



## TECHNICAL DATA SHEET

# MIXING SYSTEM 1K AUTOBASE+

## BASECOAT MATT

### DESCRIPTION

The **1K AUTOBASE+** system reproduces pastel, metallic, pearl and xiralic matt shades of enamels for absolutely any car model.

**1K AUTOBASE+** Formulas are available in dedicated software that is updated every two months. The **1K AUTOBASE+** system has a colorbox and is supported by an X-RITE 5-angle spectrophotometer.

#### ADVANTAGES:

- 1) High level of hiding power.
- 2) High level of consistency of color formulas.
- 3) Easy to apply and quick drying.
- 4) Maximum stability of pigments.
- 5) Ease of repair.
- 6) A wide range of formulas (over 75,000).

#### IMPORTANT:

For each formula, use a filler to match the enamel shade specified in the software. The product must be applied to a well sanded and dried filler.

#### APPLICATION RECOMMENDATIONS:

**- it is recommended to apply 1 layer very light and thin.**

The distance from the application surface should be 20 cm, if the spray gun is RP the air pressure should be set to 3.5-4 bar, if the spray gun is HLVP-LVLP then the air pressure should be set to 1.8 - 2.2 bar. Nozzle - 1.2 - 1.3 mm.

*This step is optional, but recommended to eliminate microdefects due to the presence of silicone in the air.*

**- the next step is to apply 2 standard coats, the interval between which should be 5-10 minutes.**

In this case, the product is applied until the required coverage level is reached. The distance from the surface should be 10-15 cm, spray gun adjustment - see **technical information below**.

**- final coat - spray over the entire surface.**








Apply 1 very light and uniform coat. The last layer – spraying, is applied over the entire surface at the moment when the enamel becomes almost dull (3-4 minutes after application at 20 °C), while adhering to the rules specified in the technical information section entitled "Spraying".









After 15 minutes at 20 °C, apply a solvent-based varnish - ADC.0010.



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### TECHNICAL INFORMATION

TECHNICAL CHARACTERISTICS				
	<b>MIXING RATIO</b>	100 (PRODUCT) : 0 (HARDENER) : 60 (THINNER)		
	<b>PRODUCT, 1K AUTOBASE+</b>	100 VOL		
	<b>HARDENER</b>	-		
	<b>THINNER, CODE ADT.4400</b>	60 VOL		
	<b>POT LIFE (20 °C)</b>	-		
	<b>APPLICATION VISCOSITY</b>	16 ± 1 DIN 4		
	<b>AIRBRUSH ADJUSTMENT</b>	2 Turns		
	<b>NOZZLE</b>	1,2 – 1,3 RP		
	<b>AIR PRESSURE</b>	1,8 – 2,0 RP		
	<b>NUMBER OF COATS</b>	<b>1 LIGHT</b>	<b>2 FULL</b>	<b>FADE OUT</b>
	<b>TIME INTERVAL BETWEEN COATS</b>	5-10 MIN – 20-25°C		

FADE OUT		
	<b>AIRBRUSH ADJUSTAMENT</b>	2 Turns
	<b>NOZZLE</b>	1,2 – 1,3 RP
	<b>AIR PRESSURE</b>	1,5 RP
	<b>DISTANCE FROM THE SUPPORT</b>	30 – 35 cm
TECHNICAL INFORMATION		
	<b>FLASH TIME</b>	5-10 MIN – 20-25°C
	<b>THROUGH DRYING</b>	-
	<b>DRY FILM THICKNESS</b>	<b>20-25µ</b>
	<b>YIELD RFU – M<sup>2</sup> / KG X 1 µ</b>	9-10
	<b>ROTO-ORBITAL DRY SANDING</b>	P600-P800 –Old Paint Coat P500-P600 – Filler
	<b>ROTO-ORBITAL WET SANDING</b>	-
	<b>MANUAL SANDING ON WET</b>	-
	<b>DRY MANUAL SANDING</b>	P500 – P600 –Old Paint Coat P400-P500 – Filler
	<b>OVERCOATABLE</b>	15 MIN AFTER FADE OUT
	<b>STORING</b>	24 Months 5 < °C < 35