

3.5 VOC Intermix System Basecoats Normal Solids

Technical Support: 1-800-776-0933

Product Description Prospray 3.5 VOC Basecoat utilizes existing Prospray solvent toners and a special system of thinners and binders to provide a VOC compliant solvent basecoat that is durable, easy to use and easy to apply.

Components



Basecoat 3.5 VOC Basecoat Color (mixed)
Thinner PCR-1463™ (Normal) or PCR-1464 (Slow)™ Thinner

NOTE: These thinners are designed specifically for use with the Normal Solids Prospray color formulas only. Use of these thinners in any other low VOC Prospray product will cause the VOC's to be over the threshold limit.

Typical Substrates

- Prospray 2.1 VOC Sealers
- Prospray 2.1 VOC Primers
- 2.1 VOC DTM Primers
- 2.1 VOC Epoxy Primers

Surface Preparation



Finish sand with P600–P800. Clean area with ICR-0020™ and dry thoroughly. Use of Prospray 2K A-540™ (Gray) or A-542™ (White) Sealer (Low VOC mix ratio option) is recommended.

Mix Ratio

Basecoat 1 Part
Thinner 1 Part

NOTE: up to 5% activator added to the ready to spray base coat is recommended to increase durability.

Pot Life @ 72°F / 22.2°C



4 hours when activated.

Viscosity @ 72°F / 22.2°C

14–15 secs DIN4

Gun Set Up



High Efficiency 1.2 mm–1.4 mm
HVLP 1.2 mm–1.4 mm

Air Pressure



High Efficiency 15–29 psi @ the gun
HVLP 6–10 psi max @ the cap

NOTE: Refer to individual gun manufacturer for proper spray gun setting.

Application



- Apply medium coats until full coverage is achieved.
- Allow 5–15 minutes flash between coats.
- Use of drop coats on metallics is acceptable.

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Dry Times to Clear @ 72°F / 22.2°C



Flash	5–15 minutes between coats, 20–25 minutes before clear application
Baking	N/A
Short Wave	N/A

Sanding



Dry & D.A.:	N/A
Water Sanding:	N/A

Recoat

- Before clearcoating, air dry at 72°F/22.2°C for 20–25 minutes until uniformly dry.
- Apply clearcoat within 8 hours.

Topcoats

When dry, topcoat with:

- Prospray Low VOC Clearcoats

Special Notes / Clean Up



Clean Up Clean equipment after use with a VOC compliant cleaning solvent. Dispose of solvent according to state, local and federal regulations.

Important! Shake all new toners for a minimum of five minutes before inserting mixing lid and placing on machine.

Physical Data

VOC (RTS) per U.S. Gal	3.5 lbs (maximum)
Recommended Dry Film Thickness	1.0–1.5 mils

Health and Safety



For professional use only. KEEP OUT OF REACH OF CHILDREN. WARNING! CONTENTS ARE FLAMMABLE. VAPOR AND SPRAY MIST IS HARMFUL. SKIN AND EYE IRRITANT.

Do not handle the Prospray products until the Safety Data Sheets have been read and understood in their entirety. Ensure that all employees are trained on using the Safety Data Sheets and all chemicals with which they come into contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist. Wear protective clothing, gloves and eye safety with a side shield.

This data sheet information is given in good faith but without warranty. The information contained herein represents the current state of our knowledge and is intended as a guide to our products and their uses; it is not intended for insurance of certain product properties or of their specific applications.

Follow all warnings on product labels.