

PALINAL

High Technology Paint

927 | BASE OPACA_ TRIPLO STRATO

BASE COAT MATT_ TRIPLE LAYER

BASES MULTICRYL 900 + BINDER 900.DS25



2 POSSIBILITA' DI UTILIZZO : Standard (S) – Alto Solido (H)

PREPARAZIONE

Preparation | Préparation |
Preparación | Vorbereitung


RAPPORTO MISCELA

Mixing ratio | Relación de Mezcla
Proportion de melange | Mischverhältnis

S 100 : 10 : 100
H 100 : 10 : 50-70

PRODOTTO

Product | Producto | Produit | Produkt

927

100

CATALIZZATORE

Hardener | Catalizador | Catalyseur | Katalysator

993.MS--

10

DILUENTE

Thinner | Diluyente | Diluant | Verdunner

075.0020 STANDARD
075.0015 FAST
075.0030 SLOW

S 100
H 50-70

FILTRO

Tdedjhd | Diddn | Hfkdmtd | Vdbdgbwr

2500 Maglie | Meshes | Mailles | Mallas | Poren (125µ)

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TDS D19N ED. 07/2020

APPLICAZIONE				
Application Application Aplicación Anwendung				
	POT Pot life (20° C) Vie en pot (20° C) Vida de la mezcla (20 °C) Topfzeit (20° C)	-		
	VISCOSITÀ APPLICAZIONE Application viscosity Viscosité d'application Viscosidad de aplicación Spritzviskosität	S 15" ± 1" DIN/4 H 20" ± 3" DIN/4		
	REGOLAZIONE DELLA PISTOLA Airbrush adjustment Regulación de la pistola Réglage du pistolet Sprühpistoleneinstellung	2 Giri Turns Tours Vueltas Umdrehunge		
	UGELLO Nozzle Buse Boquilla Düse	1,2-1,3 RP		
	PRESSIONE ARIA Air Pressure Pression de l'air Presión de aplicación Luft	1,8-2 RP		
	NUMERO MANI Number of coats Nombre des couches Numero de capas Anzahl Spritzgänge	Molto leggera-ancoraggio Very light – anchoring Très légère – ancrage Muy ligera – fijación Leichte Hand-Verankerung	S : 3 4 H : 2 Uniformi Uniform Uniformes Uniformes Einheitliche	 Sfumata Fade out Voile Du Placement Du Metal Difuminada Abtönung
	INTERVALLO TRA LE MANI Time interval between coats Intervalle entre les couches Intervalo entre capas Intervall zwischen den Spritzgängen	5' 10' - 20° 25°C Ventilazione Air drying Ventilation Ventilación Im Luftstrom		
SFUMATURA FADE OUT VOILE DE PLACEMENT DU METAL DIFUMINADA ABTÖNUNG				
	DILUIZIONE Diluition Diluition Diluición Verdünnung	S : 0% H : 50 or 30% depending on initial dilution (50 or 70%) 		
	REGOLAZIONE DELLA PISTOLA Airbrush adjustment Regulación de la pistola Réglage du pistolet Sprühpistoleneinstellung	1,5 - 2 Giri Turns Tours Vueltas Umdrehunge		
	UGELLO Nozzle Buse Boquilla Düse	1,2-1,3 RP		
	PRESSIONE ARIA Air Pressure Pression de l'air Presión de aplicación Luft	S 1,5 bar RP H 1,5 bar RP		
	DISTANZA DAL SUPPORTO Distance from the support Distance du support Distancia desde el apoyo Abstand von der Oberfläche	30 – 40 cm		

ESSICCAZIONE & RESA

Drying & Yield | Séchage & Rendement |
Secado & Rendimiento | Trocknung & Ergiebigkeit

	APPASSIMENTO Flash time Tiempo de secado Flétrissement Ablüftzeit	5' 10' - 20° 25°C Ventilazione Air drying Ventilation Ventilación Im Luftstrom
	ESSICCAZIONE COMPLETA Through drying Séchage complet secado completo vollständige Trocknung	20 °C: - 60 °C: -
	SPESSORE FILM SECCO Dry film thickness Espesor de película seca Épaisseur de la pellicule sèche Trockenschichtstärke	15 ± 3 µ
	RESA RFU – m² / kg x 1 µ Yield RFU Rendement RFU Rendimiento RFU Ergiebigkeit RFU	S : 130 H : 170

CARTEGGIATURA

Sanding | Ponçage
Lijado | Schmirgeln

	ROTO ORBITALE SECCO Roto-orbital dry sanding Orbital à sec Roto-orbital seco Exzenterschleifer Trocken	P600-P800 Vecchia Verniciatura Old Paint Coat Peinture Existente Antiguo pintado Alter Lackierung P500-P600 Fondo Filler Apprêt Aparejo Grundierung
	ROTO ORBITALE BAGNATO Roto-orbital wet sanding Orbital humide Roto-orbital mojado Exzenterschleifer Nass	-
	CART MANUALE BAGNATO Manual sanding on wet ponçage manuel humide lijado manual en húmedo manuelles schmirgeln auf feuchtem grund	-
	CART MANUALE SECCO Dry manual sanding Ponçage manuel à sec Lijado manual a seco Handschliff Trocken	P500-P600 Vecchia Verniciatura Old Paint Coat Peinture Existente Antiguo pintado Alter Lackierung P400-P500 Fondo Filler Apprêt Aparejo Grundierung
	SOVRAVERNICIABILE Overcoatable Survernissable Repintable Überstreichbar	5' Dalla sfumatura From the fading coat Á compter du Voile Du Placement Du Metal Desde la difuminación Ab Abtönungsanstrich

PRODOTTI COMPLEMENTARI

| Complementary products | Produits complémentaires | Productos complementarios | Komplementäres Produkt

	CATALIZZATORE Hardener Catalyseur Catalizador Katalysator	DILUENTE Thinner Diluant Diluyente Verdünner	AUSILIARI Auxiliaries Auxiliaires Auxiliares Hilfsmittel
993.MS--	Standard Maxi solid		
075.0020		Standard	
075.0015		Rapido Fast Rapide Rápido Schnell	
075.0030		Lento Slow Lent Lento Langsam	
074.DS--			Per sfumature For fade out Pour raccords fondus Para difuminados Für Abtönungen
900.FIX1			Fissativo Fixative Fixatif Fijador Fixiermittel

CONSERVABILITA'

Storing | Durée de conservation |
Tiempo de conservación | Haltbarkeit



CONSERVABILITA'

Storing | Durée de conservation |
Tiempo de conservación | Haltbarkeit

24 Mesi | Months | Mois | Meses | Monate
5 < °C < 35



927 | BASE OPACA_ TRIPLO STRATO

BASE COAT MATT_ TRIPLE LAYER

BASES MULTICRYL 900 + BINDER 900.DS25

DESCRIPTION

Class 927 of the Multicryl 900 series allows reproducing triple layer colors, matrices and variants of the cars and motorcycles of the world as well as the color codes used in the industrial body shop sector and ACE (Agriculture, Construction, Earthmoving) sectors through bases with a high pigment concentration and the 900.DS25 binding agent. Class 927 also includes low covering yield metalised and metal effect colors.

The covering yield of 927 colors sometimes calls for the use of a matching color filler: thus the final effect will be the result of the combination of the filler (926 matt base) and 927 matt base.

PRODUCT FEATURES - BENEFITS

- Colorimetric capacity: color point accuracy and wide range of the available formulations in the DataBase
- Easy application and fast drying
- Reproducibility over time: maximum base stability

DIRECTIONS FOR USE

PREPARATION:

- Use bases regularly mixed (after first opening)
- Each color formulation is available in the PalcolorFinder
- Filter the diluted product with a 2500- mesh filter (125µ)
- To avoid thermoplasticity phenomena, thin layers (20-30µ) must be applied. Given the complexity of reproducing these thicknesses accurately, it is recommended to always catalyse the 927 base at 10% with 993MS---

APPLICATION:

- Filler: For each color, the recommended filler color is reported in the Palcolorfinder.
- The 927 color must be applied on a well-dry and sanded filler:
 - o **1 light and very thin coat**
The distance from the substrate must be 20 cm, air pressure at the gun butt must be 3-4 bar when using a standard gun or 1.8 - 2.2 bar if using an HLVP-LVLP gun. Nozzle 1.2 - 1.3 mm
This stage is optional but highly recommended to remove any micro-impurities due to the presence of silicone in the air.

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STANDARD VERSION (Dilution 1 : 1)

- **3 to 4 uniform and even coats with a waiting time between one coat and the other of 5 minutes** up to the desired coverage is achieved.
Distance from the substrate must be 10-15 cm, gun adjustment according to table A.1
- **Final fade-out:** a very thin and uniform coat to be carried out when the last coat of the 927 base has reached almost full opacity (3 to 4 minutes after its application at 20°C) in accordance to the rules reported in the "fading out" section.

HIGH SOLID VERSION (Dilution 1 : 0.5:0.7)

- **2 standard and even coats**
Distance from the substrate must be 10-15 cm, gun adjustment according to table A.1
 - **Final fade-out:** further dilute the 927 matt base by 50 or 30% (depending on the initial dilution, 50% or 70%), then apply a very thin and uniform coat. Final fade-out must be carried out when the last coat of the 927 base has reached almost full opacity (3 to 4 minutes after its application at 20°C) in accordance to the rules reported in the "fading out" section.
- o After 5 minutes of drying time at 20°C apply the VOC 420 gr | lt series 223 solvent-based or series 123.0250 water-based clear coat

TABLE A.1.
AIRBRUSH ADJUSTMENT

GUN MODEL	SATA RP 4000/5000/55 00	WALCOM HTE	IWATA WB400	IWATA WBX400	DE VILBISS GT PRO T1 TRANS- TECH	DE VILBISS GT PRO H1 HVLP	ANI IDEA
NOZZLE	1.2-1.3 MM	1.2 MM	1.3 MM	1.2-1.3 MM	1.3	1.3	WB
PRESSURE IN BAR, MEASURED AT GUN BUTT	1.8 – 2.2 Bar	2.2 – 2.5 Bar	2 Bar	1.8 – 2 Bar	1.8 – 2 Bar	1 – 1.2 Bar	2.5 Bar
FAN-SHAPED OPENING	ALL OPEN	ALL OPEN	ALL OPEN	ALL OPEN	ALL OPEN	ALL OPEN	ALL OPEN
PRODUCT DISPENSING ADJUSTMENT (PRODUCT DISPENSER RPM)*	MIN 1.1/4 -2 MAX	MIN. 2 -2.3/4 MAX.	MIN 2.1/4 -3 MAX	MIN.1.3/4 -2.5 MAX.	MIN 1.1/2 -2.5 MAX	MIN 1.1/2 -2.1/4 MAX	MIN 2.1/4 -3 MAX
DISTANCE FROM THE OBJECT	10-15 CM	10-15 CM	10-15 CM	10-15 CM	10-15 CM	10-15 CM	10-15 CM

* the lower speed must be used for low-viscosity colors

SPECIAL NOTES

Painting of a triple-layer color calls for the following applications:

First layer class 926 matching color filler - 2 coats

Second layer class 927 pearlescent base - 2 coats

Third Layer clear coat

TOOL WASHING

Use washing thinner code 044----- or nitro thinner code 047-----.

ATTACHMENT

Fading out technique_000

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