



## Kuruma Mixing Color 1K

Rev.1/21

### Product Description

Kuruma Mixing Color 1K is Basecoat for use in clear over base systems for solid, metallic and pearl colours. Suitable for use on cars, trucks and buses. Composition based on acrylic copolymer.

### Substrate preparation

- Primer sanding, dry sanding no.400-500 or wet sanding 600-800
- Ensure that surface of the previous coat was clear and dry free form dirt, rust, grease, oil and other foreign matters.
- Degreasing and clearing with Matrix degreaser

### Mixing Ratio

#### - Kuruma Mixing Color 1K (Solid Color)

	Solid	Metallic&Pearl
Kuruma Mixing Color 1K (Solid Color)	100	100
Thinner	40-50	70-100

Mix Kuruma Mixing Color 1K and Thinner, strictly follow mix ratio recommendations before and stir for 2-3 minutes until the mixture is homogeneous before application.

### Thinner

Kuruma Standard Thinner No.20

### Clearcoating

Apply 2K Clearcoat

### Viscosity For Spray

	Viscosity (sec) @30°C
Iwata Cup NK # 2	11 - 13

### Spray gun

Gravity Feed

### Set-up

Full pattern Flow - 2.5 turns from fully closed set-up

### Nozzle size

1.2 - 1.5 mm. (Please refer to spray gun manufacturer)

### Spray pressure

1.5 - 1.8 Bar

### Number of spray coats

Recommended apply 2-3 coats

#### - Kuruma Mixing Color 1K

Light to medium first coat

Light to medium second coat

Drop third coat

Solid, dry film thickness : 30 - 40 microns

Metallic, dry film thickness : 15 - 25 microns

Pearl, dry film thickness : 15 - 25 microns

### Flash off time

Between coats : 3-5 mims

### Drying time

Drying time	Air dry ( 30 °C)
Surface dry	3 - 5 mins
Dry to recoat	5 - 10 mins
Dry to top clear	5 - 10 mins

### Handling and Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

### Shelf life

- 60 months at <40 °C
- The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

### Safety and Disposal

- Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.
- For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Safety Data Sheet.