Technical Data Sheet

Product Name: Nano-Ceramic Coating Series

Color Code:

Primer/Base coat: 810-HXD001 GRAY

Top coat: 340-AH010 SILVER

Printing Ink: 810-KH001 Black Ink

Substrate: Aluminum, Stainless steel, Aluminum Alloy

Operation Procedure

I.Pretreatment:

**a.   Degreasing: Use thinner, alcohol, ultra-degreaser for degreasing.
Poor degreasing process could cause pinhole and adhesion problems.**

**b.   Sandblasting: Use 60~80 mesh's sand for sandblasting. The
sandblasted surface must be very even. Bad sandblasted surface could
cause adhesion problems.**

c.   Air cleaning

II.Spraying application:

a.   Substrate preheated: P.M.T. should be the range of 45~55℃

b.   Spraying Primer/basecoat: WFT:1~1.5 mils ; DFT:15~20 microns

c.   Setting:3~5 minutes

**d.   Primer drying: bake schedule :P.M.T. should be the range of   60~80
℃x 5~10 minutes**

e.   Cooling

f.   Screen printing: 300~350 mesh

g.   Spraying Topcoat: WFT:0.5~1.0 mils ; DFT:5~10 microns

**h.   Sintering: bake schedule: 60~80℃   x 5~10 minutes(P.M.T.)
180~200℃ x 10~15 minutes(P.M.T.)**

III.Preparation:

1.Mixing: use mixer or roller to get paint even.

**2.Filtering: Primer/basecoat: use 300~400 mesh screen for filtering.
          Topcoat: use 150~180 mesh screen for filtering.**

2.   Reduction: not necessary for paint reduction.

IV. Dry Film Thickness:

One coat   Two coats

15~25μm   Primer/basecoat:15~20μm

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Topcoat:5~10μm

V. Cleaning Solvent:

Use MEK, Acetone or IPA for spraying equipment cleaning.

VI. Shelf life: 15~20 days at 20~25℃

** 30~45 days at 4~8℃**

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