



Mixing and Application Guide

U.S. Paint Insignia® brand topcoat and clearcoat are not aftermarket reproductions. These are the original OEM coatings that meet all HES (Honda Engineering Standards) testing requirements.

Surface Preparation

- Thoroughly wash surface with soap and water.
- Wipe surface with US Paint's RU0081, Wax & Grease Remover utilizing a "wax on, wax off" method. "Clean" with a clean, lint-free cloth, and "dry" with another clean, lint-free cloth.
- Sand with 400-600 grit or equivalent and re-clean.
- To remove all fingerprints, oils, and to minimize static, again wipe surface with US Paint's RU0081, Wax & Grease Remover utilizing a "wax on, wax off" method. "Clean" with a clean, lint-free cloth, and "dry" with another clean, lint-free cloth.
- Prime: For SMC substrate, use US Paint's NP1177/EP3080 epoxy primer. For plastic, use F6155/J3501 FRP primer/sealer.

Basecoat Mixing Ratio

Base code # / Description	Catalyst code	Reducer code
AJ1237 CANDY ALIZARIN RED BASE COAT R-345-C	J3501	T0159

Mixing instructions for the following amounts:	Base		Catalyst		Reducer	
	Ounces	Grams	Ounces	Grams	Ounces	Grams
Standard Mix Ratio	13.2	11.5	1.0	1.0	4.7	3.5
1 Quart / 32 oz.	32.0	898.9	2.4	78	11.3	273.1
1 Pint / 16 oz.	16.0	449	1.2	39	5.6	137
1/2 Pint / 8 oz.	8.0	225	0.6	20	2.8	68

Recommended Film Build: 0.8 – 1.2 mils DFT (dry film thickness)

Candycoat

Base code # / Description	Catalyst code	Reducer code
AJ7141 CANDY ALIZARIN RED CANDY COAT R-345-C	J3501	T0159

Mixing instructions for the following amounts:	Base		Catalyst		Reducer	
	Ounces	Grams	Ounces	Grams	Ounces	Grams
Standard Mix Ratio	5.5	4.6	1.0	1.0	4.0	3.0
1 Quart / 32 oz.	32.0	861.5	5.8	186.1	23.1	558.2
1 Pint / 16 oz.	16.0	431	2.9	93	11.5	279
1/2 Pint / 8 oz.	8.0	215	1.4	47	5.8	140

Recommended Film Build: 0.6 – 1.0 mils DFT (dry film thickness)

* U.S. Paint's Products are designed as an integrated coatings system. Use of Products not designed as part of such system are not recommended.

Clear Coat Mixing Ratio

Clear code #	Catalyst code #	Reducer code #	Accelerator code # (optional)
J3507	J3501	T0161	A0050

Mixing instructions for the following amounts:	Base		Catalyst		Reducer		Optional Accelerator	
	Ounces	Grams	Ounces	Grams	Ounces	Grams	Ounces	Grams
Standard Mix Ratio	4.5	4.0	1.0	1.0	0.9	0.7	0.21	0.17
1 Quart / 32 oz	32.0	908.0	7.0	227.0	6.4	158.9	1.5	38.6
1 Pint / 16 oz	16.0	454	3.5	114	3.2	79	0.7	19.3
½ Pint / 8 oz.	8.0	227	1.8	57	1.6	40	0.4	9.6

Recommended Film Build: 1.4 – 1.8 mils DFT (dry film thickness)

Application Instructions*

- **Normal pot life for basecoat and clearcoat at 70 °F is 2 hours.**
- **Fluid tip recommendation is 1.0 to 1.4 mm.**
- **Air pressure:**
 - **For HVLP guns, 25 lbs at the gun or 9-10 PSI at the cap is ideal.**
 - **For conventional guns, 35-45 PSI is ideal.**
- **For SMC substrate, use US Paint's NP1177/EP3080 primer. For plastic, use F6155/J3501**
- **Substrate must be primed with a black or very dark gray primer**

Important: When applying candy colors time between coats is critical.

Basecoat: Mix basecoat according to mixing guide above.

- Apply first coat to hide, or a minimum of 80% hide level.
- Flash for 10 minutes.
- Spray second coat to hide.
- Flash 10 minutes before applying pearl coat.

Pearlcoat: Mix pearl coat according to mixing guide above.

- Apply first coat to 50% recommended film build.
- Let it flash for 10 minutes.
- Spray second coat of pearlcoat to 100% recommended film build.
- Flash 10 minutes before applying clear coat.

Clear Coat: Mix according to mixing guide above.

- Apply full coat of mixed clear coat.
- Clear coat may be applied wet on wet – 10 minutes between each coat
- Let air dry minimum 24 hours or force cure maximum 30 minutes@ 180°F.

Without force-cure (bake), clear coat cure time is dependent upon film build. At ambient temperatures, typical “dry to touch” times for 2 coats are 3 hours, and for 3 coats are 5 hours. Addition of A0050 Accelerator will theoretically result in “dry to touch” times half that of normal. Although clear coat may be dry to touch, the film’s cure is still taking place. At least a 24-hour cure is recommended prior to packaging parts for shipment.

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APPLICATION CONDITION AFTER CATALYZATION AND REDUCTION: AJ1237

Viscosity	(Preferred 10.0 - 10.5 sec.) 10 to 13 seconds/ #3 Ford Dip Cup @ 77±1°F
Weight/Gallon (±0.25 lbs)	7.97
Solids(±2% Volume @ Recommended Reduction)	27.49
Solids(±2% Weight @ Recommended Reduction)	35.61
V.O.C. Content* @ Recommended Reduction	5.13 lb/gal, 615 gm/lr
Theoretical Coverage	441 Sq. Ft @ 1 mil DFT, 276 to 441 Sq. Ft @ Recommended DFT
Dry Film Thickness (Hiding <= 1.0 mils)	0.80-01.2 mils
Recommended Cure Schedule	30 Minutes @ 170°F
Filter Specification	150 Micron

SPECIAL INSTRUCTIONS:

P-MIX RATIO: 14.7 TO 1.0

ADDITIVE GUIDELINES: If fisheyes occur, add Flow Additive M3096 in increments of 1 fl. oz. to a maximum of 2 fl. oz. total per gallon of base. M3096 must be added to the base while the base is stirred mechanically.

Catalyze and reduce base normally.

APPLICATION CONDITION AFTER CATALYZATION AND REDUCTION: AJ7141

Viscosity	(Preferred 10.5 - 11.0 sec.) 10.5 to 13.5 seconds / #3 Ford Dip Cup @ 68- 78 ° F
Weight/Gallon (±0.25 lbs)	7.59
Solids(±2% Volume @ Recommended Reduction)	28.35
Solids(±2% Weight @ Recommended Reduction)	35.99
V.O.C. Content* @ Recommended Reduction	4.86 lb/gal, 582 gm/lr
Theoretical Coverage	455 Sq. Ft @ 1 mil DFT, 462 to 770 Sq. Ft @ Recommended DFT
Dry Film Thickness	0.6 – 1.0 mils
Recommended Cure Schedule	30 Minutes @ 175°F
Filter Specification	20 Micron

SPECIAL INSTRUCTIONS:

P-mix ratio is 6.94 to 1.00

ADDITIVE GUIDELINES: If fisheyes occur, add Flow Additive M3096 in increments of 1 fl. oz. to a maximum of 2 fl. oz. total per gallon of base. M3096 must be added to the base while the base is stirred mechanically.

Catalyze and reduce base normally.

*Any recommendation of U.S. Paint contained herein, covering use, utilization, chemical or physical properties and other qualities of the products sold is believed reliable; however, U.S. Paint makes no warranty or representation with respect thereto. Use or application of any U.S. Paint product is at the discretion of the Buyer without liability or obligation whatsoever of U.S. Paint.

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