



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
AJ9063 Crucible Orange (Candy) (YR-275M)	J3503	T0159

Mixing instructions for the following amounts:	Base		Catalyst		Reducer	
	Ounces	Grams	Ounces	Grams	Ounces	Grams
Standard Mix Ratio	6.7	6.1	1.0	1.0	3.6	2.7
1 Quart / 32 oz.	32.0	933.0	4.8	154.0	17.1	414.1
1 Pint / 16 oz.	16.0	466	2.4	77	8.6	207
½ Pint / 8 oz.	8.0	233	1.2	38	4.3	104

Recommended Film Build: 1.2-1.6 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.**

Important: When applying 2-stage candy colors, time between coats is critical. If applied too wet or heavy, color will be darker. If clear application is too early, color will be darker. Hotter or cooler temperatures should also be considered for flash times (shorten flash time in hot weather).

Basecoat: Mix basecoat according to mixing guide above.

- a) **Apply first coat to hide, or a minimum of 80% hide level.**
- b) **Flash for 10 minutes.**
- 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	(Preferred 10.0 - 10.5 sec.) 10 to 13 seconds / #3 Ford Dip Cup @ 77±1 ° F
Weight/Gallon (±0.25 lbs)	9.05
Solids(±2% Volume @ Recommended Reduction)	31.98
Solids(±2% Weight @ Recommended Reduction)	35.8
V.O.C. Content* @ Recommended Reduction	4.05 lb/gal, 485 gm/lr
Theoretical Coverage	513 Sq. Ft @ 1 mil DFT, 261 to 434 Sq. Ft @ Recommended DFT
Dry Film Thickness (Hiding <= 1.2 mils)	1.2 to 1.6 mils
Baking Conditions	30 minutes @ 170 ° F
Filter Specification	100 Micron

SPECIAL INSTRUCTIONS

YOU MAY REDUCE AS NEEDED USING 1A272 OR ACETONE.

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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