

SH 1K Waterborne Basecoat of Pearls (3-stage)

APPLICATION METHOD			
Surface Preparation		Remove wax, silicon or other contaminations with degreaser.	
Mixing Ratio (Weight/Volume)		Effect Colors	+ Viscosity Adjuster
		10-35°C(68-95°F)	100 WB3041 20-30
		35-40°C(50-104°F)	100 WB3043 20-30
Spray Viscosity		Spray Viscosity: 25 - 40 seconds (DIN 4 at 23°C)	
Spray Gun Setup	 	RP: 1.2-1.3 mm 1.3-1.8 bar HVLP: 1.2-1.3 mm 1.3-1.5 bar	
Coats		1. Basecoat Application (Please refer to the Coats of Solid colors). 2. Effect Coat Application (add 5% basecoat hardener to the ready-mixed paint): First coat: wet spray, then air or force dry. Second coat: mist spray. (Specific spraying method may be adjusted according to vehicle body color.) Dry Film Thickness: 10-20um	
Flash Off		Allow bake or air-drying equipment. Apply clear coat after the film turns matte.	
Dry Film Thickness		15±5um	

Precautions:

1. Surface must be sanded and cleaned before spraying (recommended sanding: dry sandpaper P500-P600).
2. Tools and containers for waterborne coatings must be made of water-resistant materials (e.g., stainless steel, plastic) or have suitable internal coating treatment.
3. Stir waterborne basecoat pigments thoroughly on a mixer before tinting; prepared waterborne basecoat should also be stirred promptly.
4. Do not spray on bare metal. If metal is exposed, apply epoxy primer, dry, then apply surfacer before waterborne basecoat application.
5. Film drying rate depends on ambient temperature, humidity, and air flow. Avoid application when humidity exceeds 85%.
6. If minor film defects (e.g., dust nibs) occur during basecoat application, after flash-off, dry sand with fine sandpaper (sponge sandpaper P1000-P1500) and repair.
7. Paint mixed with Viscosity Adjuster must be used within 24 hours.
8. Use a dedicated waterborne spray gun washer; clean the spray gun with deionized water. Clean all equipment immediately after spraying to prevent drying and clogging.
9. In three-stage white pearl applications, it is recommended to add 5% basecoat hardener to it before adding Viscosity Adjuster as usual. This significantly improves the water resistance of the film and prevents blistering.

Storage:

1. 5-30°C (41-86°F), ideally at cool and dry place at 23°C (73°F) with minimum temperature fluctuation.
2. Shelf life: 2 years in originally sealed cans.