



## 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
<b>AJ9109 HON379 MATT AXIS ORANGE YR-256M</b>	<b>J3503</b>	<b>T0159</b>

Mixing instructions for the following amounts:	Base		Catalyst		Reducer	
	Ounces	Grams	Ounces	Grams	Ounces	Grams
Standard Mix Ratio	14.5	12.5	1.0	1.0	3.3	2.5
1 Quart / 32 oz.	32.0	893.2	2.2	71.2	7.4	178.1
1 Pint / 16 oz.	16.0	447	1.1	36	3.7	89
1/2 Pint / 8 oz.	8.0	223	0.6	18	1.8	45

Recommended Film Build: 1.6-2.2 mils DFT (dry film thickness)

### Flat Clear Coat

Clear code #	Catalyst code #	Reducer code #	Accelerator code # (optional)
<b>AF3070</b>	<b>J3503</b>	<b>T0161</b>	<b>A0050</b>

Mixing instructions for the following amounts:	Base		Catalyst		Reducer		Optional Accelerator	
	Ounces	Grams	Ounces	Grams	Ounces	Grams	Ounces	Grams
Standard Mix Ratio	9.3	8.7	1.0	1.0	6.3	4.8	0.21	0.17
1 Quart / 32 oz.	32.0	956.8	3.4	110.4	21.5	534.1	1.5	38.6
1 Pint / 16 oz.	16.0	478	1.7	55	10.7	267	0.7	19.3
1/2 Pint / 8 oz.	8.0	239	0.9	28	5.4	134	0.4	9.6

Recommended Film Build: 0.8 – 1.2 mils

\* 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.*
- *Substrate must be primed with a black or very dark gray primer.*

*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 11.0 - 12.0 sec.) 11.0 to 14.0 seconds / #3 Ford Dip Cup @ 68- 78 ° F
Weight/Gallon (±0.25 lbs)	7.84
Solids(±2% Volume @ Recommended Reduction )	21.64
Solids(±2% Weight @ Recommended Reduction )	29.84
V.O.C. Content* @ Recommended Reduction	5.37 lb/gal, 644 gm/lr
Theoretical Coverage	347 Sq. Ft @ 1 mil DFT, 160 to 220 Sq. Ft @ Recommended DFT
Dry Film Thickness (Hiding <= 1.6 mils)	1.6 to 2.2 mils
Baking Conditions	30 @ 175 F
Filter Specification	100 Micron

**SPECIAL INSTRUCTIONS**

P-mix ratio is 22 to 1

**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.**

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