

廣州利晟貿易有限公司

Guangzhou Nuway Trading Co., Ltd.

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## Technical Data Sheet

**Product Name: Nano-Ceramic Coating Series**

**Color Code:**

**Primer/Base coat: 810-DH019**

**Top coat:810-AH010**

**Printing Ink: 810-KH001**

**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°C
- 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°C 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°C x 5~10 minutes(P.M.T.)  
180~200°C 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.

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#### **IV. Dry Film Thickness:**

**One coat    Two coats**

**15~25µm    Primer/basecoat:15~20µm**

**Topcoat:5~10µm**

#### **V. Cleaning Solvent:**

**Use MEK, Acetone or IPA for spraying equipment cleaning.**

**VI. Shelf life:        15~20 days at 20~25°C**

**30~45 days at 4~8°C**

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