



H₂O System refinishing base coat

PRODUCT



Additives	Number	Contents	Part numbers:
AD 400 IXELLTECH blending > 30	1	3.5 L	77 11 431 531
AD 401 IXELLTECH slow blending < 30	1	1 L	77 11 576 768
AD 231 ADD HYGRO > 30	1	3.5 L	77 11 431 535
AD 228 ADD HYGRO < 30	1	3.5 L	77 11 579 364
AD 300 IXELLTECH hardener	1	0.5 L	77 11 431 532

SPECIFICATIONS

Use by date in new pots

TB metallic and pearlescent	24 months
TB opaque	36 months
AD 231 HYGRO > 30 % H.R.	24 months
AD 228 HYGRO < 30 % H.R.	24 months
AD 300 IXELLTECH hardener	24 months
Formula shelf life without additive	6 months
Duration of use ⁽¹⁾ PAE (with ADD 228 or 231)	8 hours



1) PAE product can be re-used once by adding 10% ADD 228 or 231.



Avoid exposure to frost
Store at +15°C to + 25°C
Brief storage possible (several days)
at a minimum T° of + 5°C or maximum T° of + 35°C



Stir base colours
1 to 2 times max.

HEALTH AND SAFETY



Maximum respiratory protection is provided using a mask with an air supply

PAE PRODUCT TECHNICAL SPECIFICATIONS

H₂O refinishing base coat: The European limit of VOC contained in the ready-to-use product (Category IIB.d) is 420 g/l maximum. The VOC content of this ready-to-use product is a maximum of 420 g/L.

SURFACES

from  to  • Old paint
• Base coats 1K and 2K

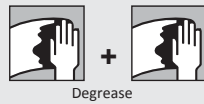
It is best to use Fortia or Univia grey gradient base coats combined with the paint colour formula.



For new panels, the wet on wet version can be used (Wet/Wet).

USE

SURFACE AREA PREPARATION



Degrease

Wipe off



Degrease with solvent-based surface cleaner.

Old paint	S/C 2K Fortia / Lévia Evolution and Univia	S/C spray I-Prémia version 2 coats
P 600 / 800		
Abrasive sponge P 800		
P 1000 / 1200		

Before painting,
degrease with H₂O based surface cleaner.

PRODUCT PREPARATION AT 20°C

Before mixing paint colour:
Shake the base colour by hand for several seconds

Paint colour	AD 228 Hygro additive < 30% or AD 231 Hygro additive > 30% T° > 25° and HR > 30% add 5 to 10% thinner H2O	<p>Mix</p>	<p>8 hours</p>
Opaque	10%		
Effects	20%		

APPLICATION



Sata WSB spray gun
Devilbiss GTI Pro T1 or TE 10 spray gun.



Application distance	Number of applications: 2	Desolvation	Maximum thickness
15/20 cm	1st coat at 80% coverage	Without	20 µm max.
25/30 cm	2nd coat at 20% to complete coverage at 100%, and optimise placement of aluminium particles		

DRYING BEFORE APPLYING TOP COAT

Completely matted



Ventilation at 20°C

Assisted ventilation at 20°C

Blower nozzle at 20°C (2)

Not applicable

FINISHING TOP COAT

IXALIS ÉVOLUTION

ALTIA

CLEARIUS



Refer to clear coat technical data sheets

FLASH

RECOMMENDATIONS

(1) The PAE product can be re-used once by adding AD 231 or 228 with a period of 6 months, only for interior painting or small paint blending-in on areas that are not visible. E.g.: for 100 g of PAE paint colour, add 10% AD 228 or 231 for opaque colours or 20% AD 228 or 231 for paint colours with effects.



Loss of coverage.

(2) The blower nozzle requires 4 essential actions for optimum drying:

- An angle of 45° to the surface area;
- A distance of 1 metre from the surface area;
- Blower nozzle inlet pressure of 3 bar;
- A minimum ambient temperature of 20°C.

Bringing the blower nozzle closer to speed up the drying process is ineffective. A distance too close to the surface area can alter the base structure and affect the perceived quality after applying the clear coat lacquer.