



Technical Data Sheet

WHEELKOTE BASECOAT COLORS

DESCRIPTION: Wheelkote Basecoat Color system provides an environmentally friendly and economical solvent solution. The basecoat system is a cost-effective color system providing high performance, fast coverage, outstanding dry times, excellent metallic control, simple to mix, easy to apply and easily repairable.
 *Stir thoroughly to assure proper mixing
 *WK Basecoat Must Be Clear Coated

PRODUCT & ADDITIVES:	PRODUCT	ITEM #	SIZE
	Wheelkote Basecoat Color	Various	Various
	Fast Reducer	161003/161004	Qt/Gal
	Medium Reducer	161008/161009	Qt/Gal
	Slow Reducer	161013/161014	Qt/Gal
	Extra Slow Reducer	161018/161019	Qt/Gal
	*See Application (Reman) for Basecoat Activator recommendations.		
	*Basecoat Activator	162105	½ Pint

COMPATIBLE SUBSTRATES: DTA Foundation Coating / 1K Primers / Grey or Black 2K Epoxy Primers / Properly prepared OEM finishes / previously painted surfaces / properly prepped surfaces that have been finish sanded with P400-P600 grit, cleaned, degreased and tacked.

NOTE: Do not use over Self Etching Primers, wash primers that contain acid activators, directly to pretreated substrate, or over bare aluminum.

SAFETY ASPECTS: Users should review the Safety Data Sheet (SDS) and product label for the material to be used to determine possible health hazards, appropriate engineering controls and precautions to be observed in the use of the material. Copies of the SDS and product label are available upon request.



MIXING RATIOS:

	MOBILE REPAIR = MIX 100:50-100
	100 parts WK Basecoat Color
	50-100 parts Reducer (Speed depending on current temperature)
	REMAN SHOP = MIX 100:5:50-60 (See Application (Reman): notes)
	100 parts WK Basecoat Color
	5 parts Basecoat Activator
	50-60 parts Reducer (Speed depending on current temperature)

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POTLIFE: 5 hrs@70°F/21°C with Basecoat Activator

GUN SETUP:



TYPE	FLUID TIP	SPRAYING PRESSURE
Conventional Gravity	1.2 mm – 1.4 mm	30 - 35 psi @ gun
HVLP Gravity	1.2 mm – 1.4 mm	10 psi @ cap

APPLICATION: Apply single medium wet coats, allow 3-5 minutes flash. Apply another medium wet coat, allow 3-5 mins flash. Check for opacity and/or light areas, if needed apply one more medium wet coat. As soon as hiding has been achieved an orientation coat may be applied if needed. Allow a flash time of 10-15 minutes@70°F/ 21°C prior to applying clear coat.

APPLICATION (Reman): When applying powder clears over the Wheelkote color, it is recommended to use 5% Basecoat Activator within the basecoat color (see mixing section). This will assist in reducing the majority, if not all, of color shifting possibilities. It also assists with adhesion properties between undercoat and topcoat.

FLASH TIMES: Allow 3-5 minutes between coats @ 70°F/21°C.

FINAL FLASH: Allow 10-15 minutes @ 70°F/ 21°C before applying clear coat.

DRYING TIMES:



METAL TEMP	FLASH TIME	DRY TO HANDLE	DRY
@ 70°F/ 21°C	3-5 minutes	3-5 minutes	5-10 minutes

RECOATABILITY: WK basecoat can be recoated with itself up to 24 hours before without sanding, if it has not been clear coated.

FILM THICKNESS: Approximately 0.2-0.5 mils per single coat.

CLEANING EQUIPMENT Clean equipment immediately with GC-03 Lacquer Thinner.

THEORETICAL COVERAGE: Theoretical coverage is dependent of many factors. These may include, the shape of the object, surface smoothness, application technique and other application variables among others.



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TECHNICAL DATA:



Color	Variable
Activator/Hardener	Basecoat Activator
Mix Ratio	Mobile Repair = 100:50-100 (Basecoat + Reducer) Reman Shop = 100:5:50-60 (Basecoat + Basecoat Activator +Reducer)
Reducer	Various Temp Reducer
Additives	N/A
Number of Coats	1-2 medium wet coats + orientation coat
Flash Time	3 -5 minutes between coats
Final Flash Time	10 -15 minutes prior to clearcoat
Dry Time	Refer to table on page 2
Gun Set-Up	Refer to Table on Page 2
Air Pressure @ Gun	Refer to Table on Page 2
Sprayable V.O.C.	6.5 lbs/gal 780g/liter
Package Size	Pints / Quarts
Shelf Life	12 months unopened

All data given below are MAXIMUM THEORETICAL VALUES based on the product AS CURRENTLY FORMULATED. Variations may occur on individual batches due to adjustments made during production.

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