

SH 1K Waterborne Basecoat of Metallic

APPLICATION METHOD					
Surface Preparation		Remove wax, silicon or other contaminations with degreaser.			
Mixing Ratio (Weight/Volume)		Effect Colors	+ WB3022 Binder	+ WB3020 Viscosity Balancer	+ Viscosity Adjuster
		20-35°C(68-95°F)	60	20	20
		10-40°C(50-104°F)	60	20	20
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. Apply a medium-wet coat. After confirming no defects, apply a continuous wet coat for full coverage (gun distance 10–15 cm). Air or force dry to tack-free. 2. Apply a mist coat as the effect layer (gun distance 25–30 cm). 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. For colors with high chroma and poor hiding power, add 5% WB3075 basecoat hardener to the waterborne metallic paint before adding the required Viscosity Adjuster. This improves intercoat adhesion and water resistance of the film.

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.