



Kuruma Toner (Binder system)

Rev.1/21

Product Description

- Kuruma toner (binder system) is a base coat for metallic Pearl or solid color, use both in Clear over base system and 2 component top coat solid color. It's quick dryness and easy to apply under non-mottling, good adhesion high hiding power.
- Binder system component
 - 1) Solid toner
 - 2) Metallic toner
 - 3) Pearl toner
 - 4) 1K Binder and 2K Binder
 - 5) Flip flop control agent
 - 6) Standard thinner & Slow drythinner

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 Toner 1K (Clear over base system)

	Solid	Metallic&Pearl
Kuruma toner	50%	30%
Kuruma Binder 1K	50%	70%
Thinner	30-40%	70-100%

- Kuruma Toner 2K

	Solid
Kuruma toner	50%
Kuruma Binder 2K	50%
Kuruma hardener KH021	25%
Thinner	30-50%

Thinner

Kuruma Standard Thinner No.20 or Kuruma Slow Dry Thinner No.30

Clear coating

Apply 2K Clear topcoat for Kuruma Toner 1K

Viscosity For Spray

	Viscosity (sec) @30°C
Ford Cup # 4	14 - 18

Spray gun

Set-up

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

Nozzle size

1.3 - 1.4 mm. (Please refer to spray gun manufacturer)

Spray pressure

1.5 - 1.8 Bar

Number of spray coats

Recommended apply 2-3 coats

- Kuruma Toner 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
Drying time

- Kuruma Toner 2K

Light to medium first coat
Full wet second coat and third coat
Dry film thickness : 40 to 60 microns

Between coats : 3-5 mins

- Kuruma Toner 1K

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

- Kuruma Toner 2K

Drying time	Air dry (30 °C)	Baking (60 °C / 30 mins)
Surface dry	5 - 10 mins	-
Polishing time	4 - 6 hours	
Dry to assembly	2 hours	1 hours

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

- 48 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.