

Base Coat – Mixing and Application (Commercial Kit 1 gallon / 3.75L “Mixed product”)

Mixing of Base Coat (below guidelines to be strictly adhered to):

- a) **Part A (Base) containing 2.6L:**
 - Remove the lid of the can and stir well (ensure homogeneous texture)
- b) **Part B (hardner) containing 650ml:**
 - Remove the lid of the can and pour the hardner into part A
- c) Stir thoroughly and until homogeneous using the mechanical mixing tool provided

Roller and brush application:

Add approx. 15% (450 ml) of clean water in three steps.

- d) Add approximately one-third (150ml) of the water at a time, stirring for approximately 1 minute between each addition. (Full-kit, total of 450ml of water “**Do not exceed recommended total water addition**”)
- e) Mixture must be fully homogeneous, without streaks or separation
- f) Let it rest for two minutes before application

Spray application:

Add approx. 20-25% (750 ml) of clean water in three steps.

- g) Add approximately one-third (250ml) of the water at a time, stirring for approximately 1 minute between each addition. (Full-kit total of 750ml of water “**Do not exceed recommended total water addition**”)
- h) Mixture must be fully homogeneous, without streaks or separation
- i) Let it rest for two minutes before application

Note - Mixing less than the full kit:

- Mixing ratio by volume 4:1 (4 parts A-base, to 1 part B-hardner) using a paint mixing cup or similar for mixing
- Add Water:
 - For roller and brush application: add 10-15% of water in three steps (follow step d-f)
 - For spray application: add 15-20% of water in three steps (follow step g-i)

Important before application:

Surface/metal temperature must be at least 3 °C above dew point

Relative humidity (RH): 40–85% is acceptable

(For guidance regarding application conditions and methods, please consult the PGX-Best-Practice-guide, section 1 thru 6.)

Application by Roller:

Base-coat: apply 1 layer of approx. WFT 2.95-3.95 mils (75-100µm)

- Roll in thin, even coats and avoid excessive back-rolling

Application by Brush:

Base-coat: apply 1 layer of approx. WFT 2.95-3.95 mils (75-100µm)

- Brush in thin, even coats and avoid excessive back-rolling

Application by Spray:

Base-coat: apply 1 layer of approx. WFT 2.95-3.95 mils (75-100µm)

- Apply in cross-coats where possible to ensure even film build

Note: If time permits, apply a second base coat for maximum durability, following the steps above.

Overcoating interval between coating layers:

@ 25–30 °C and 40–85 % relative humidity the following guidance is appropriate and conservative for professional use.

Minimum drying/recoat time: 2-4 hours (Ideal 4 hours)

The painted surface must be:

- ✓ Surface dry
- ✓ Non-tacky to the touch
- ✓ Able to withstand light finger pressure without marking

Maximum Recoat Window is Typically 24 hours (@ 20°C)

If exceeded: Light sanding (e.g. P240–P320) is recommended before recoating