

SH 1K Waterborne Basecoat Solid colors

APPLICATION METHOD	
Surface Preparation 	Remove wax, silicon or other contaminations with degreaser.
Mixing Ratio (Weight/Volume) 	Solid Colors + WB3021 Binder + Viscosity Adjuster 10-35°C(50-95°F) 60 40 WB3041 10-20 35-40°C(95-104°F) 60 40 WB3043 10-20
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 one medium wet coat, after checking no defect, then another full wet coat at a gun distance of 10-15cm. Blow off or bake till the surface is dry. 2. Apply wet coat until coverage is achieved, maintaining a gun distance of 10-15cm. NOTE: Mist-spraying is NOT allowed in the last coat.
Flash Off 	Allow bake or air-drying equipment. Apply clear coat after the film turns matte.
Dry Film Thickness	15 ± 5µm

Precautions:

1. Surface must be sanded and cleaned before spraying (recommended sanding: dry sandpaper P400-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.

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.