



**TECHNICAL DATA SHEET**  
**KOSMIC LUSTRE SILVER BASE**

**Description**

Kosmic Lustre Silver base is a single component metallic finish for Mild steel, Galvanized iron, Aluminum and wood. Provide with ease application, fast drying, excellent outdoor weather-ability and excellent orientation. Excellent compatible with all Nippon PU Clears and Wood Clears. This Base will be used for colour tinting purposes using tinters from ATS machine.

**Product**

**RIFSQ104L01I**

**Woods for which the product is suitable**

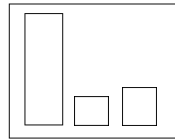
- Non resinous softwood
- Light colour hardwood
- MDF

**Product Properties**

In Can Appearance : Free Flowing Metallic Liquid  
 In Can Viscosity : 120 ± 10 secs @30°C Ford cup B4  
 Non Volatile Material : 45 ± 2%  
 WPL ( weight per litre) : 0.98 ± 0.02 gm./ml  
 Shelf Life : 1 Year (from date of mfg.)

\*\*\* Note – Product shelf life is determined at minimum temperature 10°C (50° F) maximum temperature 35°C (95°F)  
 -In 800 ml.Lustre Silver base toner to be added from ATS machine up to 10- 50ml.

**Mixing Ratio**



4 Parts by Volume – Kosmic Lustre Silver base  
 1 Part by volume – Nax Super hardener  
 30 - 35% by Volume- Pu Medium Thinner

**Complementary Products**

**Quantities**

Hardener	Super Hardener	In weight w/w %	25	
		In volume v/v %	25	
Solid Content %		<b>44± 2</b>		
Paint Mixing Qty(by volume & Weight)	Paint by Volume	Base-500 ml	Hardener-125 ml	Thinner-210 ml
	Paint By Weight	Base-500 gm	Hardener-100 gm	Thinner- 210 gm
Thinner	Pu Medium Thinner	In weight w/w %	34	
		In volume v/v %	34	

**READY TO USE PRODUCT PROPERTIES**

	Solid content 1st +2nd component(%)	44 ± 2
	Pot life @ 30°C	2.5 - 3 hrs
	Viscosity (Ford 4 cup)	18 ± 2
Code/Gloss	CODE	Gloss level EN ISO 2813 (angle measurement 60°)
	WPTCU011L01I	80 - 85 unit

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## Surface Preparation



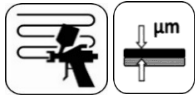
- Make Sure Proper Sanding of the Panel is done with #220-320 Mess
- No dust Particle should be present on the surface
- Remove all dust from surface using clean quality rags or wiping towels.
- Apply 2 Coat of Kosmic white filler,
- Sand the panel (#320-400 Mess) Properly, make sure no orange peel is seen on the panel.
- Apply 2 Coats of Kosmic Lustre Silver base

## Spray Gun Set Up



- Gravity Feed (Orifice) – 1.4 – 1.6 mm
- Air Pressure – 35-40 psi (2.4 – 2.75 Bar) at spray gun inlet.

## Application



Spray Gun

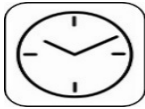
- 2 Coat Applications
- (65 – 75)  $\mu$  - spray Gun 1.4mm / (85-100)  $\mu$  Spray Gun Nozzle – 1.6mm For

- Flash Off in Between Coats – 2 -3 min @30°C, RT – 65%

## Products and Additives

Kosmic Lustre Silver base  
Nax Super Hardener  
Pu Medium Thinner

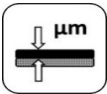
## Product Properties After Application



- Dust Free Time : 15 - 20 min
- Touch Dry : 1 - 1.5 hours
- Handability Dry : 2 - 3 hours @30°C

\*Note – All results are considerable at RT – 30°C & RH – 65%.

## Coverage



Theoretical Coverage – 50-55 Sq. ft. per litre At 50 -55 Microns DFT at 30C. The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, application pressure, application method and application circumstances.

## Product Performance Properties

- Gloss - Glossy Matallic finish
- Orange Peel – No orange Peel
- Cross Hatch adhesion – 2 mm (100\*100mm)
- PU Thinner Rub test – 20 times -Pass
- Finish-smooth
- Humidity Resistance – 240 C x RH 90% x 500hrs.
- Water resistance - 40°C/500 Hrs
- Alkali TEST (5% Nacl solution)– Pass
- Acid Test (5%H2SO4)- Pass
- PU Thinner Rub test – 20 times-Pass

\*\*Note – Product Shelf Life is determined when product is stored unopened at 30°C(86°F). Avoid Much temperature Fluctuation.