KURUMA BASECOAT (Binder system)

Product Description

- Kuruma Basecoat (Binder system) is a base coat for metallic Pearl or solid color, use both in Clear over base system and 2 component top coat solid color. It's quick dryness and easy to apply under non-mottling, good adhesion high hiding power.
- Binder system component

1) Solid toner 2) Metallic toner 3) Pearl toner
4) 1K Binder [KB011, KB150, GB150]
5) 2K Binder [KB021]
6) Hardener
7) Flip flop control agent
8) Thinner

Substrate preparation

- Primer sanding, dry sanding no.400-500 or wet sanding 600-800
- Ensure that surface of the previous coat was clear and dry free form dirt, rust, grease, oil and other foreign matters.
- Degreasing and clearing with Kuruma Silicone off

Mixing Ratio

- Kuruma Basecoat 1K (Clear over base system)

	Solid	Metallic & Pearl
Kuruma toner	50%	30%
Kuruma 1K Binder	50%	70%
Thinner	40-50%	70-100%

- Kuruma Basecoat 2K

	Solid
Kuruma toner	50%
Kuruma 2K Binder	50%
Kuruma hardener	25%
Thinner	40-50%

Thinner

Kuruma Standard Thinner No.20 or Kuruma Slow Dry Thinner No.30

Clear coating

Apply 2K Clear topcoat for Kuruma Basecoat 1K

Viscosity For Spray

Viscosity Cup	Viscosity (sec) @30°C
Ford Cup No. 4	14 - 16

Spray gun Gravity Feed
Set-up Full pattern, Flow - 2.5 turns from fully closed set-up
Nozzle size 1.3 - 1.4 mm. (Please refer to spray gun manufacturer)
Spray pressure 1.5 - 2.0 Bar
Number of spray coats Recommended apply 2-3 coats

- Kuruma Basecoat 1K

Full wet first coat
Full wet second coat
Drop third coat
Solid, dry film thickness : 30 - 40 microns
Metallic, dry film thickness : 15 - 25 microns
Pearl, dry film thickness : 15 - 25 microns

- Kuruma Basecoat 2K

Full wet first coat and second coat

Dry film thickness : 40 to 60 microns

Flash off time

Between coats : 3-5 mims

Drying time

- Kuruma Basecoat 1K

Drying time	Air dry (30 °C)
Surface dry	3 - 5 mins
Dry to recoat	5 - 10 mins
Dry to top clear	5 - 10 mins

- Kuruma Basecoat 2K

Drying time	Air dry (30 °C)	Baking (30 mins / 60 °C)
Surface dry	5 - 10 mins	-
Polishing time	4 - 6 hours	-
Dry to assembly	2 hours	1 hours

Handling and Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

Shelf life

- 48 months at <40 ^{0}C

Safety and Disposal

- Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.
- For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Safety Data Sheet.