
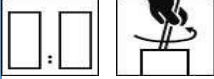







Features:	<ul style="list-style-type: none"> • Karbon BC is a basecoat, which must be re-coated with Karbon clear coats. The system provides an exceptional optical effect, high durability, resistance to chemicals and lasting gloss. 		
Benefits:	<ul style="list-style-type: none"> • Excellent Color Matching - 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 or CL40 • H4S, H4M, H2S, H2M, H2F 	
Physical Properties/ Technical Data:	Specific Gravity(kg/l):	• 0.900 to 1.170 kg/l	
	Flash Point:	• > 23°C	
	Solids Vol %:	• Varies	
	Solids Wt. %:	• Varies	
	Coverage m ² (Depending on color):	• Approx 7-9 m ² /l @ 20 -30 µm.	
	Viscosity (RFU) @20°C :	• 17-19 s DIN 4mm cup	
	Gloss:	• Matt, Semi Matt	
	Color:	• Various	
	V.O.C. Regulatory RTS (g/L) (less water, less exempts):	• 780 g/l	
	V.O.C. Regulatory RTS (lbs/Gal) (less water, less exempts):	• 6.5 lbs/gal	
Applicable Use Category:	• Color Coating		
Pretreatment:	<ul style="list-style-type: none"> • Remove rust from metal areas by sanding or sand blasting then clean surface with Universal Cleaner. Apply fillers and primers. 		
 Pretreatment:			
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 		
 Mixing Ratio:			
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: Total Re-spray			
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. 2. Sand for adhesion and clean again 		
 Application: Blending In			

	<ol style="list-style-type: none"> 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. 5. With reduced pressure at approx. 1.5 – 2.0 bar (22 – 30 psi), apply Kar-bon 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 CL20 or CL40 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>																	
<p>Flash-Off time:</p> 	<p>5-10 min. at 20°C. between coats Allow 10 – 15 min prior to applying clear coat After approx. 8 hours the surface painted with Kar-bon basecoat that has not been covered with clearcoat must be reapplied with basecoat and allowed to flash off before applying clearcoat</p>																	
<p>Drying Time: at 20°C, 65% R.H</p> 	<p>Dust Free: 5 min Air Dry: 10 – 15 min</p>	<p>Can be taped after 20 - 45 minutes.</p>	<p>To be finished with Clear CL20 or CL40</p>															
<p>Reducer Selection Guide</p>	<table border="1"> <thead> <tr> <th>Product #</th> <th>Description</th> </tr> </thead> <tbody> <tr> <td>R2S</td> <td>Slow</td> </tr> <tr> <td>R2M</td> <td>Medium</td> </tr> </tbody> </table>		Product #	Description	R2S	Slow	R2M	Medium	<table border="1"> <thead> <tr> <th colspan="2">Temperature Range</th> </tr> <tr> <th>+80°F (+26°C)</th> <th>55°F-80°F (12°C-26°C)</th> </tr> </thead> <tbody> <tr> <td style="background-color: red;"></td> <td></td> </tr> <tr> <td></td> <td style="background-color: lightblue;"></td> </tr> </tbody> </table>		Temperature Range		+80°F (+26°C)	55°F-80°F (12°C-26°C)				
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+80°F (+26°C)	55°F-80°F (12°C-26°C)																	
<p>Shelf Life:</p>	<p>Under normal storage conditions minimum four years (unopened tins).</p>																	
<p>Remarks:</p>	<p>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.</p>																	
<p>Warnings:</p>	<p>Do not pour ready for use product into container with unreduced one.</p>																	
<p>Packaging: Size Case Quantity</p>	<p>1L , 3.5L 3 , 2</p>																	