

PANDATONE

AUTOMOTIVE REFINISH



PRODUCT CATALOGUE



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PTLV-805 MS Clearcoat (VOC < 250g)

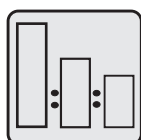
Product Features:

- 2K acrylic clearcoat, high fullness, high gloss, hard, chemical resistance and good weather resistance
- Provides balanced appearance and drying speed, good construction performance
- Combined with 1K basecoat, used for automotive accessories, partial body repair and whole vehicle spraying

Applicable substrate:

- 1K basecoat, treated 2K solid color topcoat and old paint surface

Mixing ratio:

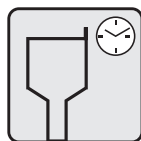


2 PTLV-805 MS Clearcoat
1 PTLV-815 MS Hardener

Usage time:

About 2-3 hours/20-25 °C

Spraying viscosity:



15~17 seconds/
apply #4 viscosity cup

Nozzle diameter:



Upper pot 1.3-1.5 mm
lower pot 1.4-1.7 mm*

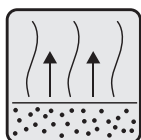
Spraying method:



Spray 2-3 times, with an interval of about 15-20 minutes between each time (based on the principle that it is not sticky to the touch)

Spraying pressure: 2-2.5Kgf/cm²

Flash-drying time:



At room temperature, after spraying, let it stand for about 5 to 10 minutes before heating and baking

Drying time: 60 °C × 60 minutes for polishing,
60 °C × 80 minutes for grinding and reworking

Natural drying:



At room temperature, dust-free time ≤ 50 minutes,
finger pressing time ≤ 8 hours 10 hours for polishing,
grinding and reworking requires more than 24 hours



PTLV-855 HS clearcoat (VOC < 250g)

Main application:

- Suitable for automobile repair and whole vehicle spraying.
It has the characteristics of high fullness, high gloss, good image quality, good weather resistance, and fast drying.

Chemical composition:

- Acrylic resin, additives, solvents, etc.

Liquid coating properties:

Color:	Transparent
Density (30°C):	1.1±0.05 g/ml
Viscosity (4# viscosity cup, 25°C):	18-19 seconds
Weight solid content (140°C, 1hours):	44.5±0.5%
Flash point:	>53°
Shelf life:	2 years

Various properties after mixing:

Ratio Project:	Weight Ratio
PTLV-855 HS clearcoat (VOC < 250g)	2
PTLV-865 HS Hardener (VOC < 250g)	1
Construction viscosity (2# cup):	About 11 seconds

Recommended construction parameters:

Base material:	1K color paint product surface
Dry film thickness:	About 30 microns
Surface drying time:	30 minutes
Baking and drying conditions:	70°C *60 minutes
Polishing time (self-drying):	16 hours

Construction method:

- Ordinary spraying



PTLV-885 Mirror Effect HHS clearcoat (VOC < 250g)

Main application:

- Suitable for automotive refinishing and full-vehicle spray painting. Features include high fullness, high gloss, excellent distinctness of image, excellent weather resistance, and fast drying.

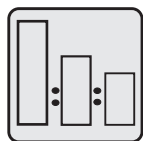
Chemical composition:

- Acrylic resin, additives, solvents, etc.

Liquid coating properties:

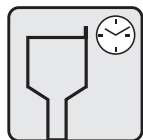
Color:	Clear
Density (30°C):	1.1 ± 0.05 g/ml
Viscosity (4# viscosity cup, 25°C):	18-19 seconds
Weight solid content (140°C, 1hours):	44.5±0.5%
Flash point:	>53°
Shelf life:	2 years

Mixed Properties:



- 2** PTLV-885 Mirror Effect HHS clearcoat (VOC < 250g)
- 1** PTLV-895 HS Hardener (VOC < 250g)

Application Viscosity (#2 cup):



Approximately 10.5 seconds

Recommended construction parameters:

Substrate:	Surface of product with 1K basecoat
Dry film thickness:	Approximately 30 microns
Touch Dry Time:	40 minutes
Bake Drying:	70°C for 60 minutes
Polishable Time (Air Dry):	24 hours

Construction method:

- Ordinary spraying

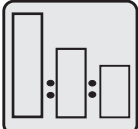


PTLV-1K Basecoat VOC 3.5lbs/gal(mixed)

Surface preparation:

- Remove wax, silicon or other contaminations with low VOC or waterborne degreaser.

Mixed Properties:

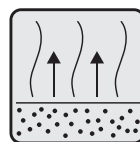
	1K Basecoat	+	Reducer
	Volume		60:80
	< 68°F	PTLV-1K Basecoat	PTLV-1
	> 68°F	PTLV-1K Basecoat	PTLV-1

Coats & Thickness :



2-3 coats, 15-25 µm

Flash-off:



68°F, 3-5 minutes between coats, then allow to dry for 10-15 minutes before applying clear coat.

Spray Gun Set:



RP: 1.3mm 29-36psi
HVLP: 1.3mm 26-29psi

Re-application :



If dust or other contaminates appear in the finished film, color sand with P-600 (dry) or P800 (Wet), then reapply the Low VOC Basecoat.

Notes:

- The substrate must be sanded and cleaned before spray. (wet sanding: P600-P800, drying sanding: P400-P600)
- Reducer should be added with Retarder Solvent at temperature is greater than 86°F. Details please refer to the technical data sheet (TDS) of Retarder Solvent for further details
- Because of the high transparency of pearl and/ metallic basecoat mixes, a good quality spray gun as well as professional spray techniques should be applied in order to prevent defects, mottling or poor metallic effects.
- To avoid problems of mottling, or poor adhesion, the thickness of metallic paint film shall be no greater than 25µm.
- Better effect can be achieved if any extra silver powder and/or dust particles can be removed from the refinish surface with a tack cloth after the flash-off between each coat.
- After spray, allow 10-15 minutes of air-drying time, then apply clear coat. Over air-drying of the basecoat can affect the adhesion properties of the basecoat to the clear coat.



PTLV-925 2K Primer (VOC < 250g)

Main application:

- Suitable for midcoat in automobiles, etc., to increase the thickness of the paint film.

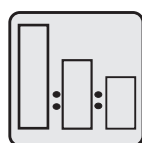
Chemical composition:

- Acrylic resin, pigment, filler, additive, solvent, etc.

Liquid coating parameters:

Color:	Gray
Density (20°C):	1.59 g/ml
Viscosity (Stormer 25°C):	100±5KU
Weight solid content (140°C, 1hours):	66.5±0.5%
Flash point:	>28°
Shelf life:	1 years

Mixed Properties:



PTLV-925 2K primer(VOC < 250)
PTLV-935 Hardener
Thinner

Weight ratio

5
1
1

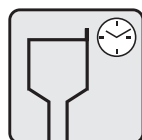
Volume ratio

3
1
1

Recommended construction parameters:

Base material:	Carefully polished epoxy primer
Dry film thickness:	60 microns
Surface drying:	About 3-5 minutes
Sanding time:	(25°C) Natural drying: more than 2 hours, Drying: 60°C*30 minutes (35°C) Natural drying: 1-1.5 hours

Construction viscosity (2# cup):



About 13 seconds

Construction method:

- Ordinary spraying



PTLV-1380 1K Binder & PTLV-1390 Flip Controller

Main application:

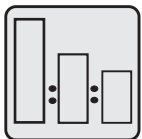
- For in the PTLV-1K basecoat system. Uses to speed up air drying time, enhance the orientation of silver & pearl particles, and improve the application properties.

For use with: PTLV 1K Basecoat toners

Characteristics

- PTLV-3520** Used to speed up air drying time, enhance the orientation of silver & pearl particles, and improve the application properties of the basecoat.
- PTLV-60** Used to lighten the side tone of the metallic basecoat color and create a darker face with the added appearance of larger metallic sparkle.

Mixing ratio:



1. Addition of PTLV-1380 to LV 1K metallic basecoat is 15-40% of total toner volume.
2. For PTLV 1K silver, white, or other lightly colored metallic basecoat, it is recommended that no less than 25% PTLV-1380 is used.
If silver basecoat is used individually, add 40% PTLV-1380.
3. In tri-coat pearl/candy colors, add up to 50-70% of PTLV-1380 into the pearl colors.
4. For basecoat colors with poor coverage, such as red pearl colors, the addition of PTLV-1380 should be less than 15% so as not to affect the coverage of the basecoat.
5. 20% or less of PTLV-1390 can be used to lighten the side tone of metallic colors, and create a darker face with appearance of increased metallic sparkle.
Adding too much of LV-1390 will affect the adhesion between the basecoat and clear coat.

Shelf Life:

- 2 years in original sealed can at cool and dry place at 41-95 °F

VOC:

- 3.5 lbs/gal(mixed)



PTLV-1400 Electroplate Binder

Characteristic:

- It's used to adjust the silver powder alignment, and it will make the solution seems white on the front and deep on the side.

Match with:

- Only used in recommended formulas, and the dosage should not more than 30% of the total formulas.

Shelf Life:

- 2 years in original sealed can at cool and dry place at 41-95 °F.

VOC:

- 3.5 lbs/gal(mixed)

Package:

- 1L



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