

TECHNICAL INFORMATION

Date of preparation:
28.10.2020r.



Update date:
17.07.2025r.

Strona 2 z 5

Product name: APP Modular Special Base 80 the following including Liquid Aluminium. APP No: 0260096 - 1.0L.

Application

Intended for use as a decorative layer in multi-layer topcoat systems.

Substrate

Suitable substrates.

Sanded factory coatings.

Surfaces pre-treated with:

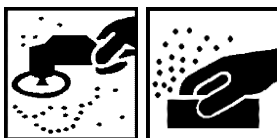
- Acrylic primers e.g. APP AcrylFiller Multi Sanding, APP AcrylFiller Multi Wet on Wet, APP AcrylFiller 401, APP AcrylFiller 501, APP AcrylFiller Rapid, APP AcrylFiller Compact,
- Epoxy primers, e.g. APP Grund EP, APP Grund EP Spray,
- Single-component fillers e.g. APP Primer Filler, APP Primer Filler Spray,
- APP Smart Primer, APP Smart Primer,
- The spray application may be performed with any of the following materials: e.g. black, chemically hardened, acrylic gloss lacquer within 12 hours after application, or after cooling down after forced drying for 30 minutes at 50-60° C, spraying without grinding the lacquer surface.

Caution!

Do not use on APP Haftgrund or APP 2K Haftgrund.

Do not use on thermoplastic finishes.

Substrate preparation.



Pre-sand by machine with P320-P400 abrasive paper.

Machine finish sanding with P500 abrasive paper.

Manual finish sanding with P800 sponge sandpaper or NTools GSD 1000-1200 double-sided sanding sponge.

Pre-sanding by hand with P600-P800 waterproof sandpaper. Finish sanding by hand with P1000 waterproof abrasive paper.

Before spraying APP Modular Special Base, the lacquered surface is to be cleaned of dust and degreased with W911 or W900 remover and WB910 with APP Premium cleaner.

For final dust removal from the surface, use APP SAS, APP SAS Aqua, APP Tack Cloth White, or APP Tack Cloth Blue.
APP Tack Cloth Blue.

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do uwag i ostrzeżeń znajdujących się na etykietach produktów i zawartych w karcie charakterystyki. We do not accept any
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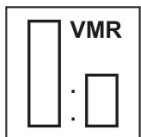
Application

Mixing proportions.



- In case of using the product on its own, it is ready for use without the addition of thinner after very thorough mixing.
- When using the product as a formula element of a colour system, proceed as with the base colour of the APP Modular Special Base system.

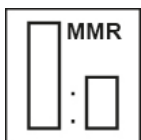
Volume mixing proportions:



VMR - Volume Mixing Ratio

- A) For temperatures from 15°C to 25°C:
- | | |
|----------------|---|
| 100 volumes of | APP Modular Special Base |
| 80-100 volume | APP Modular Special Base Thinner 80-130 |
- B) For temperatures from 25°C to 35°C:
- | | |
|---------------|---|
| 100 volumes | APP Modular Special Base |
| 80-100 volume | APP Modular Special Base Thinner 80-140 |

Mixing ratios by weight:

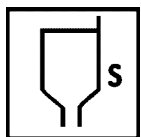


MMR - Mass Mixing Ratio

- | | |
|-----|---|
| 100 | APP Modular Special Base |
| 91 | APP Modular Special Base Thinner 80-130/140 |

Thinners may be used:

- APP Acryl Verdunnung lang - slow evaporation time
- APP Acryl Verdunnung normal - normal evaporation time



Spray viscosity:

- | | |
|-----------------------|-------------------------------------|
| 11-13 s 4mm DIN/+20°C | for APP Modular Special Base 80-96, |
| 16-18 s 4mm DIN/+20°C | for APP Modular Special Base. |



Mix the toners in the mixer once a day for approximately 15 minutes.

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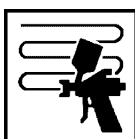
Applying:

Caution!

Check the colour of the lacquer by test spraying each time.



Apply with a spray gun equipped with a nozzle of $\varnothing 1.2$ - $\varnothing 1.4$ mm at an air pressure of 1.5 to 2.5 bar.



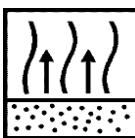
Number of coats:

- non-metallic colours: 2 full coats,
- metallic and pearlescent colours: 2 full coats and 1 skimmed coat (approx. 30% of full coat).

Dry film thickness: 20-30 μ m.

Recommended working conditions:

- minimum temperature: +15°C,
- maximum relative humidity: 75%.

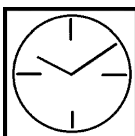


Intercoat evaporation time at +20°C:

- 5-7 minutes.

Shelf life of ready-to-use mixture in tightly closed factory packaging: 2 years.

Drying.



At +20°C:

Dry, matt and ready to cover:

15-20
minutes.

Maximum time to cover:

approx. 6
hours.

Sanding.



If necessary, e.g. inclusions, sand after drying:

- wet with waterproof sandpaper P800-P1500
- manually dry with NTools FLEXPAD Microfine abrasive sponge or APP PS G P600-P800 sponge abrasive paper.

Coatability.

After drying the basecoat, clean its surface with APP SAS dust cloth or APP SAS Aqua and coat with binary colourless topcoat, e.g. APP Klarlack UHS 410, APP Klarlack Glosser, APP Klarlack S Pro, APP Klarlack Beta, APP Klarlack S, APP Klarlack Compact APP Klarlack Smart, APP Klarlack or APP Klarlack FD or APP Klarlack Fdes spray.

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