FREEWORLD
AUTOMOTIVE COATINGS

Data Sheet Number:
OBR-01-2
OBR Range

OBR Range of Mastermix Basecoat Toners

- Good opacity
- Easy to blend in
- A wide range of coloured Toners including silvers and a full range off pearls

Technical Description

- Mix with 40 - 50% Basecoat Thinner OBR 1000 (in mixed colour formulation)
- Recommended Dry Film Thickness (DFT) 30 - 40 microns
- 2 - 3 spray passes

OBR Range of Mastermix Basecoat Toners

WORKING PROCESS:

2 stage system

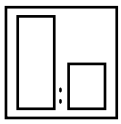
SUBSTRATE:

- On all refinish primed surfaces
- Cured sanded painted surfaces

PRETREATMENT / CLEANING:

Ensure that all surfaces are clean, free from Dust, oil, grease or other contaminants by using Acryline Pre-cleaner (ATH 310)

APPLICATION:



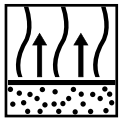
Mix with Basecoat Thinner (OBR 1000)

Use air fed respirator.
Refer to relevant Health and Safety Data sheets.

40 - 50% Basecoat Thinner (OBR 1000)
20–22” DIN 4 @ 23°C or 22 - 24 sec F4 @ 23°C

1.3 - 1.4 mm
HVLP: 1.8 - 2 bar
Conventional: 3 - 4 bar
2 - 3 coats = 30 - 40 micron (approx.)

1.5 - 1.7mm
Conventional: 3 - 4 bar
2 - 3 coats = 30 - 40 micron (approx.)



5min @ 23°C, Non metallic
Flash off between coats and final flash off
Allow metallics 10min.
Flash off before application of Clear coat

Overcoat with Plascon 2K Clear (PTK 10)
as per TDS

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Flashpoint:	Specific Gravity:	Solid content:
23°C	0.90 - 1.11 g/cm³ Dependant on colour	+/- 36% (by weight)

Average DFT: 15-20 microns per coat

Raw Material: Special Blend of resins combined with lightfast and durable pigments, aluminums and mica pearl products.

Cleaning of Equipment: Clean equipment immediately after use with a suitable thinner.

Shelf Life: 12 months @ 20 - 25°C in original sealed packaging.

Important remarks:

- For professional use only.
- Caution - Clearcoat contains isocyanate. When spraying, operator must wearcompressed air breathing apparatus or other suitable protection which is satisfactory for use with isocyanates

Limitations: This product cannot be used over:

- Unprimed body filler/sprayfiller
- Air drying enamels
- Water based finishes

Protect from sunlight

Working areas should be well ventilated.
Booth must have good extraction.
Refer to Material Safety Data Sheet (MSDS)

Protect from severe cold

This Product contains flammable materials.
Keep away from sparks & open flames.
No smoking permitted in the area.

Disclaimer:
The recommendations contained herein are given in all good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control. Should a recommendation be of a GENERAL NATURE and not refer to any particular project, and should the reader wish to use the general specification for a PARTICULAR project, then he should first confirm with the Technical Service Department that the specification can be used. Not all products referred to in this Data Sheet are stock items. Many are manufactured only on receipt of official customer orders. It is essential,therefore, where time is of the essence, to check availability and manufacturing lead times with us.

Validity date:
Paint technology is continually being improved and developed. Therefore before putting this Technical Data Sheet into practical use please confirm with our Technical Service Department that it has not been superseded. We cannot accept ANY responsibility where this precaution has not been taken. Issue date: July 2008. NB.: TO ORDER: Quote Product name, Product Code number and pack size.Freeworld Automotive Coatings (Pty) Ltd:

Freeworld Automotive Coatings (Pty) Ltd:

Cape Town
P.O.Box 42
Eppingdust 7475
Tel: (021) 505-2400
Fax: (021) 534-3791

Durban
P.O.Box 1386
Durban 4000
Tel: (031) 451-3200
Fax: (031) 451-3408

Alberton
P.O.Box 136178
Alberton North 1456
Tel: (011) 861-0300
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P.O.Box 1594
Port Elizabeth 8000
Tel: (041) 401-1400
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