



Technical Data Sheet

Product Name: Nano-Ceramic Coating 810 Series

Color Code: Primer/Base coat: 810-DH019

Top coat: 810-AH010

Printing Ink: 810-WH001

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.

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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