



Edition nº: 004. 2018/03



TECHNICAL SHEET

SERIE / **W6000**

WATERBORNE BASECOAT SYSTEM



PRODUCTS

WS/ Solid Bases WM/ Metallic Bases WP/ Pearl Bases WX/ Xirallic Bases WT/ Colorstream Bases WA/ Additives WSO/ Water Based Diluents

DESCRIPTION

The **W6000** Series is a very high performance water-based system with excellent hiding power and blending capability, which achieves a high productivity and an excellent finish.

A thorough work in our color laboratories, and a strict quality control of both raw materials and of the system basics, guarantees a perfect match on solid, metallic, pearls or special effect colors.

In combination with the Putties, Varnishes and Fillers of **SINNEK**, the **W6000** Series guarantees a perfect Car finish, with an excellent gloss, appearance and durability

SUBSTRATES

Application on steel:

- PF/9110, PF/7040, PF/7016 after sanding with P-400.
- PW/9110, PW/7040, PW/7016 wet on wet.

Application on plastics:

- PL/7870, PL/9005 for painting bumpers.
- PL/1895 for painting several plastic materials: PP, PUR, PS, PA, PP-EPDM, ABS, PVC, GRP.

SURFACE PREPARATION

Degrease with SO/1020 - SO/4020 silicone cleaner, dry with a clean cloth and use the tack cloth.

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SERIE W6000 PREPARATION

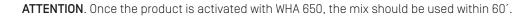
BICOAT PROCESS

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| | SOLID COLORS | METALLIC, PEARL AND SPECIAL EFFECT COLOR |
|--|---|---|
| Mixing ratio | Proportion in weight Color W6000 100 WS0/6000 [>30°C] 15-25 WS0/6001 [20-30°C] WS0/6002 [10-20°C] | Proportion in weight Color W6000 100 WSO/6000 (>30°C) 25-35 WSO/6001 (20-30°C) WSO/6002 (10-20°C) |
| Recommended Viscosity application at 20°C | 25-35" | 25-35" Maximum coverage with 15% WSO/6000- 6001-6002. With high temperatures dilute up to 35% to avoid overspraying and obtain a correc distribution and orientation of Aluminum and pearl particles. |
| Recommended filters | Use SINNEK filters recommended 125 mµ. | Use SINNEK filters recommended 125-190 mµ. |

TRICOAT PROCESS / SPECIAL EFFECTS

| | | WS BASE COAT | PEARL BASE / SPECIAL EFFECT COLOR WP-WX-WM-WT |
|------------------|---|--|---|
| | Mixing ratio | Proportion in weight Color W6000 100 WHA 6050 5 WSO/6000 [>30°C] 15-25 WSO/6001 [20-30°C] WSO/6002 [10-20°C] | Proportion in weight Color W6000 100 WSO/6000 (>30°C) 25-35 WSO/6001 (20-30°C) WSO/6002 (10-20°C) |
| FORD Nº4 S | Recommended Viscosity application at 20°C | 25-35" | 25-35" |



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SERIE W6000 APPLICATION

| ** | Gravity spraygun Application pressure | 1,2 - 1,3 mm 1,5-2 bar | 1,2 - 1,3 mm 1,5-2 bar (normal) / 1-1,5 bar (blend) |
|--------------|---|--|---|
| | Nr. layers | Solids 1-2 coats Evaporate between coats | ✓ ✓ 1-2 coats. 1 light coat for effect control Let evaporate between layers. Tricoat Pearl Fine layers up to original color Previously, corresponding first coat |
| <u>{t{t}</u> | Evaporation at 20 °C Drying with Dry Jet | 15-20' 5-10 <i>'</i> | 15-20' 5-10´ |
| | Drying at 20 ℃ | 15-20' Until complete evaporation or matt before using the clearcoat on top | 15-20' Until complete evaporation or matt before using the clearcoat on top |
| | 2C Clearcoat | Clearcoats to use CC/1758 CC/1770 CC/4790 CC/1764 | |

ADDITIONAL INFORMATION

- Identify and check the color before painting the vehicle.
- Use the mixing cups of **SINNEK** for mixing the color.
- Mix all ingredients correctly to match the color.
- It is recommended to apply the W6000 Series on the colored background indicated on each case

TECHNICAL SHEET

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SAFETY AND HYGIENE

Recommendable to use the appropriate personal protective equipment during application to avoid irritation of breathing tract, skin and eye irritation.

For professional use only.

STORAGE

Ready to use colors: 2-3 months. After this time, please contact our technical department. Keep covered in a dry and ventilated place, avoiding direct exposure to sunlight. We advise Temperature above 5°C, recommended between 15-30°C.



VOC

La Serie **W6000** has a lower organic solvent content than the traditional, compliant with the European Norm 2004/42/CE II[D] (420] <420 g/l

The information contained in this Technical Data Sheet is based on our knowledge and experience and with it we try to advise and inform, being the responsibility of the user to take the necessary measures to guarantee the intended purpose of the product. FOR PROFESSIONAL USE EXCLUSIVELY.

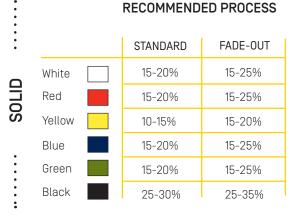
SINNEK Ugarte Industrialdea, 147 20720 Azkoitia (Gipuzkoa) - Spain

T: + 34 943 74 28 00 sinnek@sinnek.com www.sinnek.com

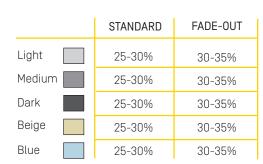
SINEK

DILUTION GUIDE FOR DIFFERENT PROCESSES

_ SERIE / **W6000**



RECOMMENDED PROCESS



ALTERNATIVE PROCESS

| STANDARD | FADE-OUT |
|----------|----------|
| 15% | 15-20% |
| 15% | 15-20% |
| 10-15% | 15% |
| 15-20% | 20% |
| 10-15% | 15-20% |
| 20-25% | 25-35% |

ALTERNATIVE PROCESS

| STANDARD | FADE-OUT |
|----------|----------|
| 20-25% | 25-30% |
| 20-25% | 25-30% |
| 20-25% | 25-30% |
| 20-25% | 25-30% |
| 20-25% | 25-30% |

*If the formula has more than a 50% of coarse aluminium pigments, reduce the dilution in a 5% from the above recommended guide.

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PEARL

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METALLIC

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RECOMMENDED PROCESS

| | STANDARD | FADE-OUT |
|--------|----------|----------|
| Red | 15-20% | 30-35% |
| Green | 15-20% | 30-35% |
| Purple | 20-25% | 25-30% |
| White | 15-20% | 20% |
| Black | 25-30% | 30-35% |
| Orange | 15-20% | 20% |

*Three layer colors 1st coat 15-20%.

*Three layer colors 2nd coat 30-35%

* All the percentages indicated must be considered as a guide.

ALTERNATIVE PROCESS

| STANDARD | FADE-OUT |
|----------|----------|
| 15% | 20% |
| 15% | 25-30% |
| 20-25% | 25-30% |
| 15% | 20% |
| 20-25% | 25-30% |
| 15-20% | 20% |