



GLOBAL REFINISH
SYSTEM

Product Information

Basecoat Colour (BC)

Product Description

The Global BC system consists of high opacity solid and metallic basecoat colours that require a clearcoat.

Global BC is designed for the repair of vehicles originally finished in a basecoat / clearcoat system.

Used in conjunction with a recommended Global repair system, Global BC meets or exceeds the performance requirements of motor manufacturer paint system warranties. Global BC carries a large number of OEM approvals.

Preparation of Substrate



Apply Global BC Colour over original stoved finishes or over recommended Global Primers.



In all cases, wash all surfaces to be painted with soap and water, then apply the appropriate Global cleaner. See GLG-142 Global Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.



Wet sand with European P800-1200 / U.S. 500-600 grade paper or dry sanding with European P600-800 / U.S. 400-500 grade paper.

Wash off residue and dry thoroughly before recleaning with appropriate Global substrate cleaner. The use of a tack rag is recommended.

APPLICATION GUIDE

Mixing Ratio:



BC Colour **1 vol***
Thinner **1 vol**

*D9700 Basecoat Black may be reduced 50-100%

*D888 must be added to both layers of a tri-coat color; reduce the ground coat 90% and the midcoat 100%. (See *additives section below*).

Thinner Selection:

Use the below chart to choose thinner according to the application temperature:

D870	Up to 18°C / 65°F
D871	18° – 25°C / 65° – 77°F
D872	25° – 35°C / 77° – 95°F
D873	Over 35°C / 95°F

Faster thinner may be needed for smaller jobs

Potlife:



@ 20°C / 68°F

No limit w/out D888 Activator
2 hours with D888 Basecoat Activator
(Stir well before using)

Additives:



D888 Basecoat Activator

Add 1.6 oz per ready to-spray quart or 5% per ready-to-spray volume.

Spraygun set-up:



1.3 – 1.5 mm or equivalent

Spray pressure:

HVLP at air cap

0.5 – 0.7 bar / 7 - 10 PSI

Conventional at spray gun

3 - 4 bar / 40 - 55 PSI

Number of coats:



2 normal coats

An optional light coat can be applied immediately after the last coat, to correct metallic orientation.

Flash off at 20°C / 68°F:



Between coats:

5 – 10 minutes

Optional light coat:

Immediately, for metallic control on last coat

Drying times:



Dust-free 20°C / 68°F:

5 – 10 minutes (10 –15 minutes with D888)

Tack-free 20°C / 68°F:

10 – 20 minutes (20 – 30 minutes with D888)

Tape-free 20°C / 68°F:

20 – 40 minutes (30 – 60 minutes with D888)



To Clearcoat 20°C / 68°F:

15 minutes minimum (24 hours maximum)

After 24 hours, surface must be sanded and basecoat colour reapplied.



APPLICATION GUIDE

Overcoat / Recoat:



Clearcoat

With any Global Clear

Performance Guidelines:

The use of HVLP spray equipment can increase transfer efficiency by about 10% depending on the make and model of equipment used.

Recoating times will be extended at lower temperatures.

Fading Out Global BC – The use of Global **D895 Color Blender** is recommended when blending metallic and mica basecoat colours. Add equal volumes of RTS D895 and RTS BC Colour. Apply this mixture to the edge of the repainted area and step out the color to complete blend. (See Global Bulletin EU113 for additional information on D895 Color Blender).

Technical Data:

Total dry film build	Minimum 10µm / 0.4 mils Maximum 25µm / 1.0 mils
Theoretical coverage	3.3 – 6.5 m ² per litre / 134 – 265 sq. ft. per US gal.
<i>Note: Theoretical coverage in m²/litre and sq.ft./US gal. Ready-to-spray (RTS), giving 25 µm (1 mils) dry film thickness.</i>	
Percent solids by volume RTS	8.4 – 16.5
VOC	
BC Colour	644 – 729 gms per litre / 5.38 – 6.08 lbs. per US gal.
BC: D871 (1 : 1)	750 – 790 gms per litre / 6.26 – 6.59 lbs. per US gal.
BC: D871: D888 (10 : 10 : 1)	713 – 761 gms per litre / 5.95 – 6.35 lbs. per US gal.

Health and Safety:

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and MSDS's of all the components, since the mixture will have the hazards of all its parts.



- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.



- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product MSDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

Basecoat Colour

Mix:



BC Colour	1 vol*
Thinner	1 vol

*D9700 Basecoat Black may be reduced 50 – 100%.

*D888 **must** be added to both layers of a tri-coat color; reduce the ground coat 90% and the midcoat 100%.

Temperature Selection Thinner

Up to 18°C / 65°F	D870
18°– 25°C / 65°– 77°F	D871
25°– 35°C / 77°– 95°F	D872
Over 35°C / 95°F	D873

Additives:



D888 Basecoat Activator	Add 1.6 oz per ready to-spray quart or 5% per ready-to-spray volume.
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Pot life:



@ 20°C / 68°F	No limit w/out D888 Activator 2 hours with D888 Basecoat Activator (Stir well before using)
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Air Pressure:



HVLP:	0.5 – 0.7 bar / 7 – 10 PSI at the air cap
Conventional:	3 – 4 bar / 40 – 55 PSI
Fluid tip:	1.3 – 1.5 mm or equivalent

Application:



Apply:	2 normal coats
Optional Light Coat:	An optional light coat can be applied immediately after the last coat, to correct metallic orientation.
Between Coats:	5 – 10 minutes

Dry times:



Dust-free 20°C / 68°F: 5 – 10 minutes (10 –15 minutes with D888)

Tack-free 20°C / 68°F: 10 – 20 minutes (20 – 30 minutes with D888)

Tape-free 20°C / 68°F: 20 – 40 minutes (30 – 60 minutes with D888)



To Clearcoat 20°C / 68°F: 15 minutes minimum (24 hours maximum)
After 24 hours, surface must be sanded and basecoat colour reapplied.



Emergency Medical or Spill Control Information (304) 843-1300; In Canada (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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