







## ISM5 ISOFAN MARINE 2K BASECOAT (from SM00590)

					
1000 ml + 100 ml + 1000-1200 ml <b>1 + 0,1 +1</b>	Ford 4 14-16"	Ø 1,2-1,3 mm 3,5-4 Atm HVL P: 2-2,5 Atm N° coats: 3 + Mist-coat	15' at 20°C	20-40 µ	4h at 20°C

### Description

2K metallic, pearl or solid **matt base coat** for the Yachting industry and can be over coated with Clear Coat. Manufactured using high quality resins. ISOFAN MARINE series clearcoats assure the highest levels of weather resistance and workability. Its balanced composition produces the best uniformity (no clouding) and makes this finish especially suitable for the professional painting of large surfaces in Yacht, Super Yacht and Marine industry.

### Colour

Available in the standard colour ranges **Yachting Colour Master** and **Yachting colour selection pastello and effect**. It is recommended to use the coloured fillers of the series Undercoat ISM9, in order to minimize the contrast. It is essential to follow this suggestion to achieve the desired colour point in the following cases:

SM5E001 Hologram**	Black undercoat SU4070
SM5E003 Cyan red iridescent**	Black undercoat SU4070
SM5E005 Red gold iridescent**	Black undercoat SU4070
SM5E007 Imperial gold iridescent**	Black undercoat SU4070
SM5E011 Sparkling black	Black undercoat SU4070
SM5E009 Sparkling white	White undercoat SU4000
SM5E012 Sparkling bordeaux	White undercoat SU4000
SM5E099 Silver harrow *	glossy black (colour SG723)

**\*NOTE: Silver harrow is a special ready for use colour. No catalysis nor thinning is required.**

**\*\*Being special colours, they are not recommended on large surfaces.**

The colour references **Yachting effect colour selection pastel and effect** are to be considered as indicative references. Prior to painting it is essential to spray a reference spray-out card to submit to the customer for approval.

### Characteristics

- Easy to apply
- Very good overspray absorption
- Patch- and stripe-free
- Very good durability against the marine environment (when using ISOFAN MARINE clear coats)
- High opacity power
- High coverage

## Substrate preparation

### Stoppani polyurethane undercoats

Dry sanding with P 320-400 paper

## Application

By spray with traditional spray gun, HVLP or airmix

Application conditions:

- Relative humidity < 80%
- Temperature >10 °C <35°C
- Substrate temperature 5° > dew point

## Mixing ratio

	Volume	Weight
ISM5 ISOFAN MARINE 2K BASECOAT (mixed colours) ..... A	1000 ml	1000 g
SM00630 ISOFAN MARINE BASECOAT HARDENER..... B	100 ml	100 g
SM00780 ISOFAN MARINE SLOW THINNER SM00700 ISOFAN MARINE STANDARD THINNER SM00715 ISOFAN MARINE FAST THINNER..... C	1000-1200 ml	1000-1200 g

At temperatures above 25°C and for applications of large surfaces when more painters are involved (f.i. Superyacht), it is recommended to replace a part of SM00780 ISOFAN MARINE SLOW THINNER with SM00720 ISOFAN MARINE RETARDANT until a max. 1:1 mixing ratio, in order to help the overspray absorption.

Spray viscosity Ford Cup 4: 14-16 sec.

Pot-life: 4 h at 20°C

Ø conventional air cap and HVLP: 1,2-1,3 mm

Pressure: 3,5 – 4 Atm HVLP: 2 – 2,5 Atm

N° of coats: 3 (½ thin coat "grip coat" + 1 full coat + 1 full coat + mist-coat)

Recommended film thickness: 20-40 µ dry

Interval between the coats: min. 15' max. 18 h at 20°C

Theoretical coverage mix A+B : 8,2 m<sup>2</sup> for 1 l mixture at 30µ

Solids content by volume mix A+B: 24,5%

Solids content by volume mix A+B+C: 12,9%

\*The value is purely indicative and can slightly change according to the colour

## Drying

	10°C	20°C	35°C
Over coat in wet-on-wet with itself after	min. 30' max. 36h	min. 15' max. 18h	min. 10' max. 9h
Taping with plasticised tapes after	8 h	Min. 4h	Min. 2 h
Over coat in wet-on-wet with Clearcoat after	min. 2h max. 36h	min. 1h max. 18h	min. 30' max. 9h

## Over coating/Polishing

The product must be over coated with one of the ISOFAN MARINE clear coat range.

Before applying the clearcoat wipe the surface with a tack rag removing any overspray. Check the surface and remove any dirt by sanding with ultrafine sand paper and by applying the basecoat in a mist-coat before applying the clearcoat.

Polishing can be carried out only on the clearcoat after it is suitably dry.

Where some touch-ups are needed apply the basecoat again after verifying that the paint has dried enough by touching the paint edge. After applying the basecoat wait a few minutes and verify that no wrinkles and/or no absorption have appeared.

To thin the basecoat it is recommended to use SM00715 FAST THINNER and to apply very thin mist-coats. This avoids attacking the underlying basecoat. After the basecoat has dried apply two coats of clear coats again, by reducing the overspray in the fade-out zone using EL085 ENERGY SPRAY LINE FADE-OUT BLENDER.

### TECHNICAL DATA SHEET N° S187-GB

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