

H₂O System Refinishing base coat

PRODUCT

- Water-soluble base coat.
- Easy to apply.
- Excellent colour matching.
- Easy to use.
- High coverage.
- Excellent placement of metal particles.
- Environmentally-friendly.
- Application: without desolvation.
- Less aggressive on irregular surfaces.



Description	Number	Contents	Part number
Oxelia base coat	40	0.5 L	
Oxelia base coat	27	1 L	
Oxelia base coat	11	0.25 L	
H ₂ O base coat thinner		1 L	77 11 218 194
Oxelia matt base coat accelerator		0.5 L	77 11 573 491

SPECIFICATIONS

	Base coat	Thinner
Colour	Transparent	Transparent
Storage	1.016	0.85



Avoid exposure to frost

Store at +15°C to + 25°C

Storage during transport (max. 4 weeks) at a minimum temperature of +5°C

HEALTH AND SAFETY



Maximum respiratory protection is obtained using a mask with an air supply.

PAE PRODUCT 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.

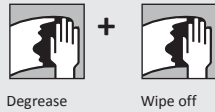
USE

SURFACES



Old paint
Base coats 1K and 2K

SURFACE PREPARATION



Degrease with solvent-based surface cleaner



Surface primer

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 surface cleaner

PRODUCT PREPARATION AT 20°C




Before mixing paint colour

Stir base colours



a Oxelia base coat

b Oxelia base coat thinner










	
100a : 10b	
T° > 25°C	100a : 15b



Mix


	
28 - 34	2 months in a plastic container

APPLICATION AND DRYING






Application				Conventional drying		
Sata WSB spray gun Devilbiss GTI Pro T1 or GTI Pro lite TE10 spray gun				Without accelerator and no accessories to fit*		
   				  		
Application distance	Number of applications: 3	Desolvation	Maximum thickness	Dry before clear coat		
10/15 cm	1 light coat	Without	20 µm max.	15/20 min. at 22/24°C	15/20 min. at 60°C	Not applicable
10/15 cm	1 covering coat	Without		 		
10/20 cm	1 light coat for particle placement	5 min. at 20°C before drying				

*See table of recommendations during hot periods

FINISHING TOP COAT

IXALIS EVOLUTION	ALTIA	CLEARIUS
 Refer to clear coat technical data sheets		FLASH

During hot periods there is a risk when fitting accessories such as door mirrors, windscreen seals, etc., which once fixed, exert pressure on the repainted panel and when exposed to sunlight can generate a wrinkling effect around the edge of the accessory.

Method		Application of base coat thickness F.T. 20 µm max.	Desolvation with blower nozzle at 22/24°C	Base coat curing in booth for 30 min. at 60°C + cooling	Application and drying of F.T. clear coat	FITTING ACCESSORIES	
						After IR drying, at 50/60°C at location of accessory only	After 24h at 20°C
	WITHOUT accelerator and WITH accessory	✓	15 to 20 min.		✓	25 to 30 min.	
OR							
	WITHOUT accelerator and WITH accessory	✓			✓		✓
(1) 	WITH accelerator and WITH accessory	✓		30 min. at 60°C	✓		
Conventional method	WITHOUT accelerator and WITHOUT accessory	Application of base coat thickness F.T. of 20 to 25 µm max.	Desolvation with blower nozzle 20 to 25 min at 22/24°C		✓		
	WITHOUT accelerator and WITH accessory	✓	30 min. or 15 min.		✓	30/40 min.	
(1) 	WITH accelerator and WITH accessory	✓		✓	✓	15 min.	

(1) Except aluminium grey paint colours which can cause a colour match difference.

The pot life with accelerator is 30 min. After this time, the product can be applied but a colour match difference is observed and causes a significant difference in colour.

