
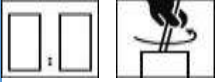






Features:	<ul style="list-style-type: none"> • Karbon BC is a basecoat, which must be re-coated with Karbon clear coats. The system provides an exceptional optical effect, high durability, resistance to chemicals and lasting gloss. 		
Benefits:	<ul style="list-style-type: none"> • Excellent Color Matching - Excellent drying • Low consumption - Good flow 		
Recommended Use:	<ul style="list-style-type: none"> • For painting passenger and commercial vehicles, trucks, etc. 		
Required Materials:	<ul style="list-style-type: none"> • Karbon Basecoat • Karbon Reducer • Karbon Primer • Karbon Clear • Karbon Hardener 	<ul style="list-style-type: none"> • BC • R2S, R2M • PR50 • CL20 • H4S, H4M, H2S, H2M, H2F 	
Physical Properties/ Technical Data:	<ul style="list-style-type: none"> • Specific Gravity(kg/l): • Flash Point: • Solids Vol %: • Solids Wt. %: • Coverage (Depending on color): • Viscosity (RFU): • Gloss: • Color: • V.O.C. Regulatory RTS (g/L) (less water, less exempts): • V.O.C. Regulatory RTS (lbs/Gal) (less water, less exempts): • Applicable Use Category: • Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency: • Sq. Ft Coverage m²/ L (x-y μm) 	<ul style="list-style-type: none"> • 0.900 to 1.140 kg/l • > 23°C' • Varies • • • 20 -30 μm approx. 7-9 m²/l • 60±5" Ford Cup DIN 4 • Matt, Semi Matt • Various • 780 g/l • 6.5 lbs/gal 	
Pretreatment: 	<ul style="list-style-type: none"> • Remove rust from metal areas by sanding or sand blasting then clean surface with Automotive Art Universal Cleaner 20-95. Apply fillers and primers. 		
Cleaning the Equipment:	<ul style="list-style-type: none"> • Lacquer Thinner 		
Mixing Ratio: 	<ul style="list-style-type: none"> • 2 :1 with reducer • 100% by vol. Karbon Basecoat • 50% by vol. Karbon Reducer R2M, R2S 		
Nozzle Size:	Gravity Gun: Suction Gun:	HVLP: 1.3-1.4 mm HVLP: 1.6 mm	High Pressure: 1.3-1.4 mm High Pressure: 1.4-1.6 mm
Spraying Pressure:	<ul style="list-style-type: none"> • HVLP: 2.0 – 3.0 bar (30 – 45 psi) • See Info Manufacturer • High pressure: 3 - 4 bar (45 - 60 p.s.i.) 		
Application: Total Re-spray 	<ul style="list-style-type: none"> • <u>Total re-spray:</u> Apply by spray gun 2 ½ to 3 coats using normal spraying motion, observe flash off time of 5 to 15 minutes between coats or until matt. • Coat Thickness: 15-25μm (0.6-1.0mil) 		
Application: Blending In 	<p><u>Blending In:</u> When repairing a two-stage metallic finish, you have to pre-spray the area to be refinished with reduced B01 (as a blending clear) to make sure that the effect particles in the blend-in area settles properly:</p> <ol style="list-style-type: none"> 1. Clean with Universal Cleaner. 		

	<ol style="list-style-type: none"> 2. Sand for adhesion and clean again 3. Cover damaged area with 2 – 3 coats of basecoat, pressure to approx. 2.0 – 3.0 bar (30 – 45 psi) Flash off until mat. 4. Apply one spray coat of B01 – 2 parts to 1 part Reducer (as a blending clear) on the adjacent area as previously stated in the manual. 5. With reduced pressure at approx. 1.5 – 2.0 bar (22 – 30 psi), apply Dos basecoat to damaged area fading out on to surrounding surface. 6. Leave to flash off until mat before applying 1 or 2 thin spray coats of 82-50 or 9250 clear to the whole part including the repair area. If the area cannot be masked, the clear must be blended in. After lightly spray a blending reducer at the edge. 7. After drying, the area must be polished. <p>Be sure to scuff the entire blending area prior to spraying.</p>																											
Flash-Off time: 	10-15 min. at 20°C.																											
Drying Time: 	15 - 20 min. at 20°C	Can be taped after 20 - 45 minutes.	To be finished with Clear CL20																									
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R2S	Hi-Temp/ Slow																											
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Shelf Life:	Under normal storage conditions minimum two years(unopened tins).																											
Remarks:	This system can be used when painting semi-rigid and soft plastics. A flex additive must be mixed with the clear. E.g. Flexing Agent. (Refer to section on painting of plastics.)																											
Warnings:	Do not pour ready for use product into container with unreduced one.																											
Packaging:	Sizes: 3.5L, 1L																											