

Metallic Base Coat

Technical Data Sheet:
403-26 / M series

- 1. Introduction** ALEXSEAL® Metallic Base Coat is a two component material.
- 2. Range of application** ALEXSEAL® Metallic Base Coat is intended to be part of a base coat/clear coat finish combined with ALEXSEAL® Premium Topcoat 501, T0125 Clear Gloss for the application of a metallic finish. It can be used internally or externally on areas of the yacht which are not subject to permanent water immersion.
- 3. Color** ALEXSEAL® Metallic Base Coat is available in custom colors.
- 4. Coverage** Coverage for ALEXSEAL® Metallic Base Coat when applying 2 - 3 coats or passes in the same application period is as follows:
- Volume Solids without reduction: 30 - 45%
(depending on color)
- | | | |
|---------------------|------------------------------|---|
| Theoretical: | pure silver and light colors | 14.3 m ² / liter (54 m ² per gal.), (582 sq. ft. gal) |
| | dark colors | 23.0 m ² / liter (87 m ² per gal.), (936 sq. ft. gal) |
| Practical: | Spray application all colors | 2.4 m ² / liter (9.2 m ² per gal.), (100 sq. ft. gal) |
- Coverage for ALEXSEAL® T0125 Clear can be found in the coverage section of the ALEXSEAL® Premium Topcoat 501 Technical Data Sheet.
- 5. Substrate pre-treatment** The substrate must be clean, dry and free from dust, grease, oil and other contaminations. To achieve optimum performance and adhesion ALEXSEAL® Finish Primer 442 must be used. ALEXSEAL® Finish Primer 442 should be applied and smooth sanded with 320 - 400 grit sand paper.
- 6. Trade names**
- | | | |
|------------------------|-------|-----------------------------------|
| Base Material | M.... | ALEXSEAL® Metallic Base Coat |
| Hardener | C5051 | ALEXSEAL® Topcoat Converter Spray |
| Reducer Slow (spray) | R5030 | ALEXSEAL® Topcoat Reducer Slow |
| Reducer Medium (spray) | R5050 | ALEXSEAL® Topcoat Reducer Medium |
| Reducer Fast (spray) | R5070 | ALEXSEAL® Topcoat Reducer Fast |
- 7. Mixing ratio**
- Compressed air spraying:
- | | | |
|------------------------------------|-------|---------------------------------------|
| 5 parts by volume | M.... | ALEXSEAL® Metallic Base Coat |
| 1 part by volume | C5051 | ALEXSEAL® Topcoat Converter Spray |
| 50 % by volume | | ALEXSEAL® Topcoat Reducer (see above) |
| Example: 5 : 1 : 3 = 50% reduction | | |
- First Clear Application:
- | | | |
|---|----------------|---|
| 1 part by volume | T0125 | ALEXSEAL® Premium Topcoat 501 Clear |
| 1 part by volume | C5051 | ALEXSEAL® Premium Topcoat 501 Converter |
| 20 - 45 % by volume | R5030 or R5050 | ALEXSEAL® Topcoat Reducer |
| Example: 1 : 1 : 2/5 = 20 % reduction up to 1 : 1 : 9/10 = 45 % reduction | | |
- Subsequent sanding with 320 - 400 grit dry sand paper or 500 - 600 grit wet sand paper is recommended.
- Second Clear Application: Recommended to achieve higher DOI and gloss:
- | | | |
|---|----------------|---|
| 1 part by volume | T0125 | ALEXSEAL® Premium Topcoat 501 Clear |
| 1 part by volume | C5051 | ALEXSEAL® Premium Topcoat 501 Converter |
| 20 - 45 % by volume | R5030 or R5050 | ALEXSEAL® Topcoat Reducer |
| Example: 1 : 1 : 2/5 = 20 % reduction up to 1 : 1 : 9/10 = 45 % reduction | | |

Professional Use Only

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8. Application

Viscosity	Zahn #2: approx. 16 - 18 sec, DIN 4 cup 4mm: approx. 14 - 16 sec
Fluid Nozzle Size	1.0 to 1.3 mm (0.040 to 0.050)
Atomizing Pressure	3.0 to 5.0 bar (42 to 70 PSI)
Pot Pressure	0.7 to 1.5 bar (10 to 20 PSI)

ALEXSEAL® Metallic Base Coat is intended to be part of a base coat / clear coat finish. This system needs to be applied in 2 to 3 steps.

Step 1: Apply ALEXSEAL® Metallic Base Coat by spray application using a cross hatch application technique. A minimum of two medium wet coats at 50 % reduction will be required before full hide of the substrate can be achieved. Multiple coats at 50 % reduction may be required depending on the size of the surface and colors or color of the surface to be coated. A flash-off time / drying period of at least 30 minutes at 30°C (85°F), longer times for lower temperatures, see chart below, and up to a maximum of 4 hours between application of the individual coats.

Step 2: After the Base Coat has dried a minimum of 1.5 hours at 30°C (85°F), longer times for lower temperatures, see chart below, up to a maximum of 8 hours at 25°C, apply 2 to 3 coats of ALEXSEAL® Premium Topcoat 501 Clear in order to seal the Base Coat.

Step 3: To achieve a higher level of gloss and a more durable finish, a second application of 2 to 3 coats of ALEXSEAL® Premium Topcoat 501 Clear may be applied. Careful sanding of the first Clear Coat with 320 – 400 grit dry sand paper or 500 – 600 grit wet sand paper is possible after a period of at least 24 hours in order to avoid damaging the metallic surface. Graphics may be added between Step 2 and 3.

Application information for ALEXSEAL® Premium Topcoat 501 Clear can be found in the ALEXSEAL® Premium Topcoat 501 Technical Data Sheet.

9. Pot life and Drying

Recommended minimum 15°C (60°F) 40 % RH, up to maximum 30°C (85°F) 80% RH for optimal application performance.

Temperature for minimum drying time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Time
Pot Life - approx. Base Coat	12 hrs	10 hrs	8 hrs	6 hrs	N/A
Recoat after tack up with ALEXSEAL® Metallic Base Coat	45 min	30 min	30 min	30 min	4 hrs
Overcoat with Alexseal® Premium Topcoat 501 Clear	3 hrs	2.5 hrs	2 hrs	1.5 hrs	8 hrs
Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, choice of reducer speed and film thickness will effect actual times during application.					
Drying parameters vary depending which ALEXSEAL® Topcoat Reducer is selected. Minimum temperature during drying phase: 15°C (60°F). Ideal temperature: 25°C (68°F).					
If the maximum recoating times are exceeded the Base Coat or Top Coat is to be sanded with 400 grit sand paper.					
Use of an accelerator in the Base Coat System is not recommended. When used in the Clear Coat System it leads to a reduction of the recoating times (refer to Technical Data Sheet 501).					

10. Packaging

M...	ALEXSEAL® Metallic Base Coat	1 Gal
C5051	ALEXSEAL® Topcoat Converter Spray	1 QT & 1 Gal
R5030, R5050, R5070	ALEXSEAL® Topcoat Reducers	1 QT & 1 Gal

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