

LV-1K Basecoat

Surface preparation	Remove wax, silicon or other contaminations with low- VOC or waterborne degreaser.
Mixing ratio	<div> <div> 1K Basecoat (volume) 100 <68°F LV-1K Basecoat >68°F LV-1K Basecoat </div> <div> + Reducer 80-100 LV-5 Fast Reducer LV-1 Standard Reducer </div> </div>
Coats & Thickness	2-3 Coats, 15-25 µm
Flash-off	68°F , 3-5 mins between coats, then allow to dry for 10-15 min before applying clear coat.
Spray Gun Set-up	RP: 1.3mm 2.0-2.5bar HVLP: 1.3mm 1.8-2.0bar
Re-application	If dust or other contaminates appear in the finished film, color sand with P-600 (dry) or P800 (Wet), then reapply the Low VOC Basecoat.
VOC	3.5 lbs/gal(mixed)

Notes:

1. The substrate must be sanded and cleaned before spray. (wet sanding: P600-P800, drying sanding: P400-P600)
2. Reducer should be added with Retarder Solvent at temperature is greater than 86°F . Please refer to the technical data sheet of Retarder Solvent for further details.
3. Because of the high transparency of pearl and/ metallic basecoat mixes, a good quality spray gun as well as professional spray techniques should be applied in order to prevent defects, mottling or poor metallic effects.
4. To avoid problems of mottling, or poor adhesion, the thickness of metallic paint film shall be no greater than 25µm.
5. Better effect can be achieved if any extra silver powder and/or dust particles can be removed from the refinish surface with a tack cloth after the flash-off between each coat.
6. After spray, allow 10-15 minutes of air-drying time, then apply clear coat. Over air-drying of the basecoat can affect the adhesion properties of the basecoat to the clear coat.