ECKART
Effect Pigments

Guiding Formulation

Waterborne OEM Base Coat

based on Bayhydrol XP 2621

Rec. No.	Date	Revised:
76-09019	26.04.07 /Mi	

		p. b. w.	
I.	Bayhydrol XP 2621, approx. 40% f.s.	28,05	www.bayer-ls.com
II.	Dest. water	17,90	
	Butyl glycol	3,08	
	Dimethylethanolamine, 10% in water	4,24	
	- 10 min. by propeller stirrer, at 5.2 m/s -		
III.	Viscalex HV 30, 30% f.s.	2,62	www.cibasc.com
	Dest. water	17,90	
	- 10 min. by propeller stirrer, at 5.2 m/s -		
IV.	Cymel 328, 85% f.s.	3,30	www.cytec.com
	Butyl glycol	3,08	
	Dest. water	8,79	
	- 10 min. by propeller stirrer, at 5.2 m/s -		
V.	Metallic-paste (Formulation; see on page 2)	11,04	
	- 30 min. by propeller stirrer, at 10.5 m/s -	---------	
		100,00	

Coating formulation
Take I and add II, III, IV and V in sequence after stirring times.
Before application, the pH of the base coat should be tested and if necessary, adjusted with a 10% aqueous solution of dimethylethanolamine. Then should be dest. water added to adjust the coating to spray viscosity, finally you have to sieve (for example 56µm sieve) the base coat.

Technical data :

Application viscosity, DIN cup, 4 mm	approx. 40s
Thinner	dest. water
pH-value	8.0-8.5
Drying condition	approx. 10 min. 80°C

(Re-coatable with for example 1K- or 2K- PUR clear coat.)

This information is for your advice on conscientiously executed tests. Considering the variety of tests this information is without warranty.

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Binder combination (solids on solids) :
Bayhydrol XP 2621 / Cymel 328 (approx. 80:20)

Pigments and additives on solid binder :	**p. b. w.**
Metallic-paste	approx. 25,5
Viscalex HV 30	approx. 5,6
Butyl glycol	approx. 44,0

Metallic paste		**p. b. w.**	
I.	Butyl glycol	41,88	
II.	Bayhydrol D 270, approx. 70% f.s.	2,89	www.bayer-ls.com
III.	Additol XL 250, 55% f.s.	4,36	www.cytec.com
IV.	Stapa Hydrolan 2156 No. 55900/G Aluminium, 60% f.s.	50,64	www.eckart.net
V.	Dimethylethanolamine, 100% f.s.	0,23	

		100,00	

Metallic paste formulation :
Take I and add II, III, IV and V in sequence, stirring slowly (propeller stirrer), test the pH-value (pH 8.0-8.5) and if necessary, adjust the paste with a 10% aqueous solution of dimethylethanolamine. Then stirring for 30 min. by a propeller stirrer at 10.5 m/s (max. temperature: 50°C).

Metallic paste data :

pH-value	8.0-8.5
Solid content	approx. 32.4 p.b.w.
Org. volatile content	approx. 64,5 p.b.w.
Aluminium powder content	approx. 28.4 p.b.w.

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