

DuPont™ Excel™ Pro Basecoat

3.5 VOC (EK quality)

Type

A two-component, 3.5 VOC, polyurethane basecoat.

Description

Ideal for dealers, independent shops, fleets and municipalities who want a cost-effective basecoat that features good performance, good color capability and very good appearance at a maximum applied VOC of 3.5 lbs/gal. Available in solid and metallic colors, this acrylic urethane basecoat uses the DuPont Multi-Temperature Platform and is mixed using PowerTint™ tints.

Suggested Uses

- Panel, multi-panel, overall repairs and rebranding
 - Two-tone applications
 - Older fleet assets, commercial vehicles, truck bodies, transit bus and light rail, beverage and delivery trailers, emergency vehicles
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Not Recommended For

Immersion service or over lacquer finishes.

Compatibility With Other Coatings

- Compatible with all DuPont OEM and DuPont Commercial Finishes primer systems.
 - Must be clear coated with DuPont™ Excel™ Pro 3430S™ 3.5 VOC or 3420S™ 2.1 VOC clear coats.
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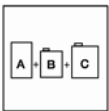
Dry Film Characteristics*

Chemical Resistance	EXCELLENT
Weatherability	VERY GOOD
Humidity Resistance	EXCELLENT
Acid Resistance	VERY GOOD
Alkali Resistance	EXCELLENT
Solvent Resistance	VERY GOOD
Abrasion Resistance	EXCELLENT
Flexibility	EXCELLENT

* Note – when properly clear coated.

Mix Ratio

Combine components and mix thoroughly. Filter material prior to spray application.



Two Component System	Parts by Volume
DuPont™ Excel™ Pro Basecoat (EK quality)	4
DuPont™ 15303S™, 15305S™ or 15307S™ Activator	1

DuPont™ 15303S™ Low Temp Activator
DuPont™ 15305S™ Medium Temp Activator
DuPont™ 15307S™ High Temp Activator

Add up to 2 oz. DuPont 189S™ Accelerator to activated gallon to extend pot life. Optionally, to improve tape time, DuPont™ 389S™ may be added up to 2 oz per activated gallon, or DuPont™ 8989S™ may be added up to 1 oz per activated gallon. Note: Use of DuPont™ 389S™ or 8989S™ will shorten pot life.

Initial application viscosity: 10-18 seconds with #3 Zahn Cup, depending on color.

A DuPont OEM / Commercial Finishes Product



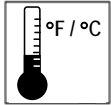


Pot Life and Induction Time

No induction time required. Pot life is 1 hr at 70°F (21°C); 1 ½ hrs at 70°F (21°C) with 2 oz DuPont™ 189S™ per RTS gal, 30 minutes with 2 oz DuPont™ 389S™ per RTS gal, or 20 minutes with 1 oz DuPont™ 8989S™ per RTS gal..

Additional Comments

Heating activated material above 110°F (43°C) will cause the product to gel. When recoating DuPont™ Excel™ Pro Basecoat with itself, sanding is required if the enamel has air dried more than 8 hrs or has been force dried.

**Application Conditions**

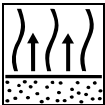
Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

Application

- Thoroughly mix DuPont™ Excel™ Pro (EK quality) prior to activation. The use of a cyclone shaker is recommended.
 - Pressure pot application is recommended for best color match and performance.
 - Apply DuPont™ Excel™ Pro Basecoat (EK quality) using a cross-coat technique. Spray a wet first coat using a top-to-bottom motion. Spray a medium-wet second coat using a side-to-side motion.
 - Flash times between coats will vary between 30 seconds and 5 minutes. In general, the shorter the flash the smoother the appearance.
 - Basecoat must be clear coated.
 - Allow DuPont™ Excel™ Pro (EK quality) basecoat to flash dry for 30 minutes prior to clear coat application.
 - If the ready to spray viscosity is above 18 seconds in a Zahn #3 at 70-75°F (21-24°C), you may use warm water or paint heaters to heat the paint to a temperature of 85-95°F (29-35°C) to achieve lower viscosity.
 - In case of fish eyes, add up to 1 oz. of DuPont™ 359S™ Additive per RTS gallon for solid colors or 1 oz. DuPont™ VGF-70050™ for metallic colors. Do not use FEE.
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**Gun Setup**

- Pressure pot fluid delivery should be set for 10 – 12 oz/min.
 - Refer to spray equipment documentation for setting recommendations.
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**Dry Time**

77°F (25°C) & 50% RH at recommended film thickness

	<u>With DuPont 189S™</u>
Dry to Touch	30 mins
Tack Free	60 min
Tape Free – Solids	90 min
Tape Free – Metallics	90 min
Dry to clear coat	30 min to 16 hrs

*Based on activation with DuPont™ 15305S™ Activator. DuPont™ 15303S™ and 15307S™ activator can be used at the prescribed ratio to adjust spray latitude for overspray melt-in and drying and tape times.

Application Equipment

Pressure Pot (recommended)
Gravity Feed
Suction Spray
HVLP or Conventional

Maximum Service Temperature

200°F (92°C) in continuous service

Volume Solids – Will Vary By Color

42.1% average unactivated
45.5% average RTS mixed 4:1 with DuPont™ 15305S™ Activator

Weight Solids – Will Vary By Color

53.6% average unactivated
56.1% average RTS mixed 4:1 with DuPont™ 15305S™ Activator

Weight Per Gallon

8.79 lbs/gal average unactivated

Suggested Dry Film Thickness

Apply until hiding is achieved. Solid and effect colors: 1.0 – 2.0 mils DFT, depending on color.

Theoretical Coverage Per Gallon

675 sq. ft./gal average @ 1 mil DFT

Gloss

High, when clear coated

Color

Available in solid, metallic and pearl colors

Flash Point (Closed Cup)

Between 20-70°F (-7 - 23°C)

Shelf Life

12 months minimum

Application Solvents

Ready to spray below 3.5 lbs/gal VOC upon activation. Further reduction will result in greater than 3.5 lbs/gal. DuPont™ 15375S™ Low Temp, 15385S™ Medium Temp, and 15395S™ High Temp reducers give the applicator the ability to customize the spray latitude based on the unit size and environmental conditions via choice of mixing formula reducer solvent from this range.

**Cleanup Solvents**

DuPont™ 106™ Gun Cleaner
DuPont™ 108™ Cleaning Solvent

Environmental

VOC content (lbs/gal)	LE	AP
DuPont™ Excel™ Pro Basecoat (EK quality)	3.8	3.8
Mixed 4:1 with DuPont™ 15305S™ Activator	3.5	3.5

For VOC Regulated Areas

These directions refer to the use of products that may be restricted or require special mixing instructions in your area. Follow recommendations in the DuPont Compliant Products Chart for your area.

Safety And Handling

DuPont is committed to helping you develop and maintain a safe working environment. Carefully read the specific warnings and precautions printed on the labels of all DuPont products before handling and using. These products are for industrial use by trained professional painters only.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

05/11

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