

# SHIVSHAKTI PAINTS

AN ISO 9001:2008 CERTIFIED COMPANY

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## METHOD OF APPLICATION FOR EPOXY / P. U. PAINT

Use rubber gloves, mask, and stirrer while application.

1) Degrease the Surface with Proper solvent. Preferably by N. C. thinner or compatible solvent. Apply three in one solution or adopt seven-tank pretreatment process. OR only shot or sand blast the surface before applying primer.(Preferred SAE 2 ½ ) The primer should be applied within one hour after the process of shot blasting pretreatment is done

2) Prepare the required quantity of epoxy primer with 1:4 ratio of hardner to base by volume, thin the primer with epoxy thinner by 20% to 30% to attain proper spraying viscosity (20 to 22 seconds on ford cupB4).Apply the coat of Epoxy primer. Allow it to AIR Dry for 6 to 8 hours; preferably overnight.

3) After priming see for any uneven surface dents and fill it with n. c. / polyester putty. Allow it to dry & wet sand it with 300-600 wet sanding paper. Allow it to dry before painting.

4) Prepare the required quantity of epoxy / polyurethane paint with 1:4 ratio of hardner to base by volume, thin it with Epoxy/ P. U. Thinner by 25% to attain proper spraying viscosity (20 to 22 seconds on ford cupB4). Apply a coat of Epoxy / P. U. paint. The pressure of air should be 4kg/cm2 (bar). Apply the second coat after first coat is hard dry. After confirming the gloss, shade, and covering or any other defect, apply the final second coat. The higher air pressure will create dry spray i.e. you will have the powdery surface when touched by hand after drying. Hence higher pressure must be avoided. Use of desiccators and draining of water in the compressor tank should confirm the dry air. This water is because of condensation of water vapor present in the air tank.

5) The above mentioned system is air drying, but to avoid delay you can cure it by heat / oven. For force drying of the paint or primer, after flash of (After evaporation of solvents/ thinner) keep the job in oven @ 80 – 100 °C for 15 to 20 minutes. This is a optional procedure.