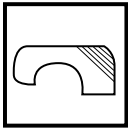
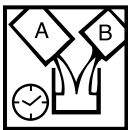


# Waterborne Basecoat



## SUITABLE SUBSTRATES

- OEM Enamels
- Aged Refinishes
- AWX® Undercoats
- UltraSystem® Undercoats
- AquaFill® W7A2260 1K Primer Surfacer
- AquaFill® W7A2260 1K Sealer



## MIXING



1  
AWX®  
Color



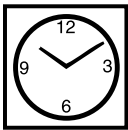
30%  
AWX® Basecoat Reducer  
4550025 Medium or 4550035 Slow

**NOTE:** Consider size of repair, humidity, and airflow when choosing a reducer. Refer to usage chart on next page.



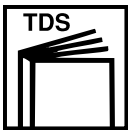
## APPLICATION

- Apply 1–3 medium coats or until hiding is achieved.
- Allow each coat to fully dehydrate prior to applying the next.
- 6–8 psi air cap pressure HVLP
- Fluid nozzle range: 1.2–1.3 MM
- Use a low-pressure finesse coat to even out metallic/mica colors for blending: 4–5 psi air cap pressure HVLP
- Film build should be between .5–1.0 mils



## RECOAT

- Allow 15–30 minutes flash or until fully dehydrated.
- Optional force dry: After dehydration, basecoat can be force dried (bake cycle or infrared) at 120–140° Fahrenheit for 5–10 minutes to improve productivity or improve dehydration in higher humidities. Allow basecoat to reach ambient temperature before clearcoat application.
- Clearcoat AWX® basecoat color with Sherwin-Williams® Clearcoat. See clearcoat product data sheets for specific instructions. Recommended clearcoats over AWX® are 1100755, CC920, CC921, CC923, CC927, HPC21 and SRC2 (VOC compliant clears). For national rule areas, 1100755, CC927, CC939, CC947 and HPC15 can also be used over top AWX®.
- Recoat window for waterborne basecoat is 7 days.



## NOTES

- Flash times between coats of base and base to clearcoat are dependent on temperature, humidity and airflow. The use of Venturi and heated air diffuser equipment will decrease flash times. **NOTE:** Allow 1–2 minutes of flash before using increased airflow to aid in the dehydration process.
- Do not use increased airflow (Venturi) after finesse coat application.
- Recommended strainer: 200–226 micron (finer strainers will negatively impact fluid flow and color).
- Do not add fisheye eliminator to AWX® Basecoat.
- AWX® basecoat may be dry sanded after dehydration with P500 or finer to remove imperfections. Apply more basecoat to sanded areas prior to clear coating.
- Potlife: 4 days reduced.
- It is important to practice good inventory management of any waterborne product, as the shelf life is shorter than of solvent-borne paints. Shelf life for chromatic toners is 36 months. Shelf life for aluminums is 24 months. Shelf life for 4010310, 4010350, and 4010401 is 18 months.



## PERSONAL PROTECTION

- For use by trained professionals only.
- Read label, directions and MSDS before use.
- Use appropriate Personal Protective Equipment while mixing and spraying.

## Best Demonstrated Practices

### SPECIAL NOTE FOR SPRAYOUTS:

Follow basecoat application methods outlined in the best demonstrated practices for waterborne basecoat.



I-CAR recommends following the paint manufacturer's recommendations for paint preparation, mixing and application of automotive refinish products.



**SHERWIN-WILLIAMS**  
Automotive Finishes

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## PRODUCT DESCRIPTION

AWX® Waterborne Basecoat is an easy-to-apply, fast-drying basecoat that provides excellent color matches to today's OEM Basecoat/Clearcoat finishes. AWX® Waterborne Basecoat is especially suited for high volume collision centers specializing in high quality car refinish repair.

## SURFACE PREPARATION

1. When sealing, final sand repair area with P400–P600 grit sandpaper. If directly top coating over primer surfacer, final sand with P600–P800 sandpaper. Dry sanding is recommended.
2. Solvent clean with appropriate Sherwin-Williams® surface cleaner and wipe dry with a clean cloth.
3. For large sand-throughs to bare metal treat with PE995 Corrosion Shield® LCF Etching Primer. For small sand-throughs to bare metal treat with P27 or P30 SpectraPrime® Primer Surfacer.

## PREPARATION FOR BLENDING PANELS (PRIOR TO BASECOAT APPLICATION)

1. Solvent clean with appropriate Sherwin-Williams® waterborne surface cleaner W4K157 and wipe dry with a clean cloth.
2. Blend panels should be sanded with P800-P1000 grit sand paper on a random orbital sander.
3. Repeat step one – then thoroughly tack the surface to be painted with a clean tack cloth.

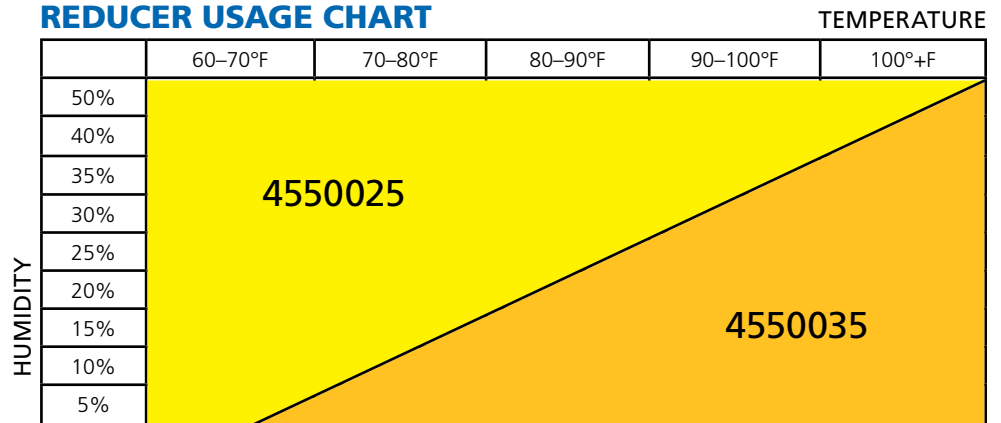
## DRYING SCHEDULE

Air dry times @ 75°F and 25% Relative Humidity:  
(NOTE: Higher humidity will extend dry times.)

Drying Schedule	Air Dry @ 75°F	Venturi @ 95°F
Dust Free	5–10 Minutes	2–3 Minutes
Tape Time	20–30 Minutes	10 Minutes
Time to Clearcoat	20–30 Minutes	10–15 Minutes

NOTE: Venturis that have the option of increasing air temperature will decrease your dry time significantly as shown above.

## REDUCER USAGE CHART



This is only a guide/starting point. Your conditions when choosing a reducer will also be based on size of repair and booth airflow. Reduction on the reducers is 30%. If humidity is above 50%, use 4550025 only.

## REGULATORY

	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	8.43	1009	8.53	1022
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	83.9	85.6	83.4	86.1
Water	73.5	74.5	73.1	74.4
Exempt Compounds	N/A	N/A	N/A	N/A
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	0.87	104	0.87	104
VOC Less Exempt	3.43	412	3.42	410
	Lb/Gal	KG/L	Lb/Gal	G/L
HAPs	4.98	0.597	1.19	0.142