

Basecoat WB GT E-Line

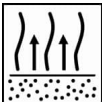
Basecoats

24/04/2024

L1.09.05

DESCRIPTION

Basecoat WB GT E-line is a VOC compliant 380 grams/liter waterborne basecoat system with the latest technology. Available in a wide variety of effect colors including metallic, pearls and solids. Specifically designed for the refinishing of passenger cars, but also suitable for refinishing of light commercial vehicles. A full range of ancillary products enables the product to be used successfully on a wide variety of jobs, in most types of application.

		Gently shake each Basecoat WB GT toner prior to use	
Mixing ratio		RFU	Basecoat WB GT
Mixing stick		At high temperatures / low humidity : Lesonal Activator WB: up to 40%	
Equipment		Spray gun set up: 1.3-1.4 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap
Application		Solids colors 2 x 1 layer *Alternative method: No flash off needed between 1 st and 2 nd layer	Metallic colors 2 x 1 layer + mist coat (please read the application process information explained in this tds)
Flash-off		Between coats Until completely matt	Before clearcoat Until completely matt
Recoatability		All Lesonal clearcoats	
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator	

Read complete technical data sheet for detailed product information

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PRODUCT AND ADDITIVES

Product	Basecoat WB GT Basecoat WB GT 06-E	
Thinner/Hardener (optional)	Activator WB Hardener WB	
Chemical Basis	Basecoat WB GT	Physical drying binders

METHOD OF USE

Substrates	Original finishes, including thermoplastic acrylic All current Lesonal preparatory products with the exception of etch/wash primers Note: All Basecoat WB GT SEC colors except SEC2322 must be applied on 2K Graphite Filler Black, 2K Filler 540 Black, Basecoat WB GT MM 23 Black or fully cured and sanded Black single stage topcoat. Basecoat WB GT SEC2322 (NIS AV2) should be applied over color NIS1052.
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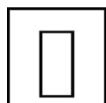
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Substrate preparation Thoroughly clean the surface with Lesonal Degreaser.
Sand with P500 grit dry.
Degrease with Lesonal Degreaser.

Mixing ratio



RFU Basecoat WB GT

For optimum pour viscosity, gently shake Basecoat WB GT / MM06-E before use.
To avoid overspray when painting larger objects or in warmer conditions / lower humidity,
Activator WB can be added up to a maximum of 40%.

Spraying viscosity 25-35 sec. DIN Cup 4 at 20°C

Potlife	All colors	3 months at 20°C
	Basecoat WB GT 308NA, NB, ND metallic colors	1 week at 20°C
	Basecoat WB GT 308NA, NB, ND metallic colors containing MM05	1 day at 20°C

Spray gun set up



Spray gun:
HVLV Gravity
LVLV/HR Gravity

Fluid opening:
1.3-1.4 mm
1.3-1.4 mm

Spraying pressure:
0.7 bar (at air cap)
1.7-2.2 bar (at air inlet)

Refer to user manual spray gun used

APPLICATION TECHNIQUE

Application



Metallic and pearl colors
Apply one single wet coat. Allow flash off until the coat is completely matt.

Apply a following lighter coat and allow to flash off until the coat is completely matt.
When covering is achieved, finish with a mist coat layer by increasing the distance to the object.

Alternative Method:

Apply a closed wet layer followed directly by a light wet layer wet-on-wet without the need to flash-off between each layer. Increase the airflow and heat until the basecoat completely dries to a matt finish. Allow the surface to cool prior to applying a controlled drop coat.

For optimal metallic orientation increase the distance of the spraygun to 30 cm.

Note: It is strongly recommended to produce a sprayout sample to check the colour accuracy prior to completing the repair.

At force drying using windjets, keep a minimum distance of 1 meter.

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Solid colors

Apply one full single coat. Allow flash off until completely matt.

Apply another single coat and allow to flash off until completely matt.

If needed, repeat until covering is achieved.

Alternative Application Method

Apply 2 single layers wet-on-wet or until opacity is achieved without the need to flash-off in-between each layer. Increase the airflow and heat until the basecoat completely dries to a matt finish. Allow the surface to cool prior to clearcoat application.

Note: It is strongly recommended to produce a sprayout sample to check the colour accuracy prior to completing the repair.

At force drying using windjets, keep a minimum distance of 1 meter.

Application



Spot repairs / Fade out areas

When making spot repairs use lower application pressure and apply thin coats until opacity is achieved.

Dry until matt after each coat before fading out well beyond the edges.

In case of metallic colors apply a mist coat when needed by increasing the spray gun distance

Note:

Fade out of Basecoat WB GT can be done on:

- Existing finishes, prepared according to TDS L8.01.01
- A wet or dry coat of MM02
- A dried coat of pure MM06-E

Working time can be reduced by acceleration of the air speed, by using dry-jets, positioned at a minimum distance of 1 meter from the object.

Note

While making a spot repair, it's not necessary to tag-rag between coats.

- If a pure Basecoat WB GT metallic tinter will be applied, always mix:
55% Basecoat WB GT metallic with 45% tinter MM06-E
- Clean spray gun with Lesonal Guncleaner WB directly after use

Equipment cleaning

Use Lesonal Guncleaner WB

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Layer thickness	10 - 25 microns	
Material usage	Ready for use mixture at 1 µm layer thickness:	167 m ² /liter
	The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances	
Recoatability	Basecoat WB GT E-Line can be recoated with all Lesonal clearcoats* When recoated with Ultra Air Clear* it is mandatory to add 5% Hardener WB to the: -Basecoat WB GT E-line -Pre-coat / Wet Bed* *Please refer to the 2K Ultra Air Clear TDS L1.05.29	
Product storage	Avoid too much temperature fluctuation. o For optimal performance, store opened products at application temperature o Maximum transport and storage temperatures between 3°C-35°C. o Frost causes gelling / lumps in Basecoat WB GT toners after which they no longer can be used.	
Shelf life	See TDS L9.01.02	
VOC	2004/42/IIB(d)(420)380 The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/l VOC. The VOC content of this product in ready to use form is max. 380 g/liter.	

FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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