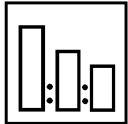
	North America	Technical Data Sheet
	U-BASE Basecoat	Basecoat
		12/13/16
FOR PROFESSIONAL USE ONLY		

Description

U-BASE Basecoat is two-component polyurethane designed for original equipment and repairs for commercial vehicles. U-BASE Basecoat provides superior performance that is simple to mix and easy to apply. The ready to spray VOC is < 3.5 lbs/gal and is HAPs compliant.



- 3 U-BASE Basecoat RM
- 1 U280 /U350 Hardener
- 1 R300 Reducer (Fast or Slow)

(Within the RM Basecoat, the ratio of tinter to UBase Binder is 1:1 by weight)



Use AkzoNobel Measuring Stick

106



Spray gun setup:

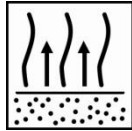
Check gun manufacturer

HVLP – Pressure Feed	1.0 – 1.2mm	Max 10psi (cap)	12 – 16 oz/min
HVLP – Gravity Feed	1.2 – 1.4mm	Max 10psi (cap)	



Apply on (1) wet coat followed by a cross coat (½) or until hiding is achieved

For metallic colors, an orientation coat may be desired.



Between coats
3 - 5 min at 70°F (21°C)

Before clear coat application
30 min (Solid Colors) at 70°F (21°C)
45 min (Effect Colors) at 70°F (21°C)



Dry to clear coat

Dry to tape


Maximum recoat window 24 hours

	70°F (21°C)	2oz SuperTop Plus per RTS gal at 70°F (21°C)
Dry to clear coat	30 min (Solids) 45 min (Effects)	15 min (Solids) 30 min (Effects)
Dry to tape		30 min (Solids) 45 min (Effects)



Use suitable respiratory protection
AkzoNobel recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

	North America	Technical Data Sheet
	U-BASE Basecoat	
FOR PROFESSIONAL USE ONLY		

Description

U-BASE Basecoat is two-component polyurethane designed for original equipment and repairs for commercial vehicles. U-BASE Basecoat provides superior performance that is simple to mix and easy to apply. The ready to spray VOC is < 3.5 lbs/gal and is HAPs compliant.

Suitable Surfaces

Existing finishes, degreased and sanded with #P320 to #P400 grit paper dry or #P600 to #P800	
2KHB Surfacer	460 Flex Tintable Sealer
2K20 Surfacer	E250 DTM Epoxy Primer
2K100 Surfacer	E380/E381 Epoxy Primer
460 Tintable Sealer	

Product and Additives

Product	U-BASE Basecoat	
Hardener	U280 / U350 Hardener	
Reducers	R300 Reducer Fast	Applications 60°F (16°C) – 90°F (33°C)
	R300 Reducer Slow	Applications > 90°F (33°C)
Additives	SuperTop Plus	Accelerates dry times for taping applications
	U-Tech Metallic Wet Blend	Assists metallic spot repair

Basic Raw Material

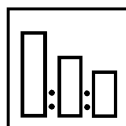
U-BASE Basecoat RM	Polyol resins
U280 / U350 Hardener	Polyisocyanate resins
R300 Reducers (Fast / Slow)	Solvents

Product Characteristics

WPG (RM color)	8.1 – 10.2 lbs/gal	Gloss	High
Volume Solids (RTS)	40% +/- 2%	Color	Solid, metallic and pearl
Theoretical Coverage	642 ft ² /gal @ 1mil – 100%TE	Pot Life (no additives)	1.5 hrs @ 70°F (21°C)
		Pot Life w/ SuperTop Plus	45-75 min @ 70°F (21°C)

Mixing

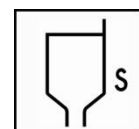
3	U-BASE Basecoat RM
1	U280 /U350 Hardener
1	R300 Reducer (Fast or Slow)



Note: R300 Reducer Fast and Slow can be blended together for medium speed


For easy and accurate mixing, use U-Tech measuring stick #106
For Taping Applications add 2oz per RTS gallon of SuperTop Plus

Viscosity



U-BASE Basecoat RM	18 - 24 sec	EZ ZAHN #2 at 70°F (21°C)
--------------------	-------------	---------------------------

Viscosities are reported as Ready to Spray

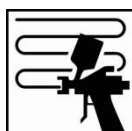
	North America	Technical Data Sheet
	U-BASE Basecoat	
FOR PROFESSIONAL USE ONLY		

Spray gun set-up / application pressure



RP – Pressure Feed	0.8 – 1.4mm	30 – 36psi	12 – 16 oz/min
RP – Gravity Feed	1.2 – 1.4mm	30 – 35psi	
HVLP – Pressure Feed	1.0 – 1.2mm	Max 10psi (cap)	12 – 16 oz/min
HVLP – Gravity Feed	1.2 – 1.4mm	Max 10psi (cap)	

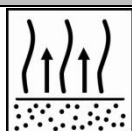
Application



Solids - Apply one (1) wet coat followed by a cross coat (½) or until hiding is achieved. Follow recommended flash time between coats.

Metallics - Apply one (1) wet coat followed by a cross coat (½) or until hiding is achieved. Follow recommended flash time between coats. An orientation coat can be applied after flashing the final coat for 1 minute.

Flash off



3 – 5 minutes at 70°F (21°C) between coats

30 min (Solid Colors) – 45 min (Effect Colors) minutes at 70°F (21°C) flash before clearcoat

Dry times



	No Additives 70°F (21°C)	2 oz/gal SuperTop Plus per RTS gal 70°F (21°C)
Dry to clear coat	30 min (Solids) 45 min (Effects)	15 min (Solids) 30 min (Effects)
Dry to tape		30 min (Solids) 45 min (Effects)

Note: SuperTop Plus will decrease pot life

Dry Film Thickness

1.5 – 2.0 mils
Some colors require higher DFT to achieve opacity

Recoatability

U-BASE Basecoat can be recoated with itself or clear coated with 4.0 Select Clear or HS21 Clear after 30 min (Solid Colors) – 45 min (Effect Colors) minutes at 70°F (21°C). Sanding is necessary after 24 hours.


Cleaning of equipment

Clean equipment with extra strong cleaning solvents

VOC

U-BASE Basecoat RM	< 3.5 lb/gal	< 420 g/l
--------------------	--------------	-----------

VOC is ready to spray at a mix ratio of 3:1:1

	North America	Technical Data Sheet
	U-BASE Basecoat	Basecoat
		12/13/16
FOR PROFESSIONAL USE ONLY		

Product Storage and Shelf Life

Store products unopened and used products with closed lids. Store products between 70°F-95°F (21°C-35°C). Optimal storage temperature is 77°F (25°C). Avoid extreme temperature fluctuation when storing.

Intermix Tints	2 years
U-BASE Binder	2 years
U280 / U350 Hardener	1 year
R300 Reducer Fast, Slow	2 years
SuperTop Plus	6 months

FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

Coatings brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.

Head Office

AkzoNobel Car Refinishes Inc. 1845 Maxwell Street Troy Michigan 48084 1-800-618-1010. www.utech.us