


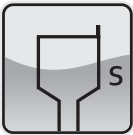



# Basecoat 2c

## 2-Stage Metallic Colors (Aluminum/Pearl/Xirallic)

**Product Description**  
Single component metallic colors for repairing automotive 2-stage finishes.

**Technical Characteristics**  
Color: mixing system      Shelf life: 48 months at 25°C      Theoretical spreading rate: 120 m<sup>2</sup>/l (avg) at 1 µm

**Pre-treatment**  
Wet flat with P800–1000 grade paper or dry flat with P600-800 grade paper.  
Degrease with IC-800  
Wash off residues and dry thoroughly.  
Re-clean with IC-800 The use of a tack rag is recommended.

	<b>Mixing Ratio</b>	<p>Stir well before use. Twice per day for 15 mins on the mixing machine.</p> <table border="0"> <tr> <td><b>IC-1KS/1KP/1KX/BH-Metallic Colors</b></td> <td>100 (vol)</td> <td>100 g</td> </tr> <tr> <td><b>IC-940</b></td> <td>(5°C–15°C)</td> <td></td> </tr> <tr> <td><b>IC-950</b></td> <td>(15°C–25°C)</td> <td>110–120 (vol)      100-110 g</td> </tr> <tr> <td><b>IC-960</b></td> <td>(25°C–35°C)</td> <td></td> </tr> <tr> <td><b>IC-970</b></td> <td>(&gt;35°C)</td> <td></td> </tr> </table> <p>Mix well and strain before application.</p>	<b>IC-1KS/1KP/1KX/BH-Metallic Colors</b>	100 (vol)	100 g	<b>IC-940</b>	(5°C–15°C)		<b>IC-950</b>	(15°C–25°C)	110–120 (vol)      100-110 g	<b>IC-960</b>	(25°C–35°C)		<b>IC-970</b>	(>35°C)	
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	<b>Spray Viscosity Potlife</b>	<p>14 to 19 seconds DIN 4 cup at 25°C 24 hours at 25°C</p>															
	<b>Sprayguns</b>	<table border="0"> <tr> <td>HVLP gravity-feed spraygun</td> <td>1.2–1.3mm</td> <td>1.8–2.0 bar</td> <td>10–15 cm</td> </tr> <tr> <td>Conventional gravity-feed spraygun</td> <td>1.3–1.6mm</td> <td>3.0–4.0 bar</td> <td>15–20 cm</td> </tr> </table>	HVLP gravity-feed spraygun	1.2–1.3mm	1.8–2.0 bar	10–15 cm	Conventional gravity-feed spraygun	1.3–1.6mm	3.0–4.0 bar	15–20 cm							
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	<b>Application</b>	<p><b>Apply basecoat over original stoved finishes or over IC-981/IC-972 grey primers.</b> Number of spraycoats: 1 thin + 1 wet coat + 1 mist coat to match effect Flash-off: 3 mins with spraygun-cooling; 5 mins Note: Before mist coat, enlarge the spray fan and adjust spraying pressure &amp; distance to be:</p> <table border="0"> <tr> <td>2.0 bar (HVLP)</td> <td>10–15 cm</td> </tr> <tr> <td>3.5 bar (Conventional)</td> <td>20–25 cm</td> </tr> </table> <p>Film thickness: 15–25 µm</p>	2.0 bar (HVLP)	10–15 cm	3.5 bar (Conventional)	20–25 cm											
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	<b>Drying</b>	<p>Drying at 25°C: 5 mins Drying at 60°C: –</p>															
	<b>Further Treatment</b>	<p>After the flash-off, apply InnoColor clear coat wet on wet</p>															

The products are suitable for professional use only. The data contained in this publication are based on our current knowledge and experience. You can obtain the latest version of technical data sheet from our website at [www.wonder-global.com](http://www.wonder-global.com) or directly from your supplier.