

SHADES ACCURACY

100%



In the global automotive refinishing industry finding the exact match of an automotive colour shade and its correct formulation is regarded by technicians as a hard and demanding procedure. In order to respond to the customer demands our colour formulations should be precise. For this reason there must be an accurate, consistent, detailed and cost effective procedure. Taking all the above into consideration HB BODY S.A. working together with one of the greatest companies in colorimetry X-Rite is able to provide to the customer validity of colour matching like never before.

Providing instruments for colour matching, quality control and also a software including all the formulations of the handmade colored fan, we allow the customer to easily produce accurately and efficiently results speeding up the whole automotive refinishing procedure.



Auto Refinishing Products



COLOR SOLUTIONS BASE COAT 2K ACRYLIC PAINT SR

Mix system.



For over 35 years HB BODY S.A. has been manufacturing and distributing quality range of automotive refinishing products globally. The well established solvent borne paint system and 2K Acrylic Paint Scratch Resistant COLOR SOLUTIONS Mix System is now completed with the latest addition of AQUA - BODY Waterborne Mix System providing to the most demanding technician a complete solution. It utilizes high technology formulations resulting in high quality, high efficiency and excellent productivity. Both solvent borne and water borne base coat systems are easy to apply, have excellent coverage and are fast drying.

Color Solutions consists basic tinters (solid, metallic, pearl and Xirallic®) and Color Solutions 2K Acrylic Paint Scratch Resistant consists of basic non metallic toners and together are stored in a mixing machine. The colour swatches are handmade and painted using paint providing the Body Shop effectiveness and accuracy in colour matching. There is also a system for tintable primers consisting of five tinters (yellow, red, black, green and blue) used with P 360 2:1 HS Filling Primer or P 307 4:1 HS Filling Primer, achieving different shades.

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Auto Refinishing Products



COLOR SOLUTIONS BASE COAT

A one component solvent borne mix system consisting of high quality acrylic resin pigments. Thinned down with 50-70% 740 Acryl Normal / 741 Acryl Slow. Cleaned pre-treated surface using 770 Antisil Degreaser / 770 Antisil Degreaser Spray. Comprises basic tinters solid, metallic, pearls and Xirallic® pearls. Supplied with a specially designed mixing machine, manually sprayed colour chips and software for shade formulations.



COLOR SOLUTIONS 2K ACRYLIC PAINT SR

A high performance two component scratch resistant acrylic polyurethane system providing excellent gloss and durability. Comprises basic non metallic tinters. Cured with 50% of H 754 Hardener Fast / H 753 Hardener Normal / H 752 Hardener Slow depending on temperature. Supplied with a specially designed mixing machine, manually sprayed colorchip and software for shade formulations.



H 752 SLOW HARDENER FOR TOPCOATS H 753 NORMAL HARDENER FOR TOPCOATS H 754 FAST HARDENER FOR TOPCOATS

Isocyanate based hardener used with COLOR SOLUTIONS 2K Acrylic Paint SR providing excellent weathering and chemical resistance properties. Can also be mixed up to 5% with COLOR SOLUTIONS Basecoat Paint ONLY for the inner metallic parts of the car where no clear coat is applied e.g under the bonnet.



740 ACRYL NORMAL THINNER 741 ACRYL SLOW THINNER 742 ACRYL EXTRA SLOW THINNER

A universal thinner used for solvent borne acrylic based products. Contains high purity solvent blend for proper surface wetting and levelling. Addition of 50-70% with the COLOR SOLUTIONS Basecoat and 10-15% with COLOR SOLUTIONS 2K Acrylic Paint SR.



777 BLEND IN THINNER 777 BLEND IN THINNER SPRAY

Special Blend-in Thinner for COLOR SOLUTIONS Basecoat Paint. Suitable for all Mix System shades either metallic or non metallic, where blending (fade-out) on spot repairs is necessary.



COLOR SOLUTIONS BASE COAT

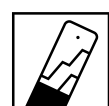
GENERAL TECHNICAL DESCRIPTION:

• A high performance basecoat mix system for motor vehicles

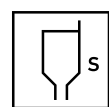
• Over 18,000 available shades

• Excellent mechanical and chemical resistance

• Great durability



Mix 2:1 with 740 ACRYL NORMAL / 741 ACRYL SLOW / 742 ACRYL EXTRA SLOW THINNER. Mix well and filter through paper filter



Ready to spray: 17-20 s / 20°C



Non force dry 15 - 20 min / 23°C

SURFACE:

• On Body Primed surfaces

• On 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:

Apply on motor vehicles. Apply two regular coats and a half coat so that the dry film thickness should not exceed 15-20 µm. Allow each coat to a mat finish.

Flash Point: 26°C / 79°F

Specific Gravity: 0.9 - 1.13 g/cm³ **

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. 2004/42/11B(e)(840)/750

Theoretical Coverage: 8 - 10 m² / l at 15 micron dry film thickness

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

Remarks:
• Allow for additional time for combi spray booths to reach the desired temperature.
• Application only with 740 ACRYL NORMAL or 741 ACRYL SLOW or 742 ACRYL EXTRA SLOW THINNER
• After preparing the area to be painted ensure that it is free from dirt, wax, oil etc.
• It can also be used by countries that do not adopt the VOC legislation.

Storage shelf life:
• Store in a cool place (+5°C - +25°C) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers.
** Specific weight values lie within a range and depend on the color shade.



HVLP 1.3 mm
1.5 - 2 bar inlet pressure
2 - 2.5 coats = 15-20 µm



Follow the application instructions mentioned in this TDS

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SPECIAL REFINISHING PRODUCT. 1K ACRYLIC MAT PRODUCT USED WITH THE METALLIC BASECOAT SYSTEM. DO NOT APPLY OVER IT.

COLOR SOLUTIONS 2K ACRYLIC PAINT SR

GENERAL TECHNICAL DESCRIPTION:

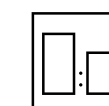
• VOC compliant with the regulations

• An Exceptional 2K acrylic, automotive finishing paint

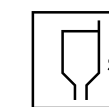
• Available in more than 6,000 shades

• Excellent scratch resistance

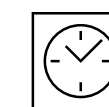
• High gloss finish



Mix 2:1 with H 752 SLOW / H 753 NORMAL / H 754 FAST HARDENERS Thinner addition 10-15% 740 ACRYL NORMAL / 741 ACRYL SLOW / 742 ACRYL EXTRA SLOW THINNER



Ready to spray: 17-23 s / 20°C



Oven force drying 20 - 45 min / 60-65°C
Non force dry 10 - 14h / 23°C

SURFACE:

• In Body Primed surfaces

• In metallic surfaces

• OEM surfaces

• Already pre painted surfaces for specific uses (military vehicles)



• 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 → Apply one coat, and after the 8-15 min flash off time apply the second coat.

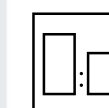
Flash Point: 28°C / 82°F

Specific Gravity: 0.9 - 1.18 g/cm³ **

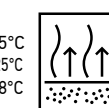
Solid Content (No thinner): 36 - 58% Weight

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 570 g/L. 2004/42/11B(e)(840)/570

Storage shelf life:
• Store in a cool place (+5°C - +25°C) and use within 12 months for best results. Guaranteed shelf life of 24 months in unused original containers.
** Specific weight values lie within a range and depend on the color shade.
*** Non force drying time depend on the hardener used.



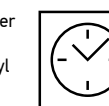
Mix 2:1 with Hardener H 752 SLOW @ temp. > 25°C H 753 NORMAL @ temp. 18 - 25°C H 754 FAST @ temp. 10 - 18°C Pot life: 2.5 - 6h /23°C



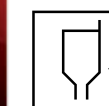
8 - 15 min / 23°C
Final flash off time



Addition 10-15% of thinner Use 740 Acryl Normal / 741 Acryl Slow / 742 Acryl Extra Slow Thinner



20 - 45 min / 60-65°C
panel temperature
Non force dry 10 - 14h / 23°C***



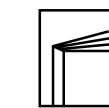
Ready to spray: 17-23 s
DIN 4 / 20°C



Always wear protective equipment



Conventional spray gun: 1.3-1.5 mm
2.5 - 3 bar inlet pressure
2 coats = 40 - 50 µm



Follow the application instructions mentioned in this TDS



HVLP 1.2 - 1.3 mm
2 bar inlet pressure

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