

# BODY AUTOEMAIL METALLIC PAINT

Technical Data Sheet No 604



A High Performance Basecoat for motor vehicles

Available in several shades

Excellent mechanical and high chemical resistance

Great durability

## General Technical Description



Mix 2:1 with  
BODY 740 ACRYL  
NORMAL /  
BODY 741 ACRYL  
THINNER SLOW  
Mix well and filter  
through paper filter



Ready to spray:  
17-20 s / 23°C



Non force dry  
10-15 min / 23°C

## Surface

In Body Primed surfaces

In metallic surfaces

OEM surfaces

## Pretreatment / Cleaning of substrate



Clean substrate using  
a soft cloth and BODY  
770 ANTISIL NORMAL  
/ BODY 771 ANTISIL  
FAST

Make sure the surface  
is air dried rather than  
wiped dry



Make sure you always  
use appropriate face  
protection and good  
ventilation

**Product Application:** 2 passes and a final mist »» Apply one hand, and after the 10 min flash off time apply the second hand and a mist. After this apply 2K clear coat over the base coat, to protect the base coat.



2:1 mix with  
Body 740 Acryl Normal /  
Body 741 Acryl Thinner  
Slow  
Use the special mixing  
ruler



5-10 min / 23°C  
Final flash off time



Ready to spray:  
17-20 s  
Cup 4/23°C - DIN  
53211@23°C



Non force dry  
10-15min / 23°C



Conventional Spray gun:  
1.2-1.3 mm  
2 bar inlet pressure  
1.5 coats = 15-20 micron



Always wear protective  
equipment



HVLP 1.3 mm  
0.7 bar atomization pressure  
1.5 coats = 15-20 micron



Follow the application  
instructions mentioned  
in this TDS

**Flash Point:**  
26°C / 79°F

**Specific Gravity:**  
0.9 - 1.2 g/cm<sup>3</sup>

**Solid Content (No thinner):**  
22% Weight

**VOC (2004/42/EC)**  
This product is a special refinish product based on its ingredients and its properties. The maximum VOC content in this category is 840 g/L. The VOC content in the ready for use form of this product is 750 g/L. 2004/42/IIB(e)(840)750

**Theoretical Coverage:**  
8 - 10 m<sup>2</sup> / l

**Cleaning of equipment:**  
Clean after final use with Body 740 ACRYL NORMAL

## Remarks:

- Allow for additional time for combi spray booths to reach the desired temperature
- Application only with BODY 740 ACRYL NORMAL or BODY 741 ACRYL THINNER SLOW
- After preparing the area to be painted ensure it to be free from dirt, wax, oil etc.
- It can be used by countries that do not adopt the VOC legislation as well.
- Store in a cool place and use within 12 months for best

**SPECIAL REFINISHING PRODUCT. 1K ACRYLIC MAT PRODUCT USED WITH THE METALLIC BASECOAT SYSTEM. DO NOT APPLY OVER IT. FOR PROFESSIONAL USE ONLY. VOC 2004/42/IIB(e)(840)750**

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