

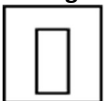


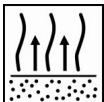
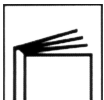


Basecoat SB 308SA Argentum

Programmed System Technique (PST)
Basecoat
05/24/19

DESCRIPTION

Basecoat SB Argentum is a special effect color in the Lesonal solvent borne two-stage paint system. It is a leafing metallic flake that provides an appearance different from typical metallic effects. Having a look similar to anodized aluminum, it may be used in color formulas or as a special effect when applied according to the technical data sheet. SB Argentum must be used in conjunction with a Lesonal low VOC clearcoat to ensure regulatory compliance

Safety Considerations 	Use suitable personal protection When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator	
Foundation Color 	<ul style="list-style-type: none">To achieve the proper reflective appearance, Basecoat SB Argentum 308SA requires application over a foundation of Lesonal Basecoat SB 23 Deep Black.<ul style="list-style-type: none">SB 23 must be mixed with 10% hardener by volume, using the same LV clear hardener intended for use in the clearcoat layer.Mix components well and reduce 100 parts of this mixture with 50 parts Lesonal SB reducer by volume.This foundation color application must be completely smooth and free of surface imperfections prior to the application of the 308SA Argentum.<ul style="list-style-type: none">Surface defects, even minuscule ones, will negatively affect the appearance of the special leafing metal.✓ Refer to the product TDS for information regarding other foundation layer options.	
Mixing 	<ul style="list-style-type: none">Lesonal Basecoat SB 308SA Argentum is ready to spray and requires no further mixing or reduction.Stir thoroughly before each use.	
Equipment 	Spray gun set up: <ul style="list-style-type: none">1.2 – 1.4 mm HVLP Gravity1.2 – 1.4 mm Compliant Gravity	Application pressure: <ul style="list-style-type: none">HVLP – 10 psi (0.68 bar) at cap maximum.Consult manufacturer specifications.
Application 	<ul style="list-style-type: none">2 – 3 thin coats	
Flash-off 	Flash Between Coats at 70°F (21°C) <ul style="list-style-type: none">4 – 8 minutes.	Flash at 70°F (21°C) Before Clearcoat <ul style="list-style-type: none">15 – 20 minutes.
Recoatable With 	<ul style="list-style-type: none">Lesonal Pro Air LV 2-PackLesonal Universal EcoClear LV 2-Pack<ul style="list-style-type: none">To maintain VOC in National Rule areas, a Lesonal LV clearcoat must be used.	

Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information

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PRODUCT AND ADDITIVES

Product	• Basecoat SB MM (Mixing Machine) toners	– Mixed to specification
	• SB MM308SA SEC Silver Argentum 1.0L	– Item # 551544
	✓ Lesonal MM308SA is used in several new OEM color formulas. When it is part of an OEM formula, mixing including normal Basecoat SB reduction and advice on primer colors should be followed.	
	✓ If used as a color by itself, MM308SA should be applied over a very smooth black foundation. Lesonal Primer Pro Black, Primer Pro LV Black or Basecoat SB MM23 Deep Black is suggested for the foundation.	

Hardeners	• Universal EcoClear LV Hardener	– Item # 553387
	• Pro Air Clear LV 2 Pack Hardener	– Item # 516522

Reducer	– Basecoat SB MM308SA Argentum is ready to spray and requires no further reduction.
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Additives	• Basecoat SB Blending Additive	– Item # 390166
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○ SDS and TDS for products available online at – <http://my.anaac.net/>

METHOD OF USE

Suitable substrates	• Lesonal Primer Pro Black	• Existing finishes
	• Lesonal Primer Pro LV Black	
	• Lesonal SB MM23 Deep Black	
	• Lesonal Basecoat SB Blending Additive	
	○ Do not apply over thermoplastic acrylic lacquers.	
	○ Do not apply directly over acid containing washprimers or pre-treatments.	
	Using sealer mixtures which contain Lesonal Flex will aid in ensuring a suitably smooth surface.	

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Basic Raw Materials



- Lesonal Basecoat SB – Physically drying binders

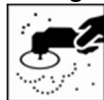
Substrate preparation



Pre-cleaning

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with Lesonal Surface Cleaner, AutoPrep Ultra-Prep (VOC compliant) or Plastic Surface Cleaner.

Sanding Preparation



- For overall application, sand as normal for primer sealer application, P400 dry machine sanding.
- If in a repair situation –
 - Prepare the repair area with black primer surfacer and final sand it with P600 dry by machine.
 - Sand the color blend and clearcoat area with P1000 dry or with a Grey Scotch Brite pad.

Surface Cleaning – Prior to Paint Application



- Clean with Lesonal Surface Cleaner, AutoPrep Ultra-Prep (VOC compliant) or Plastic Surface Cleaner.

Product Agitation



MM308SA Argentum Prep and Use

- Shake paint on a vigorously for 5 minutes before first use.
- Since MM308SA is a metallic color, also stir the color before first use.

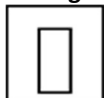
Mixing Color Formulas and Products



Formulas

- Current formulas using MM308SA are available to match the most popular OEM colors requiring its use. These are available on Mixit Cloud or Mixit-Pro Color Manager.
 - If a specified primer color is shown, ensure that shade of Primer Pro LV or Primer Pro is used.
 - When OEM colors containing MM308SA are used, follow the normal reduction for Basecoat SB.

Mixing



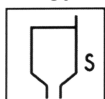
MM308 SA Argentum Mixing –

- When used over the black foundation, Basecoat SB MM308SA Argentum is ready to spray and requires no further reduction. Simply stir thoroughly before each use.

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Viscosity When Mixed **12-18 sec.** Measured with a DIN #4 viscosity cup at 70°F (21°C).



Pot-life when Mixed



Product Mix

70°F (21°C)

- Basecoat SB MM308SA Argentum – 6 months
- Foundation Coat – 4 hours

Spray Gun Set-up



Consult spray gun manufacturer instructions for pressure specifications

Spray Gun

Fluid Tip

Application Pressure

- HVLP Gravity Feed 1.2 – 1.4mm <10 psi (0.68 bar) at cap.
- Compliant Gravity Feed 1.2 – 1.4mm psi per spray gun manufacturer.

308SA Argentum Application Points to Consider



- The fine texture and thin coating created during the application of leafing metallic such as MM308SA make care in preparation and application very important.
 - Normal sanding grits are too coarse for direct application of these leafing metallic colors. Follow the preparation recommendations for these colors closely.
 - Any stray sand scratches, dust or surface imperfections will spoil the appearance of these types of leafing metallic colors and must be avoided. It is not possible to sand flaws out once the argentum application process begins.
- Argentum is affected by application variables. Create test panels ahead of time to assess what application is required for the desired effect appearance.

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APPLICATION TECHNIQUE

Foundation Color for Overall Application



- Apply Primer Pro Sealer according to product TDS specifications and make sure that the surface is completely smooth. Using sealer mixtures that contain Lesonal Flex Additive will aid in ensuring a suitably smooth surface.
 - For spot repairs dissolve overspray with the appropriate Lesonal Blending Solvent.
- Alternately, Basecoat SB MM23 Deep Black may be used as the foundation color. Mix with slower solvents in the normal ratio for a smoother application.
 - Flash for 15-20 minutes before applying the MM308SA Argentum.

Basecoat SB Argentum Overall Application



- First apply one single thin coat and flash 4 – 8 minutes.
 - Tack the entire application area between coats.
- Continue application with single coats until the desired effect is achieved.
 - Do not apply these coats too wet, maximum 70% wetness with each coat, spraying distance should be at least 12 inches.
- Argentum effect is influenced by application –
 - Less fluid or more air pressure creates a brighter appearance.
 - More fluid or lower air pressure produces a darker appearance.
 - Fewer coats form a coarser appearance.
 - More coats build a finer appearance.

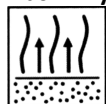
Basecoat SB Argentum Spot Repair (Blending)



- Create and use test panels before application to determine the right air-pressure, fluid delivery and number of coats.
- Basecoat SB Blending Additive must be used as a clear foundation coat before commencing argentum spot repairs. Apply one thin smooth coat of this blending foundation to allow for suitable argentum leafing and orientation. Allow the Blending Additive to flash before applying the Argentum color.
- When making spot repairs apply thin color coats until effect is achieved using an “outside-in” application. Do not flare or flip the spray-gun at the end of the gun stroke.
- Flash between each coat and tack the entire repair.

DRYING / CURING TIME

Flash-Drying



Flash Between Coats at 70°F (21°C)

- 4 – 8 minutes.
 - Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.

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Drying / Curing Time



- Allow Basecoat SB to dry for a minimum of 15 – 20 minutes at 70°F (20°C) before applying the clearcoat.
- Drying times are stated at recommended application method, film thickness and object temperature.
- The maximum time Basecoat SB may be left before clear is 24 hours. After 24 hours the surface must be abraded.

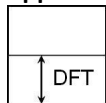
Recoating



Recoatable With:

- Lesonal Universal Eco Clear LV
- Lesonal Pro Air Clear LV 2 Pack
 - To maintain VOC in National Rule areas, a Lesonal LV clearcoat must be used.

Film Thickness – Using Suitable Application



- Basecoat SB solid, metallic and pearl colors: 0.4 - 0.9 mils (10-20µm) per coat.
- Basecoat SB MM308SA Argentum 0.1 - 0.2 (.25-.5µm) mils per coat.
- The total dry layer thickness of Basecoat SB should not exceed 1.2 mils (30µm).

ADDITIONAL INFORMATION

Cleaning of Equipment



- Clean equipment and dispose of waste following local and federal regulations. In compliant localities, use a VOC compliant high quality solvent borne gun cleaner. For national rule regions, a use high quality lacquer thinner.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

Theoretical Coverage



- With the recommended application the theoretical material usage at a 1 mil thickness (25.4 µm)
 - Foundation Layer: ± 216.9 feet²/gallon (5.3m²/liter)
 - Midcoat Layer (308SA): ± 44.5 feet²/gallon (1.1m²/liter)
- Actual coverage is dependent on many factors which may include the shape of the object, surface smoothness, application technique, among others.

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VOC / Regulatory Information



Foundation Layer Ready to Spray VOC:

- Lesonal SB MM23 mixed with 10% Universal EcoClear LV Hardener
- Lesonal SB MM23 mixed with 10% Pro Air Clear LV 2 Pack Hardener

VOC Lbs/Gal

– 6.45

– 6.40

VOC g/L

– 775

– 768

Midcoat Layer (As Supplied) VOC:

- Basecoat SB MM308SA Argentum

– 7.67

– 920

- ✓ Basecoat SB MM308SA Argentum is not compliant in regulated markets. In National Rule areas, Basecoat SB MM308SA Argentum can only be used in combination with the low VOC clearcoats listed within this document.
- Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

Product Storage



- Item unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C)

- Lesonal Basecoat SB MM308SA 4 Years (unopened)

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FOR PROFESSIONAL USE ONLY

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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