

# ALPHAGAM

## TECHNICAL DATA SHEET

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PRIMER

**BC Metallic Colors**  
**Aluminum | Pearl | Xirallic**

## BASECOAT

2 - STAGE METALLIC COLORS  
(Aluminum/Pearl/Xirallic)

### PRODUCT INFO

Single component metallic colors and pearl effect, made from weather resistant resins, featuring high quality, strong hiding power, and excellent adhesion power. Also used for repairing automotive 2 and 3- stage finishes.

#### TECHNICAL CHARACTERISTICS

Colour : Mixing System

Approx Coverage: 10 - 12 m<sup>2</sup>/l (avg) at 15 - 20 µm DFT

### PRE - TREATMENT

Apply basecoat over original stoved finishes or over APP10004 **2K PU Primer Surfacer** & APP10024 **2K Epoxy Primer**.

- Dry disc P320-400 grade paper or Wet flat with P600-800 grade paper .
- Wash off residues and dry thoroughly.
- Clean with ATN10007 Silicon remover degreaser. The use of a tack 0 rag is recommended.



### Application Method

Application method	Pressure/bar	Nozzle/mm	Spray Passes	Thinner (%)
HVLP gravity-feed spraygun	2 - 2.5	1.3 - 1.4	2 - 3	100
Conventional gravity-feed spraygun	2 - 2.5	1.3 - 1.4	2 - 3	100

This data sheet is for information purpose only. To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant precautions stated on the product label. We reserve our right to make additions, deletions or modifications to the information at any time without prior notification.

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Number of Spraycoats : 1 thin + 1 wet coat + 1mist coat to match effect.



**Pot life :**  
24 h @ 30 °C



**Hardener :**  
NA



**Thinner :**  
Basecoat Thinner




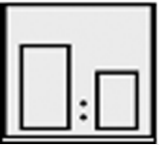

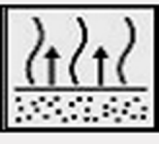

**Drying time :**

Object temperature	Dust Dry/min	Set to touch	Ready for assembly	Sandable	Recoatable
30°C	10 - 15 min	20 min	NA	NA	24 h

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## Technical Information

	<b>Colour :</b> <b>Mixing System</b>
	<b>Mixing Ratio :</b> <b>1:1</b>
	<b>Spraying Viscosity :</b> <b>16 - 18 s 4mm DIN</b>
	<b>Flash Off Time :</b> <b>5 – 10 min. between each coat.</b> <b>Note: Before mist coat, enlarge the spray fan and adjust spraying pressure &amp; distance should be:</b> <b>2 bar (HVLP) @ 10 - 15 cm</b> <b>3.5 bar (conventional) @ 20 - 25 cm</b>
	<b>Dry Coat Thickness :</b> <b>15 - 20 µm</b>

<b>Storage :</b>	<b>1year from the date of manufacturing at 30°C,if stored in a dark dry place in a tightly closed container.</b>
<b>VOC Regulation :</b>	–
<b>Processing Conditions :</b>	<b>From +10°C and up to 80% relative air humidity.</b> <b>Ensure an adequate air ventilation.</b>

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