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## POLYBASE PLUS BASECOAT

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**DESCRIPTION:** Polybase Plus is a catalyzed basecoat made from polyester and acrylic resins for use in Automotive and Truck refinishing. Polybase Plus can be used on repairs without swelling, lifting or wrinkling. The Basecoat cross-linking provides extremely strong intra-coat adhesion, flexibility and toughness.

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### PRODUCT & ADDITIVES:

**PRODUCT:** —Polybase Plus Metallic and Pearl color  
—Polybase Plus solid color

**ACTIVATOR:** —A-Base Activator


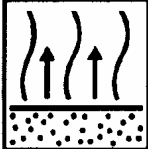
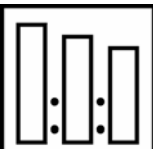
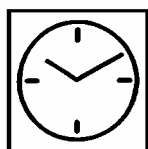
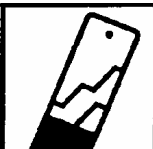


**REDUCERS:** —R200 Fast: for spot and panel repairs.  
Temperature range: 60°F–75°F (16°C C –24°).  
—R200 Medium: for panel repairs and large areas.  
Temperature range: 70°F–85°F (20°C–30°C).  
—R200 Slow: for larger areas and complete paint jobs.  
Temperature range: 80°F–95°F (27°C–35°C).  
—R200 Extra Slow: a very slow reducer that can be used in extremely hot temperatures. This may be mixed with R200 Slow. Temperature range: above 100°F (38°C).

**CLEARCOATS:** U-Tech has four clearcoats for application over Polybase Plus, 4.0 Select, MS Clearcoat, SP Clear and HS21 Clear. This selection is based on National Rule VOC regulations. Please refer to the clearcoat technical data sheet.

**BASIC RAW MATERIALS:** —Polybase Plus: Physically drying resins  
—Activator/Hardener: polyisocyanate

## POLYBASE PLUS BASECOAT

### APPLICATION:

- |    |  |  |    |  |   |
|----|--|--|----|--|---|
| 1. |   | Wear a positive pressure-fresh air mask when applying U-Tech products.           | 5. |  | 5-7 minutes at 70°F (20°C)  |
| 2. |   | <b>4:1:1</b><br>Polybase Plus Solid/Metallic<br>A-Base Activator<br>R200 Reducer | 6. |  | Minimum<br>20–30 minutes at 70°F (20°C)<br>Maximum<br>72 Hours at 70°F (20°C) |
| 3. |   | Use the Utech Measuring Stick  | 7. |  | Apply Clearcoat   |
| 4. |  | <b>1-2x1</b><br>Spray one medium wet coat followed by a cross-coat               |    |  |   |

### SUITABLE SURFACES:

- Polybase Plus can be applied directly over:
- OEM 2-step solid and metallic systems and over existing finishes; degreased and sanded with #P500 to #P600 grit paper dry or #P600 to #P800 grit wet but not over thermoplastic acrylic lacquers. In that case, the entire panel of lacquer must be sealed with a compliant U-Tech undercoat system.
  - Any U-Tech preparatory product that is compliant for local regulations.

### SURFACE PREPARATION:

- For all substrates that are to be sanded use #P400 to #P500 DA or #P500 to #P600 grit paper dry or #P600 to #P800 grit wet .
- For wet-on-wet application please follow the recommendation for the wet on wet product in use by consulting the relevant Technical Data Sheet.

### MIXING RATIO:

- Polybase Plus solid, metallic and pearl colors are mixed as follows:
- 4 parts by volume of Polybase Plus color
  - 1 part by volume of A-Base Activator
  - 1 part by volume of R200 Reducer
- For easy and accurate mixing, use the U-Tech Measuring Stick



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### SPRAYING

**VISCOSITY:** 21-28 seconds ZAHN cup #2 (15-18 seconds DIN #4) at 70°F (20°C).

**POTLIFE:** 24 hours at 70°F (20°C)

### SPRAY GUN & PRESSURE:

|               | Fluid Tip  | Spraying Pressure | Fluid Pressure |
|---------------|------------|-------------------|----------------|
| Pressure Feed | 1.0–1.2 mm | 40–50 psi         | 8–10 psi       |
| HVLP Siphon   | 1.8–2.2 mm | max. 10 psi       |                |
| HVLP Gravity  | 1.3–1.5 mm | max. 10 psi       |                |

### APPLICATION OF POLYBASE PLUS:

Solid: Spray one single coat followed by a cross-coat or until hiding. When applying more than one coat allow approximately 7-12 minutes flash-off between each coat. On spot primed areas, where extra coverage is required, first apply a single thin coat over repaired area.

Metallics and Pearls: If it is necessary to even out the metallic pattern spray an additional lighter orientation coat. (Drop Coat)

### APPLICATION 3-STEP COLORS:

**Polybase Plus 3-Step Metallics: (sprayed as a 2 stage with tinted clear coat)**

Polybase Plus Metallic (foundation color): Spray 1 -2 single coats (until covered), allowing 7-12 minutes flash-off between coats. If it is necessary to even out the metallic pattern spray an additional lighter orientation coat. (Drop Coat)

Look up the formula for the **Tint Stage 2** (mid coat) in the Utech Color retrieval program – mix this formula in any U-Tech clearcoat. Mix with the activator for the clear at the recommended ratio and spray this transparent clear mixture. This system is designed to match with 2 coats of tinted clear. It is suggested to do a let down panel to identify exactly how many coats of this tinted clear is necessary to achieve a match.

**Note:** If polishing is planned, a final coat of un-tinted clear is recommended

**POLYBASE PLUS 3-STEP PEARLS:**

Polybase Plus (foundation color): Spray 2–3 single coats (until covered), allowing 5-7 minutes flash-off between coats.

Look up the formula for the **Tint Stage 2** (mid coat) in the Utech Color retrieval program – mix this formula and spray 4:1:1. Spray this pearl color with R200 Slow Reducer, applying two to three even light coats. It is suggested to do a let down panel to identify exactly how many coats of pearl is necessary to achieve a match.



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**SANDING:** If sanding is necessary on the basecoat, wet sand with #P600 to #P800 grit. Then recoat.

**FILM THICKNESS:** Polybase Plus Solid, Metallic and Pearl: .8 - 1 mil per single coat.

**COVER RATE:** Approximately 250 sq. ft./gallon at a film thickness of 1 mil.

**PRODUCT SPECIFICATIONS:**  
(Testing at 70°F Ready to Spray)

|  |                       |
|--|-----------------------|
| Viscosity  | 21-28 Seconds #2 ZAHN |
| Dry Film Build   | 1 mil/coat            |
| Electrostatic Sprayability:<br>Rating 1-10 (10 being best) | .1 MΩ<br>1 Rating     |
| VOC/GAL  | 5.9 lbs               |
| WT/GAL   | 9.7 lbs               |
| Solids/Gal   | 3.8lbs                |

**CLEANING OF EQUIPMENT:** Use Extra Strong Cleaning Solvent, or lacquer thinner.

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### STOCK KEEPING:

**AVAILABILITY:** U-Tech Polybase Plus is available ready mixed or can be mixed by means of the U-Tech mixing machine.

**COLOR:** See the U-Tech Color Documentation.

**SHELF LIFE:**  
—Polybase Plus Basecoat: 2 years  
—A-Base Activator: 1 year  
—R200 Reducers: 2 years

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### SAFETY ASPECTS:

**READY TO SPRAY VOC:** Polybase Plus Basecoat: 6.1 lb/gal 727 g/liter

**NOTICE:** Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mists.