## Product Data Sheet

**DURACERAM®**

**Basecoat**

<table>
<thead>
<tr>
<th>Product</th>
<th>Basecoat Component A</th>
<th>Basecoat Component B</th>
<th>Catalyst C</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Code</strong></td>
<td>CB100528-1(A)</td>
<td>CB100528-1(B)</td>
<td>CB100528-1(C)</td>
</tr>
<tr>
<td><strong>Viscosity</strong></td>
<td>9±1 second Iwata#2 @ 25°C</td>
<td>8±1 second Iwata#2 @ 25°C</td>
<td></td>
</tr>
<tr>
<td><strong>Wt. Solids</strong></td>
<td>52±2%</td>
<td>N/A</td>
<td>N/A</td>
</tr>
<tr>
<td><strong>Mixing Ratio</strong></td>
<td>A:B:C = 68.47 : 27.68 : 4.45</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Mixing Speed/Time</strong></td>
<td>Add Component C into Component A. Mix 15-30 min then Add Component B into A+C. Mix @ 160-180 rpm for 24 hours. After mixing, initial 3 hours, maintain the material temperature between 30~35°C.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Density</strong></td>
<td>1.34±0.04 kg/L</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Total Wt. Solids (A+B+C)</strong></td>
<td>40±2%</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Total Vol. Solids (A+B+C)</strong></td>
<td>30±2%</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Theoretical Coverage</strong></td>
<td>11.47m²/kg at 12 micron</td>
<td></td>
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</tr>
</tbody>
</table>

**Application Parameter**

To ensure superior finished quality, it is of crucial importance that the surface be thoroughly cleaned, removing all surface particles including sand, grease and cleaning solutions.

**Substrate**

Aluminum or Stainless steel

**Substrate Preparation**

Grit blast with 60-80 mesh Ra=2.5-4.0 microns. (Pre-heat the substrate 50-60°C while spraying the coating.)

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**HEALTH AND SAFETY PRECAUTIONS:** As with any coatings material care should be exercised when using this product. The vapor may be harmful and may cause irritations. Adequate ventilation should be provided and breathing of the vapor or mist should be avoided. The use of an appropriate respirator is recommended. Avoid contact with eyes or skin, and never take internally. Keep, away from heat., sparks or flames. Keep container tightly closed. Comply with all local safety disposal and transportation regulations. Refer to the Material Safety Data Sheet (MSDS) for additional Health, Safety and Environmental Information.

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**Preparation of Coating**

It is very important that the product is well mixed and homogeneous. It must be adequately dispersed at room temperature prior to use.

First mix the component C into Component A. Then add Component B into (A+C) in recommended ratio in clean container. Put the container on roller for 24 hours for mixing. After mixing for 24 hours adjust the viscosity by recommended thinners.

All the product are filtered before shipping however further filtration through an appropriate mesh may be required to reduce the contamination.

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**Filter mesh**

<table>
<thead>
<tr>
<th>Mesh</th>
</tr>
</thead>
<tbody>
<tr>
<td>100 mesh</td>
</tr>
</tbody>
</table>

**Application**

Conventional spray

**Dry Film Thickness**

12-14 per coat recommended.

**Applied Viscosity**

8±1 second Iwata#2 @ 25°C

**Reducer**

Direct spray, if needed use IPA (Iso Propyl Alcohol)

**Curing of coating**

To ensure the proper curing of coating, the temperature of substrate must be kept at specified temperature for entire cure process.

**Flash Dry**

5 min @60-80°C

**Final Curing**

Refer to the topcoat curing specification

**Product Specification**

**Pencil hardness**

6H

**Gloss**

Medium

**Cross Hatch Adhesion**

Boiling water 20 min, then cross hatch adhesion- Pass 100%

**MEK rub**

50 double rub

**Storage**

3 months, Store at 5-30°C in dry atmosphere

**Others**

1. After A/B/C gets matured, coating must be used up within 24 hours
2. Final curing temperature should be increased gradually, too fast temperature increase will cause blister on final film.
3. IPA can be used to clean spraying gun and other equipments.
4. Mix the A+B+C= 61.92+31.90+5.31 in proper recommended ratio and recommended order.
5. After component A/B/C blend together, there will be a exothermic reaction, within 20-30 min, system temperature will reach to 50°C and then drop down gradually. This is normal.
6. As gas will be liberated during the reaction, we suggest depressurized the container after roll 20-30 min, also be care of causticity of the gas liberated.
7. Component A pH=3.5-5.0 and after mature of A/B/C system pH= 3.5-5.0 avoid contact skin, Component B is neutral.
8. Please refer to MSDS of this product before use.

**Date**

28th May, 2010

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