



## 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
AJ1232 HON 384 CANDY SPECTRA RED BASE COAT R-176-C	J3503	T0159

Mixing instructions for the following amounts:	Base		Catalyst		Reducer	
	Ounces	Grams	Ounces	Grams	Ounces	Grams
Standard Mix Ratio	9.9	9.0	1.0	1.0	4.8	3.6
1 Quart / 32 oz.	32.0	937.5	3.2	104.2	15.5	375
1 Pint / 16 oz.	16.0	469	1.6	52	7.8	188
1/2 Pint / 8 oz.	8.0	234	0.8	26	3.9	94

Recommended Film Build: 1.0 – 1.4 mils DFT (dry film thickness)

### Candycoat

Base code # / Description	Catalyst code	Reducer code
AJ7138 HON 383 CANDY SPECTRA RED CANDY COAT R-176-C	J3503	T0159

Mixing instructions for the following amounts:	Base		Catalyst		Reducer	
	Ounces	Grams	Ounces	Grams	Ounces	Grams
Standard Mix Ratio	5.6	4.9	1.0	1.0	1.3	1.0
1 Quart / 32 oz.	32.0	896.7	5.7	183	7.4	179.3
1 Pint / 16 oz.	16.0	448	2.8	91	3.7	90
1/2 Pint / 8 oz.	8.0	224	1.4	46	1.9	45

Recommended Film Build: 1.8 – 2.2 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)
<b>J3507</b>	<b>J3503</b>	<b>T0161</b>	<b>A0050</b>

<b>Mixing instructions for the following amounts:</b>	<b>Base</b>		<b>Catalyst</b>		<b>Reducer</b>		<b>Optional Accelerator</b>	
	Ounces	Grams	Ounces	Grams	Ounces	Grams	Ounces	Grams
<b>Standard Mix Ratio</b>	4.5	4.0	1.0	1.0	0.9	0.7	0.21	0.17
<b>1 Quart / 32 oz</b>	32.0	908.0	7.0	227.0	6.4	158.9	1.5	38.6
<b>1 Pint / 16 oz</b>	16.0	454	3.5	114	3.2	79	0.7	19.3
<b>½ Pint / 8 oz.</b>	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 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**
- **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 clear 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: AJ1232***

Viscosity	(Preferred 10.0 - 10.5 sec.) 10 to 13 seconds/ #3 Ford Dip Cup @ 77±1°F
Weight/Gallon (±0.25 lbs)	7.85
Solids(±2% Volume @ Recommended Reduction )	29.75
Solids(±2% Weight @ Recommended Reduction )	38.2
V.O.C. Content* @ Recommended Reduction	4.85 lb/gal, 581 gm/lr
Theoretical Coverage	477 Sq. Ft @ 1 mil DFT, 346 to 485 Sq. Ft @ Recommended DFT
Dry Film Thickness (Hiding <= 1.0 mils)	1.0 to 1.4 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: AJ7138***

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)	7.86
Solids(±2% Volume @ Recommended Reduction )	37.22
Solids(±2% Weight @ Recommended Reduction )	45.56
V.O.C. Content* @ Recommended Reduction	4.28 lb/gal, 513 gm/lr
Theoretical Coverage	597 Sq. Ft @ 1 mil DFT, 276 to 337 Sq. Ft @ Recommended DFT
Dry Film Thickness	1.8 to 2.2 mils
Recommended Cure Schedule	30 Minutes @ 175°F
Filter Specification	20 Micron

## SPECIAL INSTRUCTIONS:

P-mix ratio is 6.94 to 1.00

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**Catalyze and reduce base normally.**

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