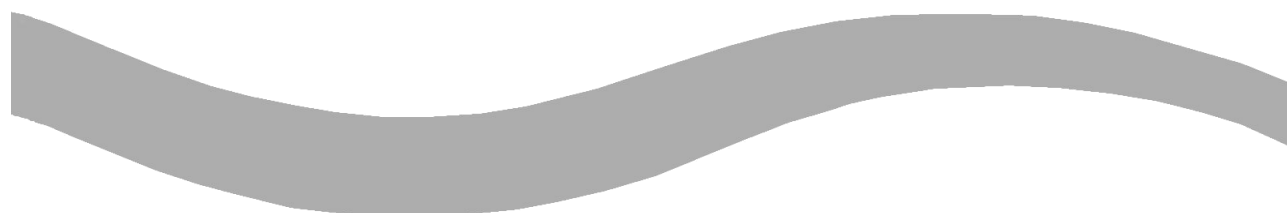




Stadox Basislack Basecoat

- **Stadox MSB System**
- **Outstanding colour accuracy**
- **Outstanding filling properties**
- **Good opacity**
- **Easy to blend in**
- **Solid, metallic, pearl colours**



Technical Description:

- Mix with 50-60% Stadox MSB Thinner
- 2 Spray passes
- 10-15 min / 18-22°C

Stadox Basecoat

Substrate:

- Through-hardened sanded paintwork
- Stadox 1K Primer
- Stadox Filler

Pretreatment / Cleaning:

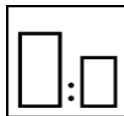


For substrate preparation information see Stadox Painting System S1.



Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

Application:



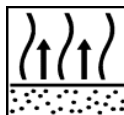
50-60% Stadox MSB Thinner
20-22 s / DIN 4 mm / 20°C
53-61 s / ISO 4 mm / 20°C



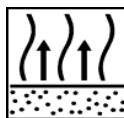
Compliant 1.2 - 1.4 mm
2.0 - 2.5 bar inlet pressure
2 = 15 - 25 micron



HVLP 1.2 - 1.4 mm
0.7 bar atomization pressure
2 = 15 - 25 micron



5 min / 18-22°C
intermediate flash off



10-15 min / 18-22°C
final flash-off



Standocryl 2K Clears /
Standocryl VOC HS Clear 9520 and
Standocryl VOC 2K Clear

Stadox Basecoat

Flash point:

- 23 - 25°C / 73.4 - 77°F

Specific Gravity:

- 0.93 - 1.15 g/cm³

Solid Content

(without thinner added):

- 15.8 - 41.8 Weight %
- 11.9 - 23.7 Volume %

Theoretical

Coverage:

- 7.1 - 8.9 m²/l at 25 micron dry film thickness

Cleaning of equipment:

Clean after use with Stadox Cleaning Thinner.

Important remarks:

- The masking of Stadox Basecoats is possible after 45-60 min/ 18-22°C or after oven drying. Hardened Stadox Basecoats should be masked only after oven drying.
- For Stadox Basecoat Real Black see technical data sheet 614.

HS System:

- For 3-stage plastic painting structured (hard plastics) (see Stadox painting system S7.3) mix Stadox Basecoat with 15% Stadox HS Hardener and 40% Stadox MSB Thinner (2 Spray passes).
Drying: 20 min/60-65°C or 2 h/18-22°C
- For higher film thicknesses, above 40 micron (e.g. multi colour systems), mix Stadox Basecoat with 15% Stadox HS Hardener and add 40% Stadox MSB Thinner. Allow longer flash off.

VOC System:

For 3-stage plastic painting structured (hard plastics) (see Stadox painting system S7.3) mix Stadox Basecoat with 10% Stadox VOC Hardener and 45% Stadox MSB Thinner (2 Spray passes).
Drying: 20 min/60-65°C or 2 h/18-22°C

For higher film thicknesses, above 40 micron (e.g. multi colour systems), mix Stadox Basecoat with 10% Stadox VOC Hardener and 45% Stadox MSB Thinner. Allow longer flash off.

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