



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
AJ8099 STALLION TRI-COAT WHITE BASE	J3503	T0159

Mixing instructions for the following amounts:	Base		Catalyst		Reducer	
	Ounces	Grams	Ounces	Grams	Ounces	Grams
Standard Mix Ratio	8.4	9.7	1.0	1.0	4.0	3.0
1 Quart / 32 oz.	32.0	1192.9	3.8	123.2	15.3	369.7
1 Pint / 16 oz.	16.0	596	1.9	62	7.6	185
1/2 Pint / 8 oz.	8.0	298	1.0	31	3.8	92

Recommended Film Build: 1.0-1.6 mils DFT (dry film thickness)

Pearlcoat

Base code # / Description	Catalyst code	Reducer code
AJ8100 STALLION TRI-COAT WHITE PEARL	J3503	T0159

Mixing instructions for the following amounts:	Base		Catalyst		Reducer	
	Ounces	Grams	Ounces	Grams	Ounces	Grams
Standard Mix Ratio	12.0	10.6	1.0	1.0	4.7	3.5
1 Quart / 32 oz.	32.0	911.4	2.7	86.0	12.4	300.9
1 Pint / 16 oz.	16.0	456	1.3	43	6.2	150
1/2 Pint / 8 oz.	8.0	228	0.7	21	3.1	75

Recommended Film Build: 1.0 – 1.5 mils

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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	
	<i>Ounces</i>	<i>Grams</i>	<i>Ounces</i>	<i>Grams</i>	<i>Ounces</i>	<i>Grams</i>	<i>Ounces</i>	<i>Grams</i>
<i>Standard Mix Ratio</i>	4.5	4.0	1.0	1.0	0.9	0.7	0.21	0.17
<i>1 Quart / 32 oz</i>	32.0	908.0	7.0	227.0	6.4	158.9	1.5	38.6
<i>1 Pint / 16 oz</i>	16.0	454	3.5	114	3.2	79	0.7	19.3
<i>½ Pint / 8 oz.</i>	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, 18-20 lbs at the gun and 9-10 PSI at the cap is ideal.**
 - **For conventional guns, 35-45 PSI is ideal.**

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 pearl coat.

Pearlcoat: Mix pearl coat according to mixing guide above.

- a) Apply first coat to 50% recommended film build.
- b) Let it flash for 60 seconds..
- c) Spray second coat of pearlcoat to 100% recommended film build.
- 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.

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APPLICATION CONDITION AFTER CATALYZATION AND REDUCTION: AJ8099

Viscosity	16-18 SECONDS #2 FISHER CUP
Weight/Gallon (±0.25 lbs)	9.43
Solids(±2% Volume @ Recommended Reduction)	36.14
Solids(±2% Weight @ Recommended Reduction)	50.98
V.O.C. Content* @ Recommended Reduction	4.63 lb/gal, 555 gm/lr
Theoretical Coverage	580 Sq. Ft @ 1 mil DFT, 362 to 580 Sq. Ft @ Recommended DFT
Dry Film Thickness	1.0 to 1.6 Mils
Baking Instructions	30 MINUTES @ 180F
FILTER SPECIFICATION	150 Microns

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: AJ8100

Viscosity	16-18 SECONDS # 2 FISHER
Weight/Gallon (±0.25 lbs)	7.87
Solids(±2% Volume @ Recommended Reduction)	26.21
Solids(±2% Weight @ Recommended Reduction)	33.52
V.O.C. Content* @ Recommended Reduction	5.23 lb/gal, 627 gm/lr
Theoretical Coverage	420 Sq. Ft @ 1 mil DFT, 280 to 420 Sq. Ft @ Recommended DFT
Dry Film Thickness	1.0 to 1.5 Mils
Baking Instructions	30 MINUTES @ 180 F
FILTER SPECIFICATION	150 Micron

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.

SPECIAL INSTRUCTIONS: APPLY 1ST COAT OF AJ8099 - FLASH 60 SECONDS , APPLY 2ND COAT OF AJ8099- FLASH 10 MINUTES, APPLY 1ST COAT OF AJ8100- FLASH 60 SECONDS, APPLY SECOND COAT AJ8100 - FLASH 15 MINUTES, APPLY J3507 CLEARCOAT

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