flat P800 – P1000 grit or dry flat P400 – P600 grit (DA).  
Re-clean surface after sanding.

### Mixing Ratio

2 parts by volume METALUX 2 Basecoat  
1 part by volume METALUX 2 Basecoat Thinners, to spray viscosity of 16 seconds with # 4 Ford Cup @ 25°C / 77°F.

Note: RFU VOC is below 6.6 lbs/gallon. Specific colour VOC contents are displayed on EasiMix.  
When used with a 4.2 or lower VOC clear meets USA national VOC rule of 5 lbs/gallon.

Option for longer recoating:  
Add 5% of Hardener to premixed basecoat.

Option for interior colours (i.e. underbody):  
Add 20% of catalyzed clear to premixed basecoat.

### Process

Apply 2 single wet coats allowing 4 to 8 minutes flash off between coats.  
An additional coat may be required with colours difficult to cover.

Option for metallic's and blending basecoat: After the final coat of colour, lower the air pressure and apply a final medium-wet drop coat. Do Not dry spray.  
Flash off for 15 to 20 minutes before applying clear.

### Spray Gun Settings:

HVLP Gravity:	1.3 – 1.4mm	0.4 – 0.5 BAR / 6 – 8 PSI	At the cap
High Efficiency:	1.3 – 1.5mm	2.0 – 2.7 BAR / 30 – 40 PSI	Inlet pressure
Conventional:	1.4 – 1.6mm	2.0 – 4.0 BAR / 30 – 60 PSI	Inlet pressure

Note: Refer to spray gun manufacturer for further information regarding inlet pressures.



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Film thickness:	± 10 micron / 0.4 mil per coat.
Recommended Flattening:	Dust nibs can be removed with P1000-P1500 after 10 minutes.
Recoatibility:	Must be recoated with clear after 15 minutes and before 8 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. If basecoat is not recoated within the proper recoat time, remove or scuff sand the basecoat and then reapply basecoat to avoid clearcoat peeling.
Cleaning of Equipment:	Clean equipment immediately with quality lacquer thinner.
Health & Safety:	Refer to text on label and MSDS. Flammable – keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.