

TECHNICAL INFORMATION

KLASS BASE COAT

509-32800-000



DESCRIPTION



Two-layer automotive finish with high hiding power and excellent accommodation of metallic and mica particles. Due to its wide range of hues, it allows for an easier color matching.



Containers ¼ Gallon, 1 gallon

Available Colors Wide range of basic colors and shades.

SURFACE PREPARATION



Before application, surface must be free of dust, grease, oil, waxes or any other contaminants that can affect product adherence.



| SUBSTRATE | FIRST CLEANING | SANDING | AFTER CLEANING | ADHERENCE ENHANCER |
|-----------|----------------|---------|----------------|--------------------|
|-----------|----------------|---------|----------------|--------------------|



| | | | | |
|------|-----------|-------------------|-----------|----------------------|
| Iron | 330 – 900 | 180–220/P180–P220 | 330 – 900 | Klass Etching Primer |
|------|-----------|-------------------|-----------|----------------------|

| | | | | |
|----------|-----------|-------------------|-----------|----------------------|
| Aluminum | 330 – 900 | 180–220/P180–P220 | 330 – 900 | Klass Etching Primer |
|----------|-----------|-------------------|-----------|----------------------|

| | | | | |
|-----------------|-----------|------------|-----------|----------------------|
| Galvanized iron | 330 – 900 | Gray Fiber | 330 – 900 | Klass Etching Primer |
|-----------------|-----------|------------|-----------|----------------------|

| | | | | |
|------------|-----------|-------------------|-----------|---------------------------|
| OEM Finish | 330 – 900 | 220–320/P220–P400 | 330 – 900 | Klass Primer Filler 3 + 1 |
|------------|-----------|-------------------|-----------|---------------------------|

| | | | | |
|------------------|-----------|-------------|-----------|---------------------------|
| Replacement Part | 330 – 900 | Gray Sponge | 325 – 900 | Klass Primer Filler 3 + 1 |
|------------------|-----------|-------------|-----------|---------------------------|

| | | | | |
|-------------------|-----|-----------|-----|----------------------|
| Paintable Plastic | N/A | Red Fiber | N/A | Klass Plastic Primer |
|-------------------|-----|-----------|-----|----------------------|

INGREDIENTS AND MIXING RATIOS



Add only the recommended components. Use KLASS measuring rule for a correct mix.



| MIXING RATIO | HARDENER | DILUENT |
|--------------|----------|---------|
| Product | 100 | 476– |
| | Parts | 900 |
| Hardener | 50 Parts | |



These technical data were calculated under controlled laboratory conditions, but SUR QUIMICA has no control over conditions, tools, applicator skills, selection, preparation, or compatibility of products used; therefore, can only guarantee this product quality, its features and qualities' suitability, but is not responsible for the results obtained in conditions impossible to check once the job has been done. SUR QUIMICA has made reasonable efforts to ensure the accuracy of the information provided here, but assumes no responsibility for any error, omission, or inaccuracy in it. If there is any inconsistency between different language issues of this document, Spanish version will prevail.

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Mix ratio 2:1N/A

Application Viscosity 18-22 seconds, Pot Life Undefined
DIN Cup #4

APPLICATION EQUIPMENT



For better results, use recommended nozzle size and pressure.



| Air Spray | Nozzle | Pressure (PSI) |
|---------------------------|-------------|----------------------|
| Conventional Suction Feed | 1.4mm | 45 - 50 |
| Standard Gravity Feed | 1.4 - 1.5mm | 40 - 45 |
| Gravity Feed HVLP | 1.3mm | 50 input (10 output) |

Follow equipment manufacturer's recommendations and test before application.

PRODUCT APPLICATION



| Number of coats | Time Between Coats | Dry Film Thickness |
|-----------------|----------------------------------|--------------------|
| 2 - 3 | 7 minutes (or until matt finish) | 1.0 - 1.5 mils |



Comments: Respect curing time between coats and do not exceed recommended thickness.

Drying Times



Data measured at 20°C (68°F). In case of contamination, lightly sand two-layer with #600 grit wet and reapply.



| Drying | TIME | Forced drying | TIME |
|-------------------------|-----------------|----------------------|------|
| Dust dry | 7 min | Oven @ 60°C: | N/A |
| Touch Dry | 25 minutes | Medium wave infrared | N/A |
| Dry-to-sand | N/A | Short wave infrared | N/A |
| Before the next product | 25 - 30 minutes | | |
| Dry to retouch | 10 - 15 minutes | | |

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SANDING

|  | SANDING METHOD | # GRIT | FEPA GRIT |
|---|--------------------|--------|-----------|
|  | Wet sand by hand | N/A | N/A |
|  | Dry sand by hand | N/A | N/A |
| | Power sanding, dry | N/A | N/A |

* In case of contamination, lightly sand two-layer with #600 grit wet.

OBSERVATIONS

VOC range is (363 – 733) g / L depending on color.

Do not use air to force drying this product.

Apply this product only over Klass line primers.

The accommodation of aluminum and mica particles is highly dependent on the condition and calibration of the application equipment.

Use an antistatic towel between two-layer coats and before applying the transparent, to remove particles that could affect the subsequent adhesion.

STORAGE, HEALTH AND SAFETY



Keep this product stored for a short period, in dry environment, between 50°F and 95°F.
• Read and understand all safety instructions on label.



Never add another components than those indicated on this sheet. Doing so may affect its performance and voids all warranties.



If you need more information, one of our technicians will assist you. Call 800-SUR-2000 or email us at customerservice@gruposur.com

This a professional/industrial product and it should be applied by properly trained personnel, wearing appropriate Personal Protection Equipment (PPE), as described in its Safety data Sheet (MSDS), available at <http://www.gruposur.com>

Do not use this product near sources of ignition, such as sparks or equipment with high temperatures.

Do not smoke during use. Use in a well aired area.

Dispose of waste in accordance with local laws and regulations.

If you need to dispose of empty containers of our products in Costa Rica, contact your SUR Color paint store or our industrial compound in La Uruca, San Jose.

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