



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/J3503 FRP primer/sealer.

Basecoat Mixing Ratio

| Base code # / Description | Catalyst code | Reducer code |
|---------------------------|---------------|--------------|
| AJ2057 STALLION BLACK | J3503 | T0159 |

| Mixing instructions for the following amounts: | Base | | Catalyst | | Reducer | |
|--|--------|-------|----------|-------|---------|-------|
| | Ounces | Grams | Ounces | Grams | Ounces | Grams |
| Standard Mix Ratio | 6.8 | 6.1 | 1.0 | 1.0 | 2.4 | 1.8 |
| 1 Quart / 32 oz | 32.0 | 911.4 | 4.7 | 150.6 | 11.2 | 271.2 |
| 1 Pint / 16 oz | 16.0 | 456 | 2.3 | 75 | 5.6 | 136 |
| ½ Pint / 8 oz. | 8.0 | 228 | 1.2 | 38 | 2.8 | 68 |

Recommended Film Build: 1.0 – 1.5 mils DFT (dry film thickness)

Clear Coat Mixing Ratio

| Clear code # | Catalyst code # | Reducer code # | Accelerator code # (optional) |
|--------------|-----------------|----------------|----------------------------------|
| J3507 | J3503 | 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)

* 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.

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, 18-20 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/J3503**

Basecoat: Mix basecoat according to mixing guide above.

- a) Apply first coat to hide, or a minimum of 80% hide level.
- b) Flash for 60 seconds..
- c) Spray second coat to hide.
- d) Flash 10 minutes before applying clear coat.

Clear Coat: Mix according to mixing guide above.

- a) Apply full coat of mixed clear coat.
- b) Clear coat may be applied wet on wet – 10 minutes between each coat
- c) 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.

| APPLICATION CONDITION AFTER CATALYZATION AND REDUCTION | |
|---|---|
| Viscosity | 18 to 20 seconds #2 Fisher Cup @ 77 ° F |
| Weight/Gallon (±0.25 lbs) | 7.93 |
| Solids(±2% Volume @ Recommended Reduction) | 36.51 |
| Solids(±2% Weight @ Recommended Reduction) | 43.3 |
| V.O.C. Content* @ Recommended Reduction | 4.50 lb/gal, 539 gm/lr |
| Theoretical Coverage | 586 Sq. Ft @ 1 mil DFT, 390 to 586 Sq. Ft @ Recommended DFT |
| Dry Film Thickness (Hiding <= 1.0 mil) | 1.0 to 1.5 Mils |
| Recommended Cure Schedule | 30 minutes @ 180 ° F |
| Filter Specification | 10 Micron |
| SPECIAL INSTRUCTIONS: | |
| APPLY 1ST COAT - FLASH 60 SECONDS APPLY SECOND COAT- FLASH 10 MINUTES APPLY J3507 CLEARCOAT | |
| 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. If fisheyes persist, add Fisheye Eliminator M9011 in increments of 0.1 fl. oz. to a maximum of 0.2 fl. oz. total in combination with 2 fl. oz. of M3096 per gallon of base. Both M3096 and M9011 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. | |
| * 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. | |