

Easy Coat, Easy Life

EasiCoat

PRODUCT INSTRUCTION



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EASICOAT PROFESSIONAL REFINISH SYSTEM

Easy Coat, Easy Life

EasiCoat CAR PAINT

Quality

Consistency

Efficiency



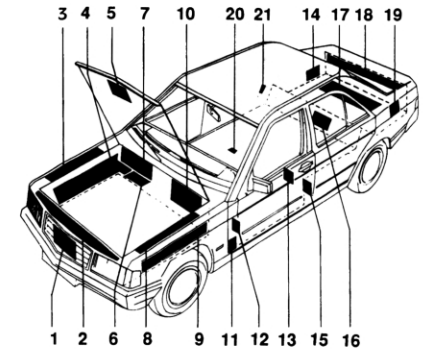
E5 Comprehensive And Full Capability

E3 Simple Compact System

Location Guide of Original Color Code in Vehicle Body

How to locate the color code —

Most of the vehicle bodies have information ID cards with color code. Locations of those ID cards are different among manufacturers with different car models.

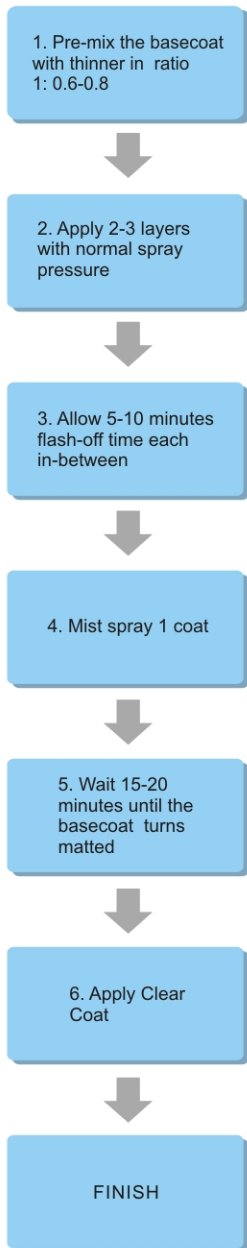


The following table shows the location of color code in vehicles:

Vehicle Manufacturers	ID Locations	Vehicle Manufacturers	ID Locations
Acura	15	Maserati	5
Alfa Romeo	5,18	mazda	7,10
Audi	14,17,18	Mercedes Benz	2,3,8,10,12,15
BMW	3,4,7,8	Mitsubishi	2,7,10,15
Chrysler	2,8,9	Nissan	2,4,7,10
Cirtoen	2,3,4,7,8,10	Opel	2,3,4,7,8,0
Dacia	7,10,18,19,14	Peugeot	2,3,8
Daihatsu	2,7,10	Porsche	2,7,8,12,15
Ferrari	5,18	Proton	2,7,10
Fiat	3,4,18	Reliant	3,4,7,9,10
Ford Europe	2,3,4,7,8,15,17,18	Renault	3,7,8,10
Ford USA	15	Rolls Royce	3,5
General Motors(color codes)	2,7,10,12	Rover	2,5
Honda	15	Saab	3,8,10,17
Hyundai	2,7,10,15	Saturn	19
Infiniti	7,10	Seat	3,8,18
Isuzu	2,7,10,13,15	Skoda	8,10,17
Iveco	5	Subaru	2,7,8,15,10
Jaguar	2,4,5,15	Suzuki	7,11,17,10
Lada	4,5,8,17,18,19	Toyota	3,4,7,8,10,15,17
Lamborghini	18	Vauxhall	2,4,8,9,10
Lancia	2,4,5,7,18	Volkswagen	1,2,3,7,8,14,17,18,19
Lexus	3,7,10,15	Volvo	2,3,7,10,11,12,15
Lotus	3,8		

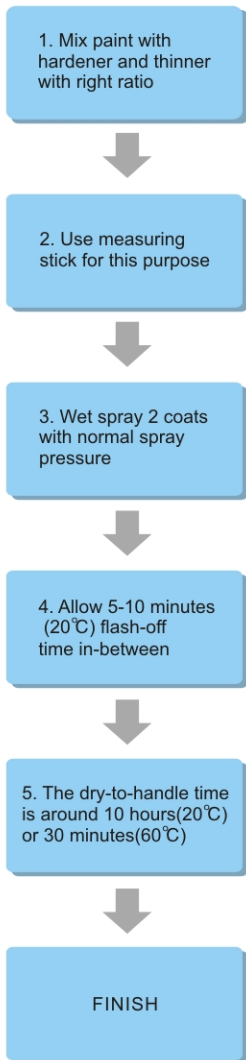
**1K Basecoat Colors
Application Flow Chart**

1、 1K Basecoat Colors



**2K Solid Colors
Application Flow Chart**

2、 2K Solid Colors



E5

EC-2K Solid Colors.....	1
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EC-1200 Standard Clear Coat.....	3
EC-2200 HS Clear Coat.....	4
EC-3200 Premium Clear Coat.....	5
EC-5200 Clear Coat Kit.....	6
EC-7200 Extra Fast Clear Coat.....	7
EC-2K Series Hardener.....	8
EC-E Series Thinner.....	9
EC-5340 Plastic Primer.....	10
EC-5351 Fast Epoxy Primer.....	11
EC-5352 Epoxy Primer.....	12
EC-5441 Fast 2K Primer Surfacer.....	13
EC-5442 2K Primer Surfacer.....	14
EC-5470 1K Primer Surfacer.....	15
EC-5480 Filler.....	16
EC-5510 2K Binder.....	16
EC-5520 1K Binder EC-5530 Flip Controller.....	17
EC-5910 Degreaser.....	18
EC-5920 Thinner SRA.....	18
EC-5930 Anti-Silicon.....	19
EC-5940 Matting Agent.....	19
EC-5941 Transparent Matting Agent.....	20
EC-5960 Retarder Solvent.....	21
EC-5980 Quick Drier.....	21

E3

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E3-800 Clear Coat Kit.....	24
E3-800W Extra Fast Clear Coat	25
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Car paint application flow chart

Yatu - EasiCoat colourbase's characteristic table

Note:The mixing ratio is ratio by volume except as otherwise specified.

Pictograph



Cleaning



Mixing ratio-
2 components



Mixing Ratio-
3 components



Ready for use



Use measuring rulers



Add hardener



Pot Life



Gravity feed spray gun



Suction feed
spray gun



No. of coats



Flash-off time



Drying time



Dry sanding
by machine



Wet sanding by hand



Dry sanding by hand



Polishing



Use spreader



Refer to product
Instruction

EC-2K Solid Colors

Characteristic: Medium and high class 2K topcoat solid colors, good hardness, high gloss and build, excellent protective and covering power, long lasting bright color.

Substrates: Sanded and dried existing finishes, 1K or 2K primer.



	Surface Cleaning: Remove wax, silicon and other contaminations with degreaser																														
	<table border="1"> <tr> <td>Mixing Ratio</td> <td>Solid Colors</td> <td>+</td> <td>Hardener</td> <td>+</td> <td>Thinner</td> </tr> <tr> <td></td> <td>2</td> <td></td> <td>1</td> <td></td> <td>0.2-0.5</td> </tr> <tr> <td>< 18°C</td> <td>EC-2K Solid Colors</td> <td></td> <td>EC-5611</td> <td></td> <td>E-1</td> </tr> <tr> <td>18-30°C</td> <td>EC-2K Solid Colors</td> <td></td> <td>EC-5612</td> <td></td> <td>E-2/E-3</td> </tr> <tr> <td>>30°C</td> <td>EC-2K Solid Colors</td> <td></td> <td>EC-5613</td> <td></td> <td>E-3</td> </tr> </table>	Mixing Ratio	Solid Colors	+	Hardener	+	Thinner		2		1		0.2-0.5	< 18°C	EC-2K Solid Colors		EC-5611		E-1	18-30°C	EC-2K Solid Colors		EC-5612		E-2/E-3	>30°C	EC-2K Solid Colors		EC-5613		E-3
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Note:

- The substrate must be sanded and cleaned before spray. (Wet sanding: P600-P800, drying sanding: P400- P600)
- At temperature lower than 15°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C.
- At ambient temperature higher than 30°C, add Retarder Solvent into thinner to avoid blushing. For details please refer to the technical data sheet of Retarder Solvent.
- In the event of fisheyes during application, add 0.5-1% Anti Silicon in the paint remained and re-spray the affected area.
- In the overspray area of new and existing finish, apply directly Thinner SRA to achieve an invisible transition. For details please refer to the technical data sheet of Thinner SRA.
- The products mixed with hardener should be used up soon and can not restore for future use.
- Clean equipments immediately with solvent after application.
- If there are particles or runs after spray, sand the affected area with P1200-P2000 sand paper after thorough drying, then polish to solve the problem.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 1L or 3.75L

EC-1K Basecoat Colors

Characteristic: Single component basecoat with solid colors, metallic and pearl effect, made from weathering resistant resins, high quality, strong covering power, and excellent adhesion power.

Substrates: Sanded and dried existing finishes, 1K or 2K primer.



	Surface Cleaning: Remove wax, silicon and other contaminations with degreaser																				
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Note:

- The substrate must be sanded and cleaned before spray. (Wet sanding: P600-P800, drying sanding: P400- P600)
- At temperature over 30°C or in high humidity, it is recommended to use Retarder Solvent to avoid mottling.
- Because of the high transparency of metallic basecoat, good quality spray gun and professional spray techniques are required in order to prevent defects of mottling or poor metallic effects.
- To avoid problems of mottling or poor adhesion, the metallic paint film should not be thicker than 25um.
- Better effect could be achieved if the extra silver powder could be removed with tack rag after the flash-off of each coat.
- After spray, allow 10-15 minutes air-drying time, then spray clear coat at once. Over long air drying time would affect the adhesion power.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C


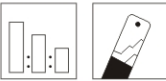


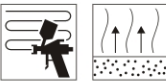

Packaging: 1L or 3.75L

EC-1200 Standard Clear Coat

Characteristic: Medium solid double component mirror effect fast drying clear coat, high gloss, good and build, chemical resistant, excellent color and gloss protective power.

Substrates: 1K Basecoat



	Surface cleaning: Clean the dust and particles with tack cloth					
	Mixing Ratio	Clear Coat	+	Hardener	+	Thinner
		2		1		0-0.2
	< 18°C	EC-1200		EC-5611		E-1
	18-30°C	EC-1200		EC-5612		E-2/E-3
	>30°C	EC-1200		EC-5613		E-3
	Pot-Life at 20°C: 2 hours with EC-5611 fast hardener 3 hours with EC-5612 standard or EC-5613 slow hardener					
	Spray Gun Set Up	Gravity Feed: 1.2-1.4mm Suction Feed: 1.3-1.5mm Conventional: 3-4 bar RP: 2.0-2.5 bar HVLP: 2.0 bar				
	Coats & Thickness	2-3 coats, total 40-60um				
	Flash-Off Time	At 20°C, 5-10 minutes between coats				
	Air-Drying Time	Allow 15-20 minutes air drying time before force drying				
	Drying Time:					
	Temperature	Dust Free	Tack Free	Dry to Handle	Dry to Polish	
	20°C	45 minutes	2-3 hours	10 hours	16 hours	
	60°C	5 minutes	15 minutes	30 minutes	60 minutes	

Note:

- At temperature lower than 15°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C.
- At ambient temperature higher than 30°C, add Retarder Solvent into thinner to avoid blushing. For details please refer to the technical data sheet of Retarder Solvent.
- In the event of fisheyes during application, add 0.5-1% Anti Silicon in the paint remained and re-spray the affected area.
- In the overspray area of new and existing finish, apply directly Thinner SRA to achieve an invisible transition. For details please refer to the technical data sheet of Thinner SRA.
- The products mixed with hardener should be used up soon and can not restore for future use.
- Clean equipments immediately with solvent after application.
- If there are particles or runs after spray, sand the affected area with P1200-P2000 sand paper after thorough drying, then polish to solve the problem.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C





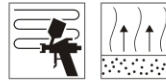

Packaging: 1L or 4L

EC-2200 HS Clear Coat

Characteristic: High performance double component clear coat, high gloss, good build, strong chemical resistant, excellent color and gloss protective power, suitable for overall refinishing and spot repair.

Substrates: 1K Basecoat



	Surface cleaning: Clean the dust and particles with tack cloth					
	Mixing Ratio	Clear Coat	+	Hardener	+	Thinner
		2		1		0.2-0.5
	< 18°C	EC-2200		EC-5621		E-1
	18-30°C	EC-2200		EC-5622		E-2/E-3
	>30°C	EC-2200		EC-5623		E-3
	Pot-Life at 20°C: 2 hours with EC-5621 fast hardener 3 hours with EC-5622 standard or EC-5623 slow hardener					
	Spray Gun Set Up	Gravity Feed: 1.2-1.4mm Suction Feed: 1.3-1.5mm Conventional: 3-4 bar RP: 2.0-2.5 bar HVLP: 2.0 bar				
	Coats & Thickness	2-3 coats, total 50-70um				
	Flash-Off Time	At 20°C, 5-10 minutes between coats				
	Air-Drying Time	Allow 15-20 minutes air drying time before force drying				
	Drying Time:					
	Temperature	Dust Free	Tack Free	Dry to Handle	Dry to Polish	
	20°C	45 minutes	2-3 hours	10 hours	16 hours	
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Note:

- At temperature lower than 15°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C.
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- The products mixed with hardener should be used up soon and can not restore for future use.
- Clean equipments immediately with solvent after application.
- If there are particles or runs after spray, sand the affected area with P1200-P2000 sand paper after thorough drying, then polish to solve the problem.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 1L or 4L

EC-3200 Premium Clear Coat



Characteristic: High solid clear coat, with properties of high build, excellent gloss, high hardness, excellent weathering and chemical resistance.

Substrates: 1K Basecoat

	Surface Cleaning: Remove wax, silicon or other contaminations with degreaser																														
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Note:

- At temperature lower than 15°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C.
- At ambient temperature higher than 30°C, add Retarder Solvent into thinner to avoid blushing. Details please refer to the technical data sheet of Retarder Solvent.
- In the event of fisheyes during application, add 0.5-1% Anti Silicon in the paint remained and re-spray the affected area.
- In the overspray area of new and existing finish, apply directly Thinner SRA to achieve an invisible transition. Details please refer to the technical data sheet of Thinner SRA.
- The products mixed with hardener should be used up soon and can not restore for future use.
- Clean equipments immediately with solvent after application.
- If there are particles or runs after spray, sand the affected area with P1200-P2000 sand paper after thorough drying, then polish to solve the problem.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 4L

EC-5200 Clear Coat Kit



Characteristics: Medium-high solid two-pack fast drying clear coat with mirror effect and deep rich gloss, suitable for overall refinish and spot repair while offering durability, yellowing resistance and excellent chemical resistance.

Substrates: 1K Basecoat

	Surface Cleaning: Remove wax, silicon or other contaminations with degreaser																														
	<table border="1"> <tr> <td>Mixing Ratio</td> <td>Clear Coat</td> <td>+</td> <td>Hardener</td> <td>+</td> <td>Thinner</td> </tr> <tr> <td></td> <td>2</td> <td></td> <td>1</td> <td></td> <td>0.2-0.4</td> </tr> <tr> <td>< 18°C</td> <td>EC-5200</td> <td></td> <td>EC-5671</td> <td></td> <td>E-1</td> </tr> <tr> <td>18-30°C</td> <td>EC-5200</td> <td></td> <td>EC-5672</td> <td></td> <td>E-2/E-3</td> </tr> <tr> <td>>30°C</td> <td>EC-5200</td> <td></td> <td>EC-5673</td> <td></td> <td>E-3</td> </tr> </table>	Mixing Ratio	Clear Coat	+	Hardener	+	Thinner		2		1		0.2-0.4	< 18°C	EC-5200		EC-5671		E-1	18-30°C	EC-5200		EC-5672		E-2/E-3	>30°C	EC-5200		EC-5673		E-3
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	<p>Pot-Life at 20°C: 2 hours with EC-5671 fast hardener 4 hours with EC-5672 standard or EC-5673 slow hardener</p>																														
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Note:

- At temperature lower than 15°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C.
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- The products mixed with hardener should be used up soon and can not restore for future use.
- Clean equipments immediately with solvent after application.
- If there are particles or runs after spray, sand the affected area with P1200-P2000 sand paper after thorough drying, then polish to solve the problem.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 5L+2.5L+1L

EC-7200 Extra Fast Clear Coat



Characteristic: Two-pack extra fast drying clear coat, high gloss and hardness, easy application, suitable for fast spots repairs, low consumption and high efficiency to ensure good profit.

Substrates: 1K Basecoat

	Surface Cleaning: Remove wax, silicon or other contaminations with degreaser																									
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(Volume)	2		1		0-0.1																					
< 25°C	EC-7200		EC-5600		E-1																					
≥ 30°C	EC-7200		EC-5601		E-2/E-3																					
	<p>Pot-Life at 20°C: 1 hour with EC-5600 extra fast hardener 1 hour with EC-5601 especially for summer</p>																									
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Drying Time:																										
Temperature	Tack Free		Dry to Handle	Dry to Polish																						
20°C	5600	10 minutes	1 hour	1.5 hours																						
30°C	5601	15 minutes	1 hour	1.5 hours																						
70°C			10 minutes	15 minutes																						

Note:

- After mixing clear coat with hardener, just add small quantity of E-1 thinner for spraying. The mixture should be used up within 1 hour.
- As this product dries very fast, the spray viscosity could not be too high, so that paint defects such as orange skin, could be avoided.
- EC-5600 Extra Fast Hardener is not used at conditions of high temperature and high humidity, otherwise there will be defects such as blistering or blushing. It is recommended to apply at conditions of temperature lower than 25°C and humidity lower than 80%. At temperature lower than 10°C, allow a forced dry by baking.
- EC-5601 is specially formulated for summer use. Its application and paint leveling is better. And it is suitable for larger area repair than EC-5600.
- The above drying time is tested by Yatu Technique Department and for reference only, the drying effect would be a little different when the application environment and conditions are different.
- Clean equipments immediately with solvent after application.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 1L or 4L

EC-2K Series Hardener



A series of yellow resistant hardener, specially designed for EC-2K solid colors and clear coats. To match different products, application area and conditions, it includes various versions as standard, fast, slow drying and high solid hardener and so on.

	Match with: EC-2K Solid Colors, EC-1200 Standard Clear Coat, EC-2200 High Solid Clear Coat and EC-3200 Premium Clear Coat
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Characteristic

EC-5611 Fast Hardener	Medium solid fast drying hardener for EC-2K solid colors and EC-1200 standard clear coat, suitable for spot repair and low temperature application below 18°C
EC-5612 standard Hardener	Medium solid standard drying hardener for EC-2K solid colors and EC-1200 standard clear coat, suitable for spot repair and overall refinish At 18-30°C.
EC-5613 Slow Hardener	Medium solid slow drying hardener for EC-2K solid colors and EC-1200 standard clear coat, suitable for spot repair and overall refinish above 30°C.
EC-5621 High Solid Fast Hardener	High solid fast drying hardener for EC-2200 high solid clear coat, suitable for spot repair and low temperature application below 18°C.
EC-5622 High Solid Standard Hardener	High solid standard hardener for EC-2200 high solid clear coat, suitable for spot repair and overall refinish at 18-30°C.
EC-5623 High Solid Slow Hardener	High solid slow drying hardener for EC-2200 high solid clear coat, suitable for spot repair and overall refinish above 30°C.
EC-5631 Premium Fast Hardener	High solid fast drying hardener for EC-3200 premium clear coat, suitable for spot repair and low temperature application below 18°C.
EC-5632 Premium Standard Hardener	High solid standard hardener for EC-3200 premium clear coat, suitable for spot repair and overall refinish at 18-30°C.
EC-5633 Premium Slow Hardener	High solid slow drying hardener for EC-3200 premium clear coat, suitable for spot repair and overall refinish above 30°C.

Note:

- Choose right hardener according to temperature, humidity and drying condition, generally, better to use fast drying hardener below 18°C, standard hardener at 18–30°C and slow drying hardener above 30°C.
- Please seal the can tightly after use as hardener is sensitive to moisture. Absorption of moisture can lead to chemical reaction and concreting. Please keep away from direct sunlight in storage.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 0.5L / 1L / 4L

EC-E Series Thinner

High quality thinner, specially developed for EC primer, basecoat and topcoat. Available with fast, standard, slow and extra slow drying speed to match different products and different application requirements.



Usage: To reduce the application viscosity, increase the smoothness of paint film. Good solubility.

Characteristic

E-5 Fast	1K basecoat only, with very fast evaporation speed, suitable for spot repair or application below 15°C.
E-1 Standard	Standard thinner For 1K basecoat and 2K products, with medium evaporation speed, suitable for spot repair or application at 15-25°C.
E-2 Slow	For 1K basecoat and 2K products, with slow evaporation speed, suitable for spot repair or overall refinishing or application at 25-30°C.
E-3 Extra Slow	2K products only, with very slow evaporation speed, suitable for overall refinishing, large area application or application over 30°C.

Note:

- If the temperature and humidity are too high, 10-30% EC-5960 Retarder Solvent can be added.
Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
Packaging: 4L

EC-5340 Plastic Primer

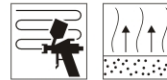
Characteristic: A single-component transparent fast drying primer, used to promote adhesion of paint system to plastic parts.
Substrates: Plastic parts such as PP、PA、PE



Surface Cleaning: Sanding with P400-P600. Remove wax, silicon or other contaminations with degreaser.



Spray Gun Set Up	Gravity Feed: 1.2-1.4mm Suction Feed: 1.3-1.5mm
	Conventional: 3-4 bar RP: 2.0-2.5 bar HVLP: 2.0 bar



Coats & Thickness	2-3 coats, total 1-2um
Flash-Off Time	At 20°C, 5-10 minutes between coats



Re-coat with primer after flash-off time of 10-15 minutes.

Note:

- The product is ready for use.
- It is recommended not to spray thickly to avoid peeling off.
- Test is recommended before application due to the variety of plastic parts.
Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
Packaging: 1L

EC-5351 Fast Epoxy Primer

Characteristic: Gives excellent rust proofing for bare metal, good adhesion power to steel, aluminium and galvanized steel.

Substrates: Dried and sanded existing finishes, steel, iron and glass fiber reinforced plastic



	Surface Cleaning: Remove wax, silicon and other contaminations with degreaser																								
	<table border="1"> <tr> <td>Mixing Ratio (Weight)</td> <td>Epoxy Primer</td> <td>+</td> <td>Hardener</td> <td>+</td> <td>Thinner</td> </tr> <tr> <td></td> <td>5</td> <td></td> <td>1</td> <td></td> <td>1-1.5</td> </tr> <tr> <td>(Volume)</td> <td>3.5</td> <td></td> <td>1</td> <td></td> <td>1</td> </tr> <tr> <td>≤ 30°C</td> <td>EC-5351</td> <td></td> <td>EC-5651</td> <td></td> <td>EC-5750</td> </tr> </table>	Mixing Ratio (Weight)	Epoxy Primer	+	Hardener	+	Thinner		5		1		1-1.5	(Volume)	3.5		1		1	≤ 30°C	EC-5351		EC-5651		EC-5750
Mixing Ratio (Weight)	Epoxy Primer	+	Hardener	+	Thinner																				
	5		1		1-1.5																				
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	Pot-Life at 20°C: 3-4 hours with hardener																								
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	Dry sanding: P240-P400 Wet sanding: P600-P800																								
	Re-coat: After drying and sanding, re-coat with putty, primer surfacer and all kinds of topcoat.																								

Note:

- For oxidated iron and cast iron, shot blasted sa2.5 class with roughness of 30-75 µm, or acid wash the oxidated parts to get rid of rust.
- It is recommended to bake at 60-70°C for 30 minutes when temperature is below 10°C for better curing of paint film.
- Choose right hardener and thinner to avoid poor curing of paint film.
- Clean equipments immediately after application.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 1kg

EC-5352 Epoxy Primer

Characteristic: Gives excellent rust proofing for bare metal, good adhesion power to steel, aluminium and galvanized steel.

Substrates: Dried and sanded existing finishes, steel, iron and glass fiber reinforced plastic



	Surface Cleaning: Remove wax, silicon and other contaminations with degreaser																								
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(Volume)	3.5		1		1																				
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	Pot-Life at 20°C: 4-6 hours with hardener																								
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	Dry sanding: P240-P400 Wet sanding: P600-P800																								
	Re-coat: After drying and sanding, re-coat with putty, primer surfacer and all kinds of topcoat.																								

Note:

- For oxidated iron and cast iron, shot blasted sa 2.5 class with roughness of 30–75 µm, or acid wash the oxidated parts to get rid of rust.
- It is recommended to bake at 60–70°C for 30 minutes when temperature is below 10°C for better curing of paint film.
- Choose right hardener and thinner to avoid poor curing of paint film.
- Clean equipments immediately after application.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 5kg

EC-5441 Fast 2K Primer Surfacer



Characteristic: Multi-purpose double pack fast drying primer surfacer, with strong filling power, fine adhesion between coats and good sanding properties, can increase gloss and build of topcoat. The recommended application temperature is below 25°C.

Substrates: Dried and sanded existing finishes, all kinds of primer and putty.

	Surface Cleaning: Remove wax, silicon and other contaminations with degreaser																								
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	Pot-Life at 20°C: 30 minutes with hardener																								
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	Dry sanding: P400–P600 Wet sanding: P800–P1000																								
	Re-coat: After drying and sanding, re-coat with all kinds of topcoat.																								

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
Packaging: 4kg

EC-5442 2K Primer Surfacer



Characteristic: Multi-purpose double pack primer surfacer, with strong filling power and fine adhesion between coats, has excellent flexibility and impact resistance which can increase gloss and build of topcoat.

Substrates: Dried and sanded existing finishes, all kinds of primer and putty.

	Surface Cleaning: Remove wax, silicon and other contaminations with degreaser																														
	<table border="1"> <tr> <td>Mixing Ratio (Weight)</td> <td>2K Primer Surfacer</td> <td>+</td> <td>Hardener</td> <td>+</td> <td>Thinner</td> </tr> <tr> <td></td> <td>4</td> <td></td> <td>1</td> <td></td> <td>1-1.5</td> </tr> <tr> <td>Mixing Ratio (Volume)</td> <td>3</td> <td></td> <td>1</td> <td></td> <td>1-1.5</td> </tr> <tr> <td>< 25°C</td> <td>EC-5442</td> <td></td> <td>EC-5641</td> <td></td> <td>E-1</td> </tr> <tr> <td>≥ 25°C</td> <td>EC-5442</td> <td></td> <td>EC-5642</td> <td></td> <td>E-2 / E-3</td> </tr> </table>	Mixing Ratio (Weight)	2K Primer Surfacer	+	Hardener	+	Thinner		4		1		1-1.5	Mixing Ratio (Volume)	3		1		1-1.5	< 25°C	EC-5442		EC-5641		E-1	≥ 25°C	EC-5442		EC-5642		E-2 / E-3
Mixing Ratio (Weight)	2K Primer Surfacer	+	Hardener	+	Thinner																										
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Air-Drying Time	Allow 15–20 minutes air drying time before force drying																														
	Drying Time: 20°C: 2-3 hours 60°C: 45 minutes																														
	Dry sanding: P400-P600 Wet sanding: P800-P1000																														
	Re-coat: After drying and sanding, re-coat with all kinds of topcoat.																														

Note:

1. Clean equipments immediately after application.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
Packaging: 4kg

EC-5470 1K Primer Surfacer



Characteristic: Fast drying one pack primer surfacer, suitable to cover minor defects in surface of putty or existing finish. It is easy to apply with good filling power and ease of sanding for economical refinishing.

Substrates: Dried and sanded existing finishes and putty

	Surface Cleaning: Remove wax, grease or other contaminations with degreaser				
	<table border="1"> <tr> <td>Mixing Ratio (Weight) (Volume)</td> <td>Primer Surfacer 1 EC-5470</td> <td>+</td> <td>Thinner 0.8-1 E-1</td> </tr> </table>	Mixing Ratio (Weight) (Volume)	Primer Surfacer 1 EC-5470	+	Thinner 0.8-1 E-1
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Flash-Off Time	At 20°C, 5-10 minutes between coats				
	Drying Time: 30 minutes at 20°C				
	Dry sanding: P400-P600 Wet sanding: P600-P800				
	Re-coat: After drying and sanding, re-coat with all kinds of topcoat.				

Note:

- Not recommended for direct application over substrate of bare metal and wood.
- Recommended to use 2K Primer to achieve good adhesion to substrate and excellent gloss and film build of the topcoat.
- Not recommended to use thinner of fast drying type.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 4kg

EC-5480 Filler



Characteristic: Single-component putty with good filling power, fast drying, easy to apply and sand, suitable to cover small scratches, sand holes and pinholes.

Substrates: Dried and sanded existing finishes, putty, 1K & 2K primer.

	Surface Cleaning: Remove wax, silicon, or other contaminations with degreaser	
	<table border="1"> <tr> <td>Mixing Ratio: Ready for use, apply with spreader. Apply a thin coat at a time. Flash-off time between coats: 10-15 minutes Application Tool: Putty knife, soft rubber or plastic spreader.</td> </tr> </table>	Mixing Ratio: Ready for use, apply with spreader. Apply a thin coat at a time. Flash-off time between coats: 10-15 minutes Application Tool: Putty knife, soft rubber or plastic spreader.
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	Drying time: 30 minutes at 20°C. Allow longer drying time for thick coating.	
	Dry sanding: P400-P600 Wet sanding: P600-P800	

Note:

- Not recommended to apply over large area.
- Not suitable for direct application over bare metals.
- Spray topcoat directly after sanding if the application area is small. It is recommended to use 2K primer surfacer prior to topcoat if the application area is large.
- Seal the can tightly after use to avoid skinning.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 1kg

EC-5510 2K Binder



Characteristic: Resin solution used as an additive for spraying EC-2K solid colors. It improves the gloss of the paint film.

	Match with : EC-2K Solid Colors
	Mixing Ratio: EC-2K Solid Colors: EC-3510 2K Binder= 100:0-20 EC-2K Solid Colors+EC-5510 2K Binder : EC-2K series Hardener= 2:1

Note:

- Do not add EC-5510 2K Binder if the coverage of the paint is poor.
- Do not use in 1K basecoat or clear coat.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 3.75L

EC-5520 1K Binder EC-5530 Flip Controller

For EC-1K metallic basecoat, able to speed up air drying time, enhance the orientation of silver & pearl particles, and improve the application property.



	Match with: EC-1K basecoat	
Characteristic	EC-5520 1K Binder	Used in 3-stage or 2-stage colors to speed up air drying time, enhance the orientation of silver & pearl particles, and improve the application property.
	EC-5530 Flip Controller	Used to lighten the side tone of the metallic basecoat color and create a darker face with appearance of larger metallic sparkle.
 	<p>Mixing Ratio:</p> <ol style="list-style-type: none"> 1. Addition of EC-5520 to EC-1K metallic basecoat is 15-40% of total volume. 2. For EC-1K silver white or other light color metallic basecoat, it is recommended to use no less than 25% EC-5520. When silver basecoat is used individually, add 40% EC-5520. 3. In 3-stage pearl colors, add 50-70% EC-5520 into the pearl colors accordingly. 4. For basecoat colors with low opacity, such as red pearl colors, addition of EC-5520 should be less than 15% so as not to affect the hiding power of the paint. 5. 20% or less of EC-5530 can be used to lighten the side tone of the metallic color and create a darker face with appearance of larger metallic sparkle. Excess addition would affect the adhesion between basecoat and clear coat. 	

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
 Packaging: EC-5520: 3.75L EC-5530: 1L

EC-5910 Degreaser

Characteristic: Able to remove grease, oil and other surface contaminants to avoid paint film defects.
Substrates: Existing finishes, primer, putty and metal.



	Mixing Ratio: Ready for use.
	<p>Usage:</p> <ol style="list-style-type: none"> 1. Clean the substrate with water to remove water-soluble contaminants and then dry it off. 2. Degrease the substrate with tack rag wetted with degreaser. 3. Wipe and dry the surface with another clean tack rag.

Note:

1. Use Degreaser before sanding to avoid oil contamination going into the sanding mark.
2. Degrease and clean the surface again with Degreaser after sanding.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
 Packaging: 1L

EC-5920 Thinner SRA

Characteristic: To dissolve the rough overspray area of new and existing finishes and achieve an invisible transition for panel repair.
Field of Application: Overspray area of 2K solid colors, clear coat in panel repairs.



	Mixing Ratio: The product is ready for use. Can mix with the paint remained in the spray gun in the ratio of 1:1
	Application Method: Spray lightly one coat over the overspray area with Thinner SRA right after the finish. Second coat in 20 seconds.

Note:

1. Not Suitable with 1K basecoat and primer.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
 Packaging: 1L

EC-5930 Anti-Silicon



Characteristic: Additive for 2K solid colors or clear coats, able to remove fisheyes or craterings on the paint film.

	Match with: 2K solid colors or clear coat.
	Mixing Ratio: Paint ready for use: anti silicon = 1L: 0.5-2 tin cap (about 4-15g)
	Application Method: Spray one or two coats over the paint film with fisheyes or craterings by paint mixed with Anti Silicon.

Note:
 1. Mix with right ratio of Anti Silicon. Excess addition may cause defect of small bubbles or pinholes.
 2. In serious problems, fisheyes affected paint film must be sanded out and filled when it is hard dry. Refinish with paint mixed with Anti Silicon.
 Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
 Packaging: 1L

EC-5940 Matting Agent



Characteristic: Used to reduce the brightness of the paint film. Good matting ability with smooth paint film. Suitable for 1K and 2K system.
Match with: EC-2K solid colors, clear coats and 1K basecoat

	Mixing Ratio: 1K Basecoat : EC-5940 = (85-70) : (15-30)			
	2K topcoat:			
	Effect	EC-2K topcoat	EC-5940	Hardener
	All matte	30 parts	70 parts	15 parts
	Half matte(egg shell)	50 parts	50 parts	25 parts
	Half bright	70 parts	30 parts	35 parts
	Application Method: Refer to the technical data sheet of the matching products for proper application.			

Note:
 1. The matting agent is easy to crystallize when exposed to air too long. To avoid particles in the paint film, especially when applied in combination with clear coat, remove crystallized particles and other contaminations around the can rim before use and pour out with filter.
 Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
 Packaging: 1L

EC-5941 Transparent Matting Agent



Characteristic: A transparent additive for a smooth matte affect while maintaining the good transparency of the clear coat. It can also be used in 2K solid colors and 1K basecoat.
Suitable for: clear coat, 2K solid colors, 1K basecoat

	Mixing Ratio:			
	1K basecoat : EC-5941 Transparent Matting Agent = (85-70) : (15-30)			
	Clear coat or 2K solid colors:			
	Effect	Clear coat or 2K solid colors	EC-5941	Hardener
	All matte	40 parts	60 parts	20 parts
	Half matte	50 parts	50 parts	25 parts
	Satin glossy	60 parts	40 parts	30 parts
	Application Method: Refer to the technical data sheet of the matching products for proper application.			

Note:
 1. The matting agent is easy to crystallize when exposed to air too long. To avoid particles in the paint film, especially when applied in combination with clear coat, remove crystallized particles and other contaminations around the can rim before use and pour out with filter.
 Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
 Packaging: 1L

EC-5960 Retarder Solvent



Characteristic: Additive to prolong volatilization of solvent. Helps to produce a quality refinishing job of good leveling and blushing-free at circumstances of high temperature, humidity or large area repair.

Match With: 1K basecoat, 2K solid colors & clear coat

	Mixing Ratio: Add 10-30% retarder solvent into E-2 or E-3 thinner when the ambient temperature is over 30°C
	Application Method: Refer to the technical data sheet of the matching products for proper application.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
Packaging: 1L

EC-5980 Quick Drier



Characteristic: Specially designed for EC-2K solid colors and clear coat, can speed up the dust free time and air drying time of paint film, suitable for spot repair or application at low temperature.

	Mixing Ratio: 1. 10-15°C: 5-6g EC-5980 Quick Drier into 1L ready-to-spray paint; 2. 0-10°C: 6-10g EC-5980 Quick Drier into 1L ready-to-spray paint; 3. Below 0°C: 10-15g EC-5980 Quick Drier into 1L ready-to-spray paint.
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Note:

- Pot life of paint mixed with EC-5980 Quick Drier would be shortened considerably, use up as soon as possible.
- Recommended addition of EC-5980 Quick Drier is not over than 15g for 1L ready-to-spray paint, otherwise it would cause paint film embrittlement and loss of gloss.
- EC-5980 Quick Drier can not be used as hardener.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
Packaging: 1L

E3-2K Solid Colors



Characteristic: Fast drying 2K topcoat for general passenger and business cars, features good leveling, hard paint film, good gloss, bright and durable color.

Substrates: Dried and sanded existing finishes, 1K or 2K Primers

	Surface Cleaning: Remove wax, silicon and other contaminations with degreaser																														
	Mixing Ratio <table border="1"> <tr> <td></td> <td>Solid Colors</td> <td>+</td> <td>Hardener</td> <td>+</td> <td>Thinner</td> </tr> <tr> <td></td> <td>2</td> <td></td> <td>1</td> <td></td> <td>0.1-0.4</td> </tr> <tr> <td>< 18°C</td> <td>E3-2K Solid Colors</td> <td></td> <td>E3-801</td> <td></td> <td>E-1</td> </tr> <tr> <td>18-30°C</td> <td>E3-2K Solid Colors</td> <td></td> <td>E3-802</td> <td></td> <td>E-2/E-3</td> </tr> <tr> <td>>30°C</td> <td>E3-2K Solid Colors</td> <td></td> <td>E3-803</td> <td></td> <td>E-3</td> </tr> </table>		Solid Colors	+	Hardener	+	Thinner		2		1		0.1-0.4	< 18°C	E3-2K Solid Colors		E3-801		E-1	18-30°C	E3-2K Solid Colors		E3-802		E-2/E-3	>30°C	E3-2K Solid Colors		E3-803		E-3
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Note:

- The substrate must be sanded and cleaned before spray. (Wet sanding: P600-P800, drying sanding: P400- P600)
- At temperature lower than 15°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C.
- At ambient temperature higher than 30°C, add Retarder Solvent into thinner to avoid blushing. For details please refer to the technical data sheet of Retarder Solvent.
- In the event of fisheyes during application, add 0.5-1% Anti Silicon in the paint remained and re-spray the affected area.
- In the overspray area of new and existing finish, apply directly Thinner SRA to achieve an invisible transition. For details please refer to the technical data sheet of Thinner SRA.
- The products mixed with hardener should be used up soon and can not restore for future use.
- Clean equipments immediately with solvent after application.
- If there are particles or runs after spray, sand the affected area with P1200-P2000 sand paper after thorough drying, then polish to solve the problem.


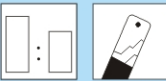

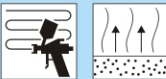
Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
Packaging: 1L or 3.75L

E3-1K Basecoat Colors

Characteristic: Single component basecoat with solid colors, metallic and pearl effect, made from weathering resistant resins, high quality, strong covering power, and excellent adhesion power.

Substrates: Sanded and dried existing finishes, 1K or 2K primer.



	Surface Cleaning: Remove wax, silicon and other contaminations with degreaser																
	Mixing Ratio	<table border="1"> <tr> <td>Basecoat Colors</td> <td>+</td> <td>Thinner</td> </tr> <tr> <td>1</td> <td></td> <td>0.6-0.8</td> </tr> <tr> <td>< 15°C</td> <td></td> <td>E3-1K Basecoat Colors</td> </tr> <tr> <td>15-30°C</td> <td></td> <td>E3-1K Basecoat Colors</td> </tr> <tr> <td>>30°C</td> <td></td> <td>E3-1K Basecoat Colors</td> </tr> </table>	Basecoat Colors	+	Thinner	1		0.6-0.8	< 15°C		E3-1K Basecoat Colors	15-30°C		E3-1K Basecoat Colors	>30°C		E3-1K Basecoat Colors
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	Coats & Thickness	2-3 coats, total 15-25um															
	Flash-Off Time	At 20°C, 5-10 minutes between coats															
	Air-Drying Time	Allow 10-15 minutes air drying time before force drying															

Note:

- The substrate must be sanded and cleaned before spray. (Wet sanding: P600-P800, drying sanding: P400- P600)
- At temperature over 30°C or in high humidity, it is recommended to use Retarder Solvent to avoid mottling.
- Because of the high transparency of metallic basecoat, good quality spray gun and professional spray techniques are required in order to prevent defects of mottling or poor metallic effects.
- To avoid problems of mottling or poor adhesion, the metallic paint film should not be thicker than 25um
- Better effect could be achieved if the extra silver powder could be removed with tack rag after the flash-off of each coat.
- After spray, allow 10-15 minutes air-drying time, then spray clear coat at once. Over long air drying time would affect the adhesion power.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C


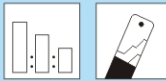




Packaging: 1L or 3.75L

E3-800 Clear Coat Kit

Characteristic: Double pack, Mirror-effect clear coat. It features smooth paint film and good gloss with durable resistance to weather and pollution.

Substrates: 1K basecoat



	Surface Cleaning: Remove wax, silicon and other contaminations with degreaser																										
	Mixing Ratio	<table border="1"> <tr> <td>Clear Coat</td> <td>+</td> <td>Hardener</td> <td>+</td> <td>Thinner</td> </tr> <tr> <td>2</td> <td></td> <td>1</td> <td></td> <td>0-0.1</td> </tr> <tr> <td>< 18°C</td> <td></td> <td>E3-800</td> <td></td> <td>E3-801</td> </tr> <tr> <td>18-30°C</td> <td></td> <td>E3-800</td> <td></td> <td>E3-802</td> </tr> <tr> <td>>30°C</td> <td></td> <td>E3-800</td> <td></td> <td>E3-803</td> </tr> </table>	Clear Coat	+	Hardener	+	Thinner	2		1		0-0.1	< 18°C		E3-800		E3-801	18-30°C		E3-800		E3-802	>30°C		E3-800		E3-803
Clear Coat	+	Hardener	+	Thinner																							
2		1		0-0.1																							
< 18°C		E3-800		E3-801																							
18-30°C		E3-800		E3-802																							
>30°C		E3-800		E3-803																							
	Pot-Life at 20°C: 2 hours with E3-801 fast hardener 3 hours with E3-802 standard or E3-803 slow hardener																										
	Spray Gun Set Up	<table border="1"> <tr> <td>Gravity Feed: 1.2-1.4mm</td> <td>Siphon Feed: 1.3-1.5mm</td> </tr> <tr> <td>Conventional: 3-4 bar</td> <td>RP: 2.0-2.5 bar</td> </tr> <tr> <td colspan="2">HVLP: 2.0 bar</td> </tr> </table>	Gravity Feed: 1.2-1.4mm	Siphon Feed: 1.3-1.5mm	Conventional: 3-4 bar	RP: 2.0-2.5 bar	HVLP: 2.0 bar																				
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Conventional: 3-4 bar	RP: 2.0-2.5 bar																										
HVLP: 2.0 bar																											
	Coats & Thickness	2-3 coats, total 40-60um																									
	Flash-Off Time	At 20 °C, 5-10 minutes between coats																									
	Air-Drying Time	Allow 15-20 minutes air drying time before force drying																									
	Drying Time:																										
	Temperature	Dust Free	Tack Free	Dry to Handle	Dry to Polish																						
	20°C	45 minutes	2-3 hours	10 hours	16 hours																						
	60°C	5 minutes	15 minutes	30 minutes	60 minutes																						

Note:

- At temperature lower than 15°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C.
- At ambient temperature higher than 30°C, add Retarder Solvent into thinner to avoid blushing. Details please refer to the technical data sheet of Retarder Solvent.
- In the event of fisheyes during application, add 0.5-1% Anti Silicon in the paint remained and re-spray the affected area.
- In the overspray area of new and existing finish, apply directly Thinner SRA to achieve an invisible transition. Details please refer to the technical data sheet of Thinner SRA.
- The products mixed with hardener should be used up soon and can not restore for future use.
- Clean equipments immediately with solvent after application.
- If there are particles or runs after spray, sand the affected area with P1200-P2000 sand paper after thorough drying, then polish to solve the problem.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C


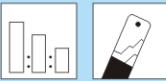


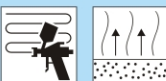

Packaging: 5L+2.5L+1L

E3-800W Extra Fast Clear Coat

Characteristic: Double pack, mirror-effect, medium solid, extra fast clear coat with easy application and higher mixing ratio with thinner, suitable for spot repair and overall refinishing especially good for winter use. It features smooth paint film and good gloss with durable resistance to weather and pollution.

Substrates: 1K basecoat



	Surface Cleaning: Remove wax, silicon or other contaminations with degreaser					
	Mixing Ratio	Clear Coat	+	Hardener	+	Thinner
	< 25°C	2		1		0.1-0.2
		E3-800W		E3-801		E-1
	Pot-Life at 20°C: 4 hours with E3-801 fast hardener					
	Spray Gun	Gravity Feed: 1.2–1.5mm Siphon Feed: 1.4–1.7mm				
	Spray Up	Conventional: 3–4 bar RP: 2.0–2.5 bar HVLP: 2.0 bar				
	Coats & Thickness	2–3 coats, total 40–60um				
	Flash-Off Time	At 20 °C, 5–10 minutes between coats				
	Air-Drying Time	Allow 10–20 minutes air drying time before force drying				
	Drying Time:					
	Temperature	Dust Free	Tack Free	Dry to Handle	Dry to Polish	
	20°C	15 minutes	30 minutes	2 hours	16 hours	
	60°C	————	10 minutes	20 minutes	30 minutes	

Note:

- At temperature lower than 15°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C.
- In the event of fisheyes during application, add 0.5–1% Anti Silicon in the paint remained and re-spray the affected area.
- In the overspray area of new and existing finish, apply directly Thinner SRA to achieve an invisible transition. Details please refer to the technical data sheet of Thinner SRA.
- The products mixed with hardener should be used up soon and can not restore for future use.
- Clean equipments immediately with solvent after application.
- If there are particles or runs after spray, sand the affected area with P1200–P2000 sand paper after thorough drying, then polish to solve the problem.


Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 5L+2.5L+1L

E3-2K Series Hardener

A series of yellow resistant hardener, specially designed for E3-2K solid colors and clear coats. To match different products, application area and conditions, it includes various versions as standard, fast, slow drying and high solid hardener and so on.



	Match with: E3-2K solid colors, E3-800 clear coat	
Characteristic		
E3-801 Fast Hardener	Medium solid fast drying hardener for topcoat, suitable for spot repair and low temperature application below 18°C.	
E3-802 standard Hardener	Medium solid standard drying hardener for topcoat, suitable for spot repair and overall refinish at 18–30°C.	
E3-803 Slow Hardener	Medium solid slow drying hardener for topcoat, suitable for spot repair and overall refinish above 30°C.	

Note:

- Choose right hardener according to temperature, humidity and drying condition, generally, better to use fast drying hardener below 18°C, standard hardener at 18–30°C and slow drying hardener above 30°C.
- Please seal the can tightly after use as hardener is sensitive to moisture. Absorption of moisture can lead to chemical reaction and concreting. Please keep away from direct sunlight in storage.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C




Packaging: 0.5L /1L / 4L

E3-10 Plastic Primer

Characteristic: A single-component transparent fast drying primer, used to promote adhesion of paint system to plastic parts

Substrates: Plastic parts such as PP、PA、PE



	Surface cleaning: sanding with P400-P600, remove wax, silicon or other Contaminations with degreaser.			
	Spray Gun	Gravity Feed: 1.2–1.4mm Siphon Feed: 1.3–1.5mm		
	Spray Up	Conventional: 3–4 bar RP: 2.0–2.5 bar HVLP: 2.0 bar		
	Coats & Thickness	2–3 coats, total 1–2um		
	Flash-Off Time	At 20°C, 5–10 minutes between coats		
	Re-coat:	With primer right after flash-off time of 10–15 minutes.		

Note:

- The product is ready for use.
- It is recommended not to spray thickly to avoid peeling off.
- Test is recommended before application due to the variety of plastic parts.
- Spray primer over the plastic primer after flash off in 10–15 minutes

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 1L

E3-20 Epoxy Primer



Characteristic: Gives excellent rust proofing for bare metal, good adhesion power to steel, aluminium and galvanized steel.
Substrates: Dried and sanded existing finishes, steel, iron and glass fiber reinforced plastic

	Surface Cleaning: Remove wax, silicon and other contaminations with degreaser																								
	<table border="1"> <tr> <td>Mixing Ratio (Weight)</td> <td>Epoxy Primer</td> <td>+</td> <td>Hardener</td> <td>+</td> <td>Thinner</td> </tr> <tr> <td></td> <td>5</td> <td></td> <td>1</td> <td></td> <td>1-1.5</td> </tr> <tr> <td>(Volume)</td> <td>3.5</td> <td></td> <td>1</td> <td></td> <td>1</td> </tr> <tr> <td>≥ 30°C</td> <td>E3-20</td> <td></td> <td>E3-21</td> <td></td> <td>E3-22</td> </tr> </table>	Mixing Ratio (Weight)	Epoxy Primer	+	Hardener	+	Thinner		5		1		1-1.5	(Volume)	3.5		1		1	≥ 30°C	E3-20		E3-21		E3-22
Mixing Ratio (Weight)	Epoxy Primer	+	Hardener	+	Thinner																				
	5		1		1-1.5																				
(Volume)	3.5		1		1																				
≥ 30°C	E3-20		E3-21		E3-22																				
	Pot-Life at 20°C: 4-6 hours with hardener																								
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Temperature	Dust Free	Tack Free	Dry to Handle	Dry to Polish																					
20°C	45 minutes	2-3 hours	10 hours	16 hours																					
60°C	5 minutes	15 minutes	30 minutes	60 minutes																					
	Dry sanding: P240-P400 Wet sanding: P600-P800																								
	Re-coat: After drying and sanding, re-coat with all kinds of topcoat.																								

Note:
 1. For oxidated iron and cast iron, shot blasted sa2.5 class with roughness of 30-75 um, or acid wash the oxidated parts to get rid of rust.
 2. It is recommended to bake at 60-70°C for 30 minutes when temperature is below 10°C for better curing of paint film.
 3. Choose right hardener and thinner to avoid poor curing of paint film.
 Shelf Life : 2 years in original sealed can at cool and dry place at 20°C
 Packaging: 5kg

E3-30 Primer Surfacer



Characteristic: Multi-purpose double pack primer surfacer, with strong filling power and fine adhesion between coats, has excellent flexibility and impact resistance which can increase gloss and build of topcoat.
Substrates: Dried and sanded existing finishes, all kinds of primer and putty.

	Surface Cleaning: Remove wax, silicon and other contaminations with degreaser																														
	<table border="1"> <tr> <td>Mixing Ratio (Weight)</td> <td>2K Primer Surfacer</td> <td>+</td> <td>Hardener</td> <td>+</td> <td>Thinner</td> </tr> <tr> <td></td> <td>4</td> <td></td> <td>1</td> <td></td> <td>1-1.5</td> </tr> <tr> <td>(Volume)</td> <td>3</td> <td></td> <td>1</td> <td></td> <td>1-1.5</td> </tr> <tr> <td>< 25°C</td> <td>E3-30</td> <td></td> <td>E3-31</td> <td></td> <td>E-1</td> </tr> <tr> <td>≥ 25°C</td> <td>E3-30</td> <td></td> <td>E3-31</td> <td></td> <td>E-2 / E-3</td> </tr> </table>	Mixing Ratio (Weight)	2K Primer Surfacer	+	Hardener	+	Thinner		4		1		1-1.5	(Volume)	3		1		1-1.5	< 25°C	E3-30		E3-31		E-1	≥ 25°C	E3-30		E3-31		E-2 / E-3
Mixing Ratio (Weight)	2K Primer Surfacer	+	Hardener	+	Thinner																										
	4		1		1-1.5																										
(Volume)	3		1		1-1.5																										
< 25°C	E3-30		E3-31		E-1																										
≥ 25°C	E3-30		E3-31		E-2 / E-3																										
	Pot-Life at 20°C: 1.5 hours with E3-31 Hardener																														
	<table border="1"> <tr> <td>Spray Gun</td> <td>Gravity Feed: 1.4-1.8mm</td> <td>Siphon Feed: 1.7-2.0mm</td> </tr> <tr> <td>Spray Up</td> <td>Conventional: 1.5-2.5 bar</td> <td>RP: 0.5-2.0 bar HVLP: 0.7-2.0 bar</td> </tr> </table>	Spray Gun	Gravity Feed: 1.4-1.8mm	Siphon Feed: 1.7-2.0mm	Spray Up	Conventional: 1.5-2.5 bar	RP: 0.5-2.0 bar HVLP: 0.7-2.0 bar																								
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Flash-Off Time	At 20°C, 5-10 minutes between coats																														
Air-Drying Time	Allow 15-20 minutes air drying time before force drying																														
	Drying Time: 2-3 hours & 20°C or 45 minutes & 60°C																														
	Dry sanding: P240-P400 Wet sanding: P600-P800																														
	Re-coat: After drying and sanding, re-coat with all kinds of topcoat.																														

Note:
 1. Clean equipments immediately after application
 Shelf Life: 2 years in original sealed can at cool and dry place at 20°C
 Packaging: 4kg

E3-40 1K Primer Surfacer

Characteristic: Fast drying one pack primer surfacer, suitable to cover minor defects in surface of putty or existing finish. It is easy to apply with good filling power and ease of sanding for economical refinishing.

Substrates: Dried and sanded existing finishes and putty



	Surface Cleaning: Remove wax, grease or other contaminations with degreaser										
	<table border="1"> <tr> <td rowspan="3">Mixing Ratio (Weight) (Volume)</td> <td>Primer Surfacer</td> <td>+</td> <td>Thinner</td> </tr> <tr> <td>1</td> <td></td> <td>0.8-1</td> </tr> <tr> <td>E3-40</td> <td></td> <td>E-1</td> </tr> </table>	Mixing Ratio (Weight) (Volume)	Primer Surfacer	+	Thinner	1		0.8-1	E3-40		E-1
Mixing Ratio (Weight) (Volume)	Primer Surfacer		+	Thinner							
	1			0.8-1							
	E3-40		E-1								
	<table border="1"> <tr> <td>Spray Gun</td> <td>Gravity Feed: 1.4-1.8mm</td> <td>Siphon Feed: 1.7-2.0mm</td> </tr> <tr> <td>Spray Up</td> <td>Conventional: 1.5-2.5 bar</td> <td>RP: 0.5-2.0 bar HVLP: 0.7-2.0 bar</td> </tr> </table>	Spray Gun	Gravity Feed: 1.4-1.8mm	Siphon Feed: 1.7-2.0mm	Spray Up	Conventional: 1.5-2.5 bar	RP: 0.5-2.0 bar HVLP: 0.7-2.0 bar				
Spray Gun	Gravity Feed: 1.4-1.8mm	Siphon Feed: 1.7-2.0mm									
Spray Up	Conventional: 1.5-2.5 bar	RP: 0.5-2.0 bar HVLP: 0.7-2.0 bar									
	<table border="1"> <tr> <td>Coats & Thickness</td> <td>2-3 coats, total 25-30um</td> </tr> <tr> <td>Flash-Off Time</td> <td>At 20°C, 5-10 minutes between coats</td> </tr> </table>	Coats & Thickness	2-3 coats, total 25-30um	Flash-Off Time	At 20°C, 5-10 minutes between coats						
Coats & Thickness	2-3 coats, total 25-30um										
Flash-Off Time	At 20°C, 5-10 minutes between coats										
	Drying Time: 20°C, 30 minutes										
	Dry sanding: P600-P800 Wet sanding: P400-P600										
	Re-coat: After drying and sanding, re-coat with all kinds of topcoat.										

Note:

- Not recommended for direct application over substrate of bare metal and wood.
- Recommended to use 2K Primer to achieve good adhesion to substrate and excellent gloss and film build of the topcoat.
- Not recommended to use thinner of fast drying type.

Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 4kg

E3-50 Filler

Characteristic: Single-component putty with good filling power, fast drying, easy to apply and sand, suitable to cover small scratches, sand holes and pinholes.

Substrates: Dried and sanded existing finishes, putty, 1K & 2K primer.



	Surface Cleaning: Remove wax, silicon, or other contaminations with degreaser
	Application Method: Directly spread thin coat by coat. Flash-off time of every coat is 10-15 minutes. Application Tool: Putty knife, soft rubber or plastic spreader.
	Drying time: 30 minutes at 20°C. Allow longer drying time for thick coating.
	Dry sanding: P400-P600 Wet sanding: P600-P800

Note:

- Not recommended to apply over large area.
- Not suitable for direct application over bare metals.
- Spray topcoat directly after sanding if the application area is small. Large. It is recommended to use 2K primer surfacer prior to topcoat if the application area is large.
- Seal the can tightly after use to avoid skinning.

Shelf life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 1kg

E3-60 1K Flip Controller

Characteristic: Effect additive for metallic colors.



 Mixing Ratio (Volume)	E3-60 1K Flip Controller 20% or less of EC-5530 can be used to lighten the side tone of the metallic color and create a darker face with appearance of larger metallic sparkle. Excess addition would affect the adhesion between basecoat and clear coat.
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Shelf Life: 2 years in original sealed can at cool and dry place at 20°C

Packaging: 1L

EasiCoat

CAR PAINT
Refinishing Procedure



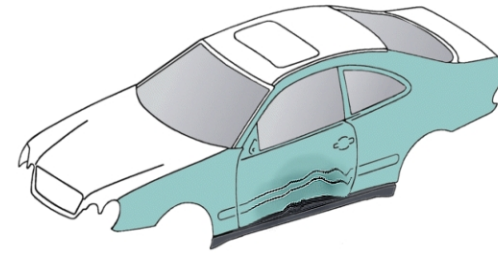
E5 Comprehensive And Full Capability

E3 Simple Compact System

Sand Old Paint Film

1. Degrease, clean

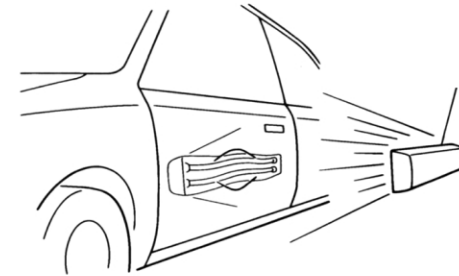
After proper repair of the damaged metal parts, rinse, degrease and blow off the repair area.



2. Estimate the extent of damage

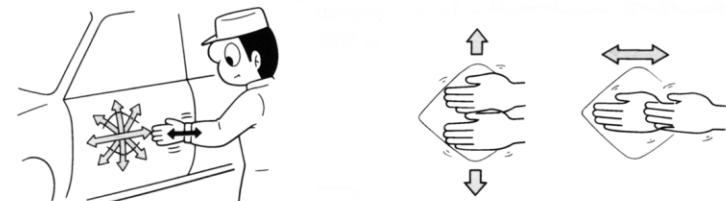
(1) Visual Assessment

Check fluorescent reflection on the panel to estimate the extent of damage and the size of the affected area.



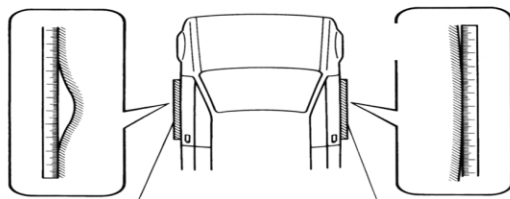
(2) Touch Assessment

Put on gloves (cotton), touch the damaged area, but do not push, and feel with the palms of your hands.



(3) Ruler assessment

Put the ruler on the damaged area and estimate the crack.



3. Sand the old paint film

Before applying body filler (polyester putty) sand the surface with P80-180 grip sandpaper to bare metal, make sure all corrosion, imperfect existing paints, etc, are removed.

After sanding, the area should be:

- (1) Smooth
- (2) Even
- (3) All surface imperfections are removed
- (4) Round or oval



Single action-sander



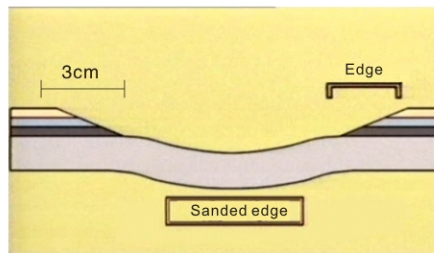
4. Sand for a feather edge

Featheredge the sanded area.

Caution:

Hold the sander flat on the surface before turning on the sander so that the sandpaper does not dig into surface. Don't put the sander on one place too long, or the plate will be distorted because of overheating.

Double action-sander



5. Clean and degrease

(1) Clean (blow off the area with a high-pressure air gun).

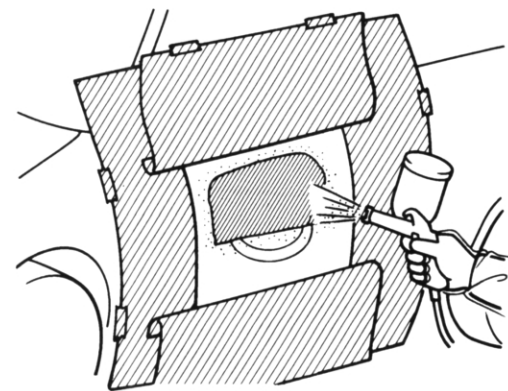
(2) Degrease (wipe over the area with a piece of cloth soaked with degreaser and wipe off while wet with another clean cloth).



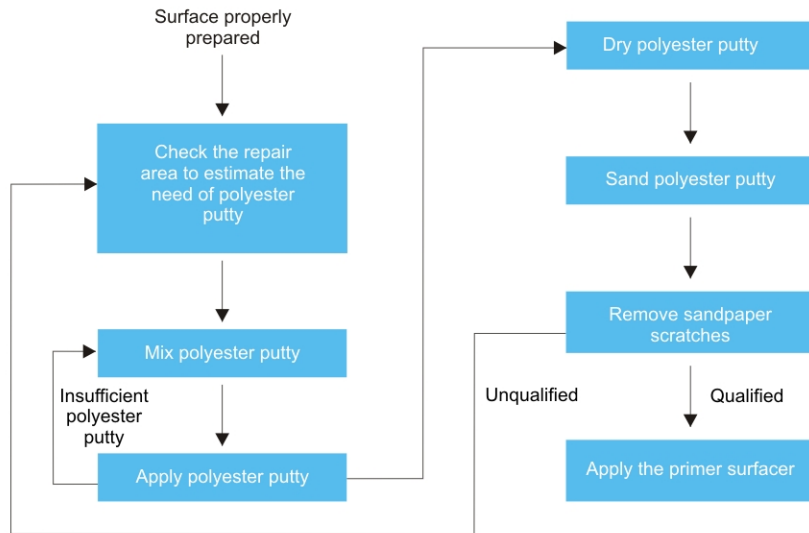
6. Apply Primer (YATU Epoxy primer)

Apply primer in over bare metal to provide rust resistance and promote adhesion of paint system to the substrate.

- (1) Properly mask.
- (2) Mix the epoxy primer with hardener and thinner according to the manufacturer's instruction.
- (3) Apply the primer in accordance with the manufacturer's instructions.
- (4) Allow the coating to dry.
- (5) Remove the mask.

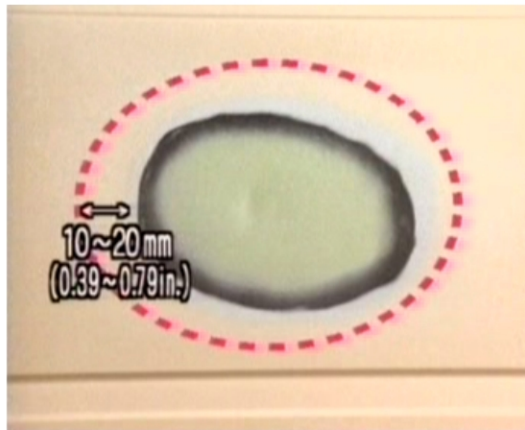


Polyester Putty Application



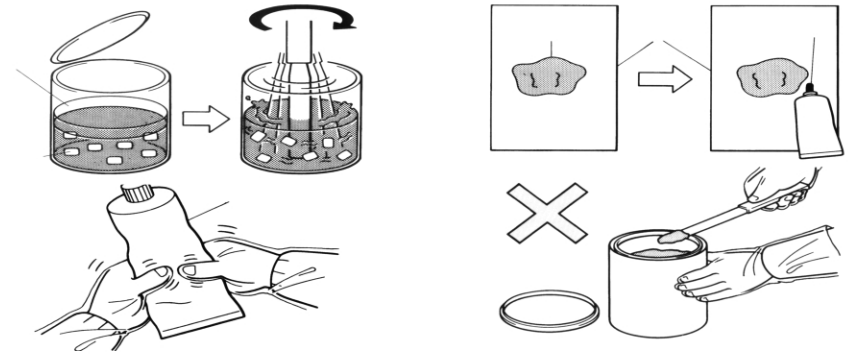
1. Evaluate the repair area

Check the repair area and estimate how much polyester putty is needed to fill the area.



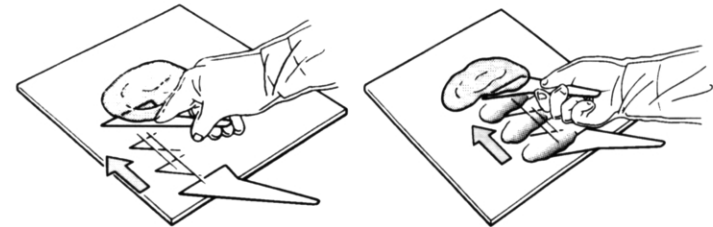
2. Mix polyester putty

(1) Take out the desired amount of putty, make sure to stir the putty well before removal.



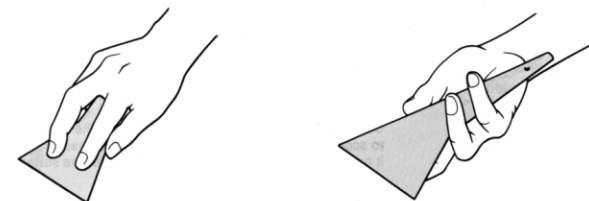
(2) Mix polyester putty and hardener

Mix the polyester putty with hardener according to the proportion indicated by the manufacturer, mix them together thoroughly and achieve a uniform color.

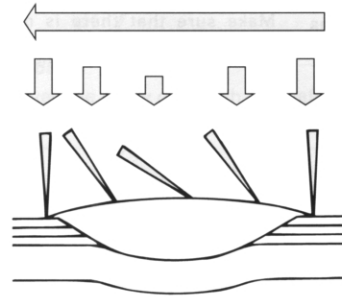
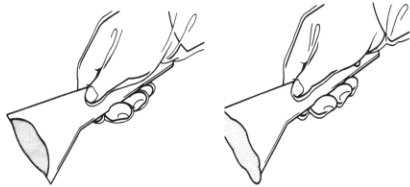


3. Apply polyester putty

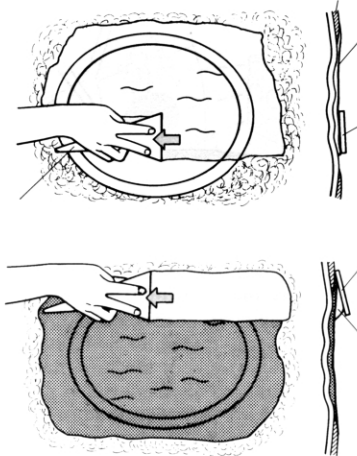
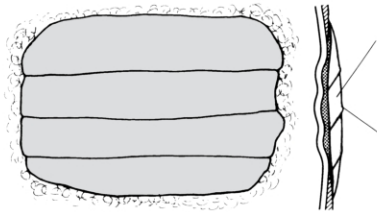
(1) Use a spreader.



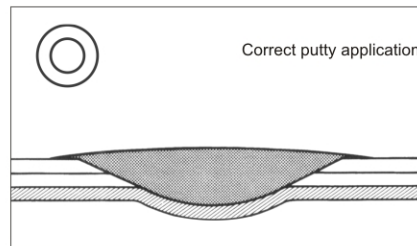
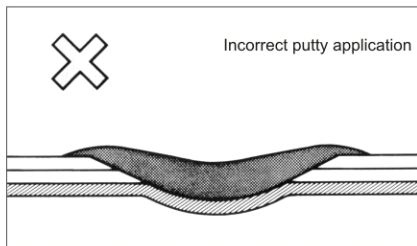
(2) Basic method to apply polyester putty
 Apply a thin coat at a time to make sure the scratches and holes are properly filled. If the dent is deep, apply more coats after the previous coat cures.



(3) Apply polyester putty on a flat surface
 ① Apply a thin coat at a time.
 ② Make sure the surface is flat and even each time, so that the sanding job afterwards is as easy as possible.

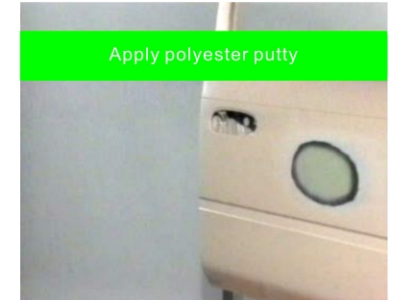


Note 1:



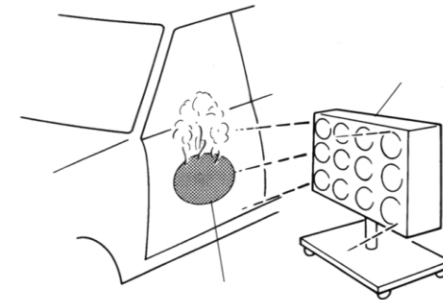
Note 2:

- ① The surface must be sanded before applying polyester putty.
- ② Normal working time is about 3 minutes after the putty is mixed with hardener.
- ③ Spreader should be cleaned immediately after using.
- ④ Polyester putty mixed with hardener will produce heat when curing, so make sure the remain of mixture putty is cold when discarded.



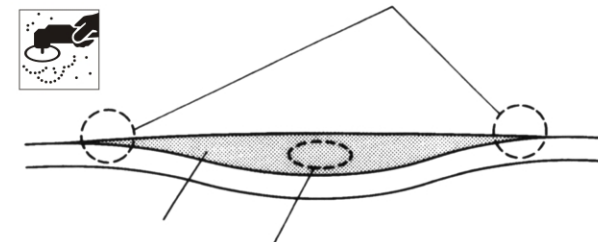
4. Dry polyester putty

The dry-to-sand time of the polyester putty is about 20-30 minutes. In conditions of low temperature or high humidity, the drying time will be longer. Infrared or baking can be used to shorten the drying time.

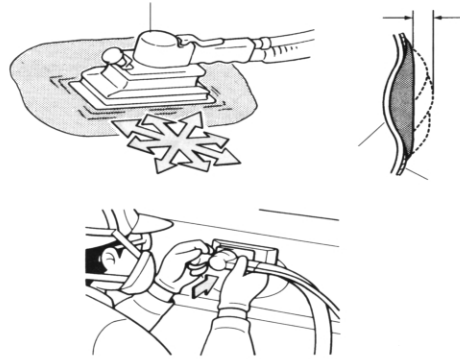


5. Sand polyester putty

Sand and smooth the surface of the putty by hand or sander. A orbital sander is preferable than DA sander.

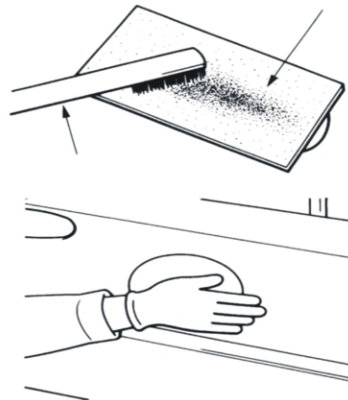


Use P80 grit sandpaper first and followed by P180, Sand the surface in several directions: forward to backward, right to left, and diagonally. Note:
 1. Not allowed to sand before the putty layer is completely cool.
 2. Do not attempt to smooth the surface by a time, check how even is the surface by hand or straight scale from time to time.
 3. Sanded area is where the putty is applied on.

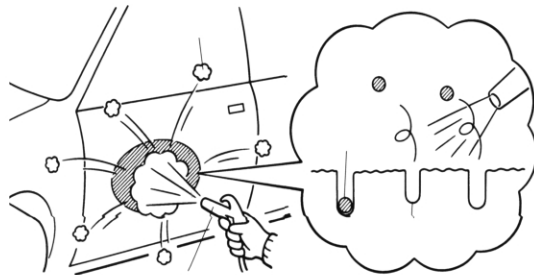


6. Remove the sanding scratches

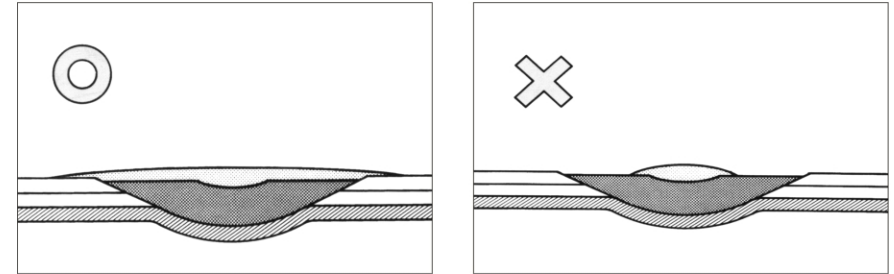
Remove sanding scratches with P320-P400 grit sandpaper. A sanding block is recommended to use.
 (1) Sanding area should be larger than previous sanded area.
 (2) The putty should be properly feather edge and blend smoothly into the panel.
 (3) Clean Thoroughly.
 (4) Check the result from time to time .



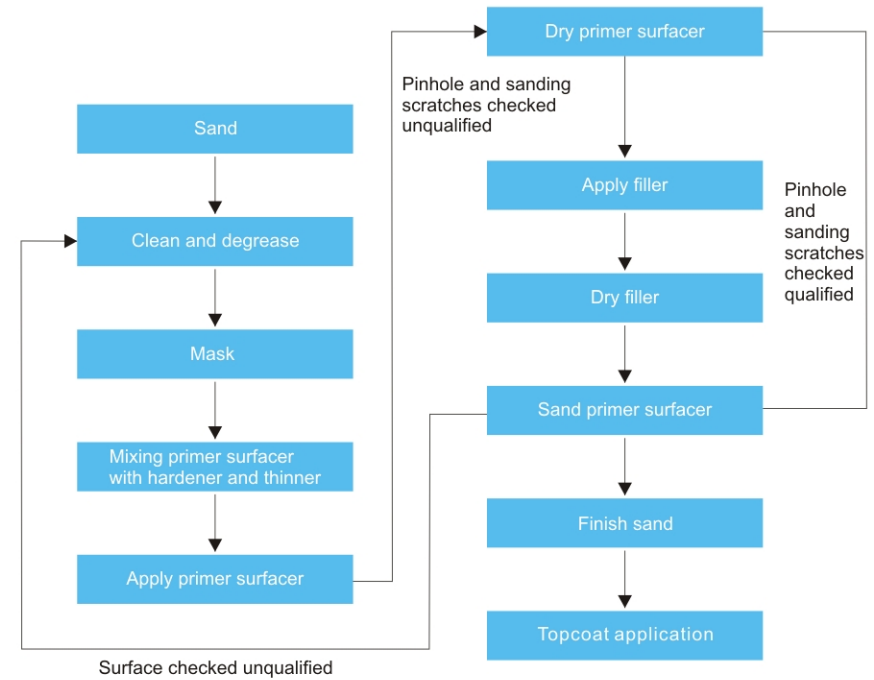
Reference:
 Clean and degrease: Blow off dust with high pressure air gun and follow the degreasing process.



Re-coat the polyester putty. If the surface is not finished perfectly, apply more coats to build up the repair area to a proper contour.

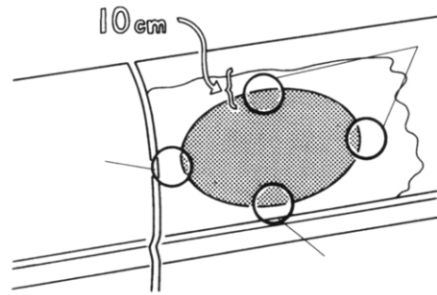


Primer surfacer application



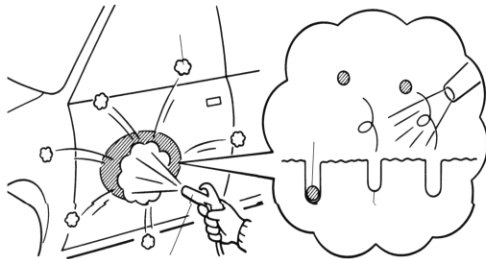
1. Sand

- (1) Sand existing paint with P320 grit sandpaper to promote adhesion of primer surfacer to the surface.
- (2) The width of sanding area is approximately 10 cm beyond the edge of putty.



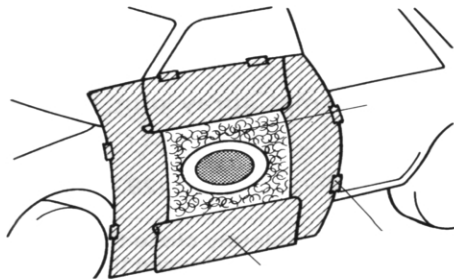
2. Clean and Degrease

Blow off the surface with high pressure air gun and degrease .



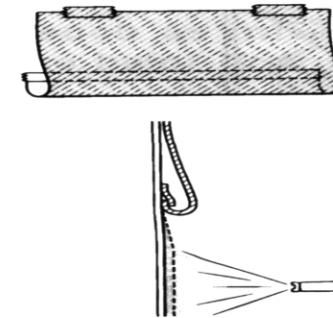
3. Mask

Mask nearby area.



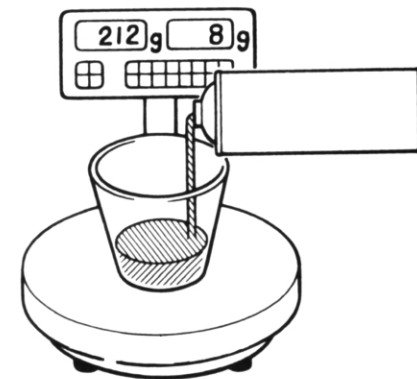
Note:

- A) When masking, make sure the surface is properly masked with the application area exposed while masking paper should not go beyond the sanding area.
- B) To avoid the lip at the edge of the coating of primer surfacer, masking paper should be masked by the way of backward masking.



4. Mix primer surfacer

Mix primer surfacer with its hardener and thinner according to the manufacturer's instructions.

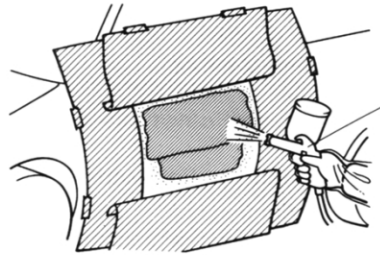
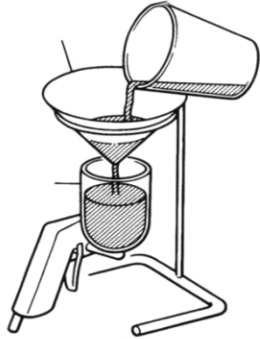


Note:

- A) Stir the primer surfacer in can well before use.
- B) 2K primer surfacer is recommended for high performance of filling power and compatibility to topcoat while 1K primer surfacer is suitable for economical refinishing.
- C) Choose right hardener and thinner according to the ambient temperature.

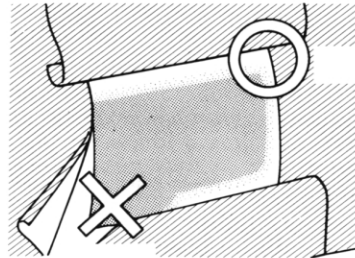
5. Apply primer surfacer

- (1) Stir the mixture of primer surfacer, hardener and thinner well; Pour the paint into the spray gun with filter.
- (2) Apply 2-3 coats of primer surfacer.
- (3) Allow enough flash-off time between coats.
- (4) Apply a sanding guide coat on the surface of primer surfacer.



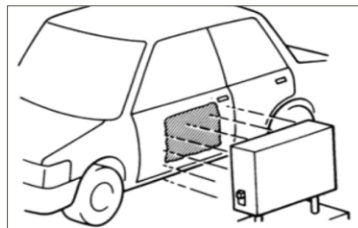
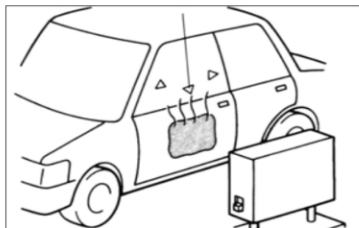
Note:

- A) When applying the second or third coat, expand the coating area a little further beyond the previous coats.
- B) If the primer surfacer is sprayed beyond the masking paper, a lip will result in the edge of the coating.



6. Dry primer surfacer

- (1) Drying time of the primer surfacer: 2-3 hours at 20°C, 45 minutes at 60°C (refer to the manufacturer's instructions).
- (2) Allow enough flash-off time indicated by the manufacturer before force drying.



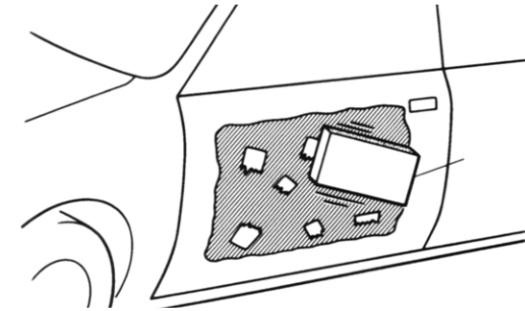
7. Applying filler

- (1) Check for pinhole and sanding scratches.
- (2) Apply filler to cover the pinholes and scratches.

8. Sanding primer surfacer

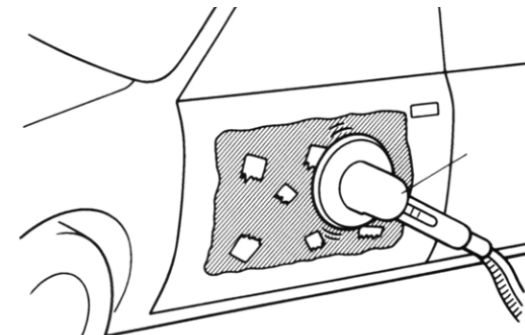
Dry sanding or wet sanding(Dry sand the dried primer surfacer with P400-500. If necessary, wet sand partly with P600-800)

- (1) Dry sanding by hand
Using a sanding block with P600 grit sandpaper. As the sandpaper will get dull with dust, keep to use the fresh side of the sandpaper or remove the dust from the sandpaper with brush.



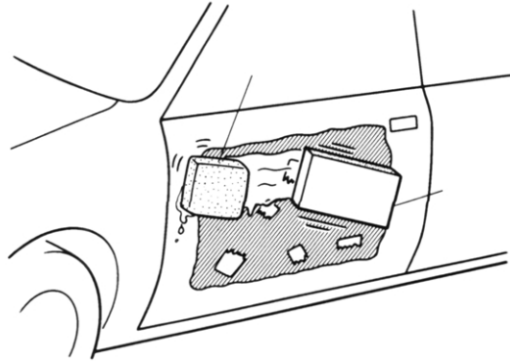
(2) Dry sanding by sander

Using DA sander with P400 grit sandpaper. Finished by hand sanding wet.

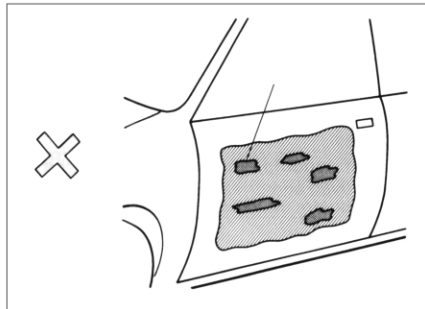
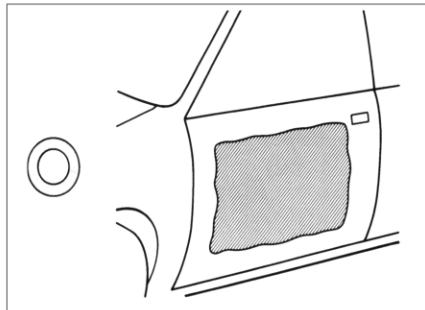


(3) Wet sanding by hand

After sanding with DA sander, Finally finish the surface by hand using a sanding block with P600-P800 grit sandpaper. After sanding, dry the whole panel.



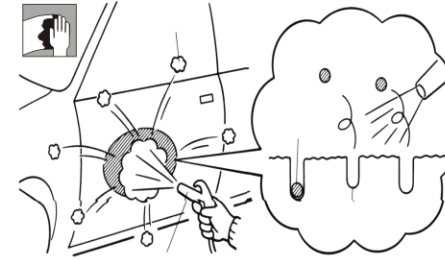
(4) Check if the surface is perfectly smooth and even with no putty or bare metal visible.



TOP COAT APPLICATION

1. Clean and degrease

Blow off the dust on the car body and car door with high-pressure air gun, remove contaminations with degreaser and wipe off the repair area clean with tack cloth.



2. Mask the car body



3. Mix the paint

Find the color formula in the mixing system for the car and mix the paint, spray the paint on a small plate to compare the color with that of the car. If necessary, adjust the color by tinting till it match the car.



4. Spray the top coat

(1) 2K Topcoat

Mix the paint with right proportion of hardener and thinner. Spray 2-3 coats till satisfactory coverage is achieved. Allow 5-10 minutes flash-off time between coats. Make sure to use the proper hardener and thinner according to the weather conditions.



(2) 1K Basecoat

Mix the 1K basecoat with right proportion of thinner. Spray 2-3 coats till satisfactory coverage is achieved. Allow 5-10 minutes flash-off time between coats. Use tag cloth to wipe off overcoated paint after the flash-off of each coat to achieve better effect if necessary.



(3) Apply Clear coat

Mix clear coat with right proportion and type of hardener and thinner according to the manufacturer's instructions. Spray 2 coats of medium solid clear coat or one and a half coats of high solid one. Allow 5-10 minutes of flash-off time between coats and 15-20 minutes before force drying.



Polishing

Dust particles and sagging area can be sanded out with P1500-P2000 grit sandpaper wet after the clear coat is completely dry. Compound and polish to restore gloss.



Easy Coat, Easy Life

EasiCoat

CAR PAINT

Paint Defect Guide



Orange Peel



(Poor Flow, Texture)

Paint film having an uneven texture, much like the skin of an orange.

Cause

- (1) The paint is under reduction. The viscosity is too high for spray conditions.
- (2) Thinner/reducer evaporates too fast for spray conditions.
- (3) Extreme shop temperature. When ambient temperature is too high, droplets lose more solvent and dry out before they can flow and level properly.
- (4) Improper gun adjustment and techniques.
 - ① Excessively thick or thin film, spray gun too far from surface.
 - ② Incorrect compressed air pressure and nozzle adjustment.
 - (5) Improper flash-off or recoat time between coats.
 - (6) The substrate was not sanded thoroughly.

Prevention

- (1) Reduce to proper viscosity in recommended ratio.
- (2) Select recommended thinner/reducer based on temperature, humidity, air movement, and size of repair.
- (3) Use proper gun adjustments, techniques, and air pressure.
- (4) Ensure sufficient flash-off and drying time.
- (5) Prepare and sand substrate correctly.
- (6) Avoid temperature and humidity extremes. The temperature of the substrate shall be less than 50°C. Recommended air temperature is around 20°C.

Repair

- (1) Compound or polish to reduce surface texture.
- (2) Or, sand smooth with very fine grit sandpaper, compound and polish to restore gloss.
- (3) Or, sand down to smooth surface and refinish.

Runs/Sags



Coatings that fail to adhere uniformly, causing beads, droplets, or slippage of the total film.

Cause

- (1) Over reduction and/or too slow evaporating thinner.
- (2) Applying paint materials without proper flash-off time between coats.
- (3) Applying excessive wet coats due to:
 - ① Holding the gun too close to the surface.
 - ② Slow gun speed.
 - ③ Double coating.
- (4) Incorrect gun set-up and too low air pressure.
- (5) Unbalanced spray pattern.
- (6) Ambient or substrate temperature too low, or/and poor ventilation.
- (7) Surface is contaminated by oil, grease, etc. or existing paint film is not sanded.

Repair

- (1) Remove the wet paint film with solvent, clean and refinish.
- (2) Or, after finish is completely dry, remove excess paint by block sanding with P1200 or finer grit sandpaper, compound and polish to restore gloss.
- (3) Or, sand to a smooth surface and refinish.

Blushing**(Milkiness)**

A milky gray cloud appears on the surface of the paint film.

Cause

When spraying during humid conditions, air from the spray gun and solvent evaporation lowers the substrate temperature below the dew point, causing moisture in the air to condense in or on the paint film. The condition is aggravated when

- (1) Too fast drying or poor quality thinner is used;
- (2) Fanning dry the paint film to speed up solvent release;
- (3) Inadequate heating and / or air movement.

Prevention

- (1) Use good quality and proper thinner for spraying conditions.
- (2) Add the recommended amount of retarder solvent when spraying in humid conditions.
- (3) Use proper gun set-up and techniques.
- (4) Ensure the paint booth is properly ventilated, adequately heated.

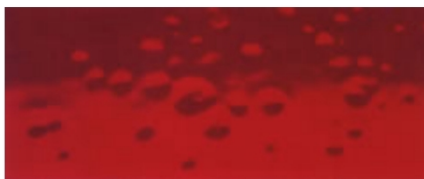
Repair

(1) Should blushing occur during application:

- ① apply heat to the affected area, or
- ② add retarder solvent and apply additional coats.

(2) If the finish has dried, minor blushing may be corrected by compounding or polishing.

(3) Severe cases will require sanding and refinishing.

Fisheyes**(Silicone Contamination, Cratering)**

Small circular, crater-like openings in the finish.

Cause

(1) Contaminations

- ① Surfaces contaminated with oil, wax, silicone, grease, etc. Silicones adhere firmly to the paint film and require extra effort for their removal. Even small quantities in sanding dust, rags can cause this type of failure.
- ② The remains of soap, detergent in surface cleaning.
- ③ Use of silicone-containing polishes in proximity to the spray area.
- ④ Contaminated air supply, spray gun, other tools and equipments for application.

(2) spray in too high air pressure, hold the spray gun too close to the surface.

Prevention

- (1) Thoroughly clean the surface with wax and grease remover.
- (2) Avoid using silicone polishes in proximity to the paint shop.
- (3) Install an air filtering system that removes and prevents oil and moisture contamination.
- (4) Regular maintenance of the air supply.
- (5) Ensure that the spray gun and compressed air equipment is properly maintained.

Repair

- (1) For mild cases, respray the affected area right after the flash off time with paint added fisheye preventer.
- (2) In severe cases, sand the affected area, clean thoroughly and repaint.

Pinholes

Depressions as small as pin holes or pores of the leather, appear from the top to the bottom of coatings.

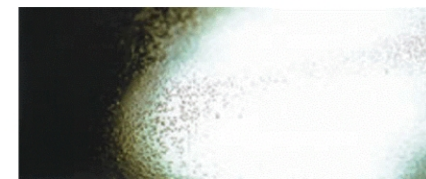
Cause

Pinholes are mainly caused by solvent or moisture, gathering underneath the top layer, no way to volatilize.

- (1) Excessive paint film thickness and no enough time for drying.
- (2) Air trapped in putty and become pinholes after sanding.
- (3) Bad choice of thinner, such as wrong ratio, bad quality, or incorrect type of dry time.
- (4) Incorrect initial cleaning or other pre-treatment, lead moisture existing and bringing about pinholes in the process of evaporation.
- (5) Unsuitable spray techniques, such as incorrect spray gun adjustment or too short distance to the working substrate.
- (6) Insufficient flash-off time before force drying, sudden heating-up, too fast exterior drying.
- (7) Too high temperature of the repair substrate itself.

Repair

- (1) Sand through to putty layer, fill pinholes and redo putty works where needed, then sand smooth and continue the repair process.
- (2) Pinholes or scratches in the putty surface after sanding can be filled by a thin coat of polyester putty or pinhole filler. Hold the spreader vertical to the surface so that the spreader may push the putty into the holes and does not pull it out at each stroke.

Solvent Popping

Small bubbles in the top paint film, some burst.

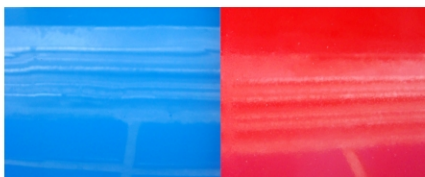
Cause

It is often seen that more or less moisture goes into the paint film, even in the best refinishing job. When moisture brings enough pressure to paint film, it will lessen adhesion between coats or adhesion of the whole coating to the substrate. Then small bubbles come out. It is often happens in hot, rainy or humid days.

- (1) Main reason: improper preparation and cleaning of surface. Surface not completely dry after sanding or cleaning with water. Use petrol instead of recommended degreaser to degrease, its content of water soluble or foreign matters remain on the surface.
- (2) No enough time for complete evaporation for solvent due to insufficient flash-off between coats or excessive coating thickness of primer.
- (3) Use too fast evaporating thinner or high viscosity paints.
- (4) Bad quality thinner will make the primer not dry properly. After topcoating, solvent remained in the undercoats evaporates by heat and cause popping.
- (5) Insufficient flash-off time before force dry, sudden heating-up, too fast exterior drying.
- (6) Too high temperature for drying.
- (7) Too high air pressure of spray gun or dry spray method for applying primer.

Repair

Sand and refinish.

Loss Of Gloss

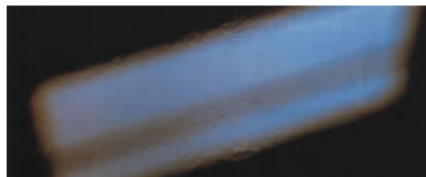
Beautiful shine of wet film but loss of gloss as the film dries or ages.

Cause

- (1) Coarse substrate and rough sanding paper lead to higher absorption of top coats.
- (2) Excessive thickness and roughness of silver basecoat lead to absorption of clear coat.
- (3) Thick coating of putty which is not thoroughly dry.
- (4) Insufficient dry of the clear coat before polish.
- (5) Improper thinner ratio.
- (6) Thinner choice does not match spray booth condition.
- (7) Bad condition of spray booth may lead moisture trapped onto top coat:
 - ① Insufficient air ventilation or unsuitable air circulation.
 - ② Too hot, too cold or too humid.

Repair

Polish to improve gloss after paint film dries completely. If ineffective, sand and refinish.

Lifting / Solvent Aggression

Top coat lifts the undercoat, which causes wrinkling, expanding and bubbling.

Cause

- (1) Spray top coat before undercoat dries.
- (2) Unsuitable flash-off time between coats.
- (3) Bad solvent resistant of undercoat or too powerful solvency of top coat.
- (4) Bad adhesion of undercoat.
- (5) Excessive thickness of each layer.

Repair

Lightly sand the affected area and seal the surface, then re-spray; Extra care to the sensitive substrate; Keep each layer thin and flash off time long enough; If lifted seriously, completely remove the entire area and apply the paint system again.

Poor Adhesion

Bad joint between top coat and primer, or between top coat and existing paint, or between primer and bare metal.

Cause

- (1) Main reason: Incorrect surface cleaning and preparation. Dust or other contaminations remained on the surface lead to poor adhesion.
- (2) Incompatibility of primer and top coat or incompatibility of primer and substrate.
- (3) Spray top coat before the under coat dries.
- (4) Insufficient sanding or absolutely no sanding makes the substrate too smooth.
- (5) Bad quality thinner and lack of solvency.
- (6) Masking without the first color completely dry during dual-color application.
- (7) While painting silver color, no enough flash-off time between coats or too high viscosity.
- (8) Too long flash-off time between basecoat and clear coat.
- (9) There is invisible water film on the primer surface when spray top coat:
 - ① The weather is too humid while applying primer surface.
 - ② Dry overnight on the primer in humid environment.
- (10) The paint film dry too much before removal of masking may cause peel-off at the edge.

Repair

- (1) In serious case, remove the existing paint and apply the color system again.
- (2) If caused by the paster, re-sand the affected area and re-spray.

Poor DIO

Distinctness of Image (DIO) is a value indicates the surface quality of the paint film, which is closely related to the smoothness and gloss of the paint film. Poor DIO means bad decoration performance. DIO can be felt by vision or measured by instrument.

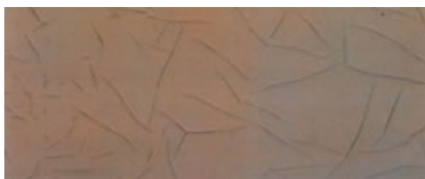
Cause

- (1) Coarse substrate, rough sanding paper or not fine enough sanding.
- (2) Paint applied runs vertically, lack of gloss, fails in fineness and opacity.
- (3) Bad spray booth condition lead to particles existing on the top and lack of gloss.
- (4) Bad atomization causes serious orange peel.
- (5) Insufficient thickness makes lack of saturation.

Repair

Compound and polish after the topcoat is completely dry or refinish with another good quality product.

Cracking



Cracks or lines of various width, length and depth exist in the coating finish.

Cause

- (1) Existing cracking of the old paint film is not sanded completely before top coat.
- (2) Imperfect aged existing paint which is incompatible to the refinishing system.
- (3) Unsuitable substrate treatment:
 - ① too rough sanding material.
 - ② not clean enough.
 - ③ improper application of body filler.
- (4) Spray thermopaint onto the insufficient hardened paint film or thermoplastic acrylic coat.
- (5) Cracks of putty.
- (6) Excessive thickness: the thicker of the paint (especially air dried type), the lower tolerance to cold and lead to crack.
- (7) The paint is not mixed well with hardener and thinner before spraying, under reduced or reduced with wrong type of thinner.
- (8) Th substrate is too cold or too hot while spraying.

Repair

- (1) If slight affection, re-sand the affected area and re-spray.
- (2) In serious case, remove the existing paint and apply the color system again.

Wrinkling



Textured surface of the paint film with uneven wave type formation. This happens when the surface of the paint film dries faster than the substrate coats.

Cause

- (1) Excessive coat thickness.
- (2) Bad dry condition:
 - ① too low or too high temperature.
 - ② too large or too small air flow.
 - ③ polluted air.
- (3) Insufficient flash-off time, or high temperature accelerated drying, or sun exposure.
- (4) Incorrect thinner: too powerful penetrability of thinner may swell to wrinkle.
- (5) Too long time for some synthetic resin baking finish to dry in the air before baking.
- (6) Spray polyurethane coat onto the existing nitril paint and re-mend later.

Repair

- (1) Make paint film completely dry.
- (2) If slight affection, re-sand the affected area and polish.
- (3) In serious case, remove the existing paint and apply the color system again.

Particles and Dust



Particles or dirt and dust in the paint surface.

Cause

- (1) Faulty ceiling filters in the spray booth or baking room.
- (2) Incorrect cleaning of the surface before application of the paint.
- (3) Dirty packing tin and paint not adequately filtered before use.
- (4) Dust in the gaps of the car body not completely blown off.
- (5) Dirty spray booth.
- (6) Incorrect air filtering.
- (7) Dirty application area.
- (8) After spraying, particles in the air drop on the paint surface.
- (9) Paint deterioration.

Repair

- (1) For very small particles, sand lightly with water and polish.
- (2) If seriously contaminated, sand and then re-spray.

Poor Drying



The paint film could not dry thoroughly after normal necessary time and requires an extra long drying period, or fails to cure thoroughly.

Cause

- (1) Incorrect mixing ratio of 2K paint (too much or less of hardener) .
- (2) Unsuitable hardener.
- (3) The temperature could not reach requirement. Normally speaking, when the temperature is lower than 10 °C, the drying process would be excessively slow.
- (4) Over-thickness of the paint film.
- (5) Poor weather condition and poor ventilation.
- (6) Insufficient, bad quality or wrong thinner.
- (7) Incorrect application method.

Repair

- (1) Increase the drying temperature to make the paint film dry thoroughly.
- (2) If the paint film could not dry thoroughly even by increasing the temperature, sand or remove the paint, then re-spray.

Clouding or Mottling

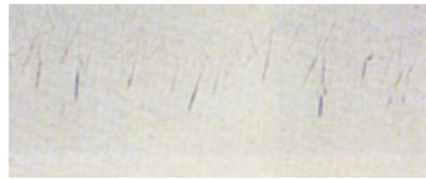
Uneven color or poor effect of metallic finishes due to the uneven thickness of sprayed paint and the poor distribution of silver granules.

Cause

- (1) Insufficient mixing of paint.
- (2) Incorrect thinner or thinner of poor solubility.
- (3) Unsuitable spray viscosity.
- (4) Uneven spray thickness and poor spraying technique.
- (5) Insufficient flash-off time.
- (6) Spray too thick or too wet.
- (7) Incorrect application temperature.

Repair

- (1) Further spray one coat of paint with correct technique to cover the defects.
- (2) Sand and re-spray when the defected surface is thoroughly dry.

Sanding marks

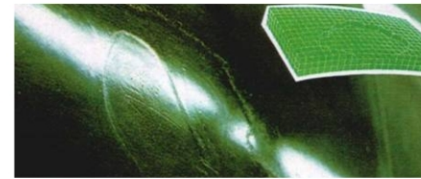
Sanding marks in the substrate show in the topcoat after paint drying.

Cause

- (1) Incorrect substrate preparation: insufficient filler or poor quality and excessive coarse sanding paper.
- (2) Poor sanding tools or wrong sanding method.
- (3) Insufficient paint thickness of topcoat.
- (4) Sand with no sanding board in flat finishes.
- (5) The primer prior to topcoat is over thick and insufficient drying time for the primer.
- (6) Incorrect preparation of the old existing paint finishes.

Repair

- (1) Sand with extra fine paper, then polish.
- (2) If the surface is seriously defected, sand, then re-spray.

Putty Marks or Edge Shrinking

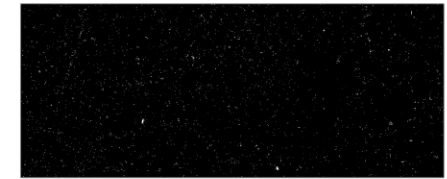
The repaired area by polyester putty or its edge showing in the topcoat.

Cause

- (1) Insufficient sanding of putty.
- (2) Sanding paper of wrong size.
- (3) Paint absorption of putty is too serious because putty is not sealed by primer surfacer.
- (4) Putty layer too thick and before over-coated, not thoroughly drying.
- (5) Excessive shrinkage of putty; distortion after drying.

Repair

- (1) Sand the putty layer sufficiently and ensure smooth and even edge of putty.
- (2) Use primer surfacer to seal the repaired area by putty.
- (3) Use putty with small shrinkage.

Paint Mist, Dry Spray

In the spray process, paint mists drop on the paint finish and make the paint finish rough, full of small particles and loss of gloss.

Cause

- (1) Incorrect spray method: Spray gun too far away from the surface, not vertical to the surface, spray speed too fast, or air pressure too high.
- (2) Incorrect viscosity; thinner too fast.
- (3) Too near to the surface and easily affected by the paint mist.
- (4) Poor ventilation of the spray booth.
- (5) No covering of the part unnecessary for application.
- (6) Dirty or damaged spray gun.

Repair

- (1) Primer: Allow it dry, then sand.
- (2) Topcoat: Fine sand the last layer of dry spray, then polish.
- (3) Single layer silver basecoat: Sand and re-spray.

Color Floating

Because the granule size, shape, density and dispersion of pigments are different, the pigments in the top layer and under layer disperse unevenly, and there is color difference in different spray layer.

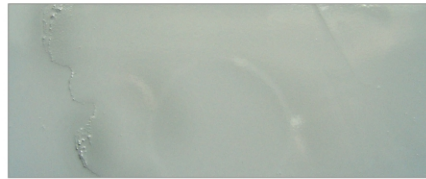
Cause

Color floating relates closely with pigment convection during the formation process of paint finishes, thus incorrect manufacturing formula and technique are the main reason for this paint defect.

- (1) In the manufacturing which needs more than two pigments, color floating occurs easily because solvent in the coating volatilizes differently.
- (2) Excessive difference in density of different pigments.
- (3) Dispersion of color paste could not reach requirement, incorrect dispersion method, or unsuitable dispersing machine.
- (4) Lack of anti-floating agent.
- (5) Low viscosity.

Repair

Re-spray with qualified paint over the defected paint finish.

Putty Patch or Substrate Scratches

During the paint drying process, paint finish loses gloss and the under layer defects like putty patches and substrate scratches could be seen easily.

Cause

- (1) Wrong size of sanding paper and poor sanding.
- (2) Substrate dry spray.
- (3) Insufficient flash-off time between layers.
- (4) Poor drying condition.
- (5) Primer is sanded when it is not thoroughly drying.
- (6) Uneven stirring of the primer.
- (7) Poor solubility of thinner.

Repair

- (1) For small defect, after thoroughly drying, fine sand, then polish.
- (2) In serious cases, after thoroughly drying, fine sand, then re-spray.

Polyester Putty Adhesion Loss

Adhesion loss between polyester putty and the substrates.

Cause

- (1) Substrate not properly prepared (main reason).
- (2) Unsuitable polyester putty.
- (3) Improper use of infrared baking machine.

Repair

Sand the damaged area and redo the repair. (Before application of the putty, better to clean the existing paint finishes with thinner, if the existing paint color fades, sand the existing paint finishes to ensure good substrate).

Uneven Color, Color Variation

Uneven color in part of the paint finish with streaks or patches of lighter or darker tint.

Cause

- (1) Poor dispersion of paint pigments; insufficient mixing of different color paint; use thinner with poor solubility; improper viscosity.
- (2) Uneven spray thickness. In thickly sprayed parts, pigments convection and make color floating.
- (3) Poor spraying technique: improper overlapping, too near from the paint surface, wrong angle between the spray gun and the surface (main reason).
- (4) In the application site, there is gas source able to react with paint finish, such as ammonia, or carbon dioxide.
- (5) Spray tools not clean enough.
- (6) Incorrect spray nozzle and spray pressure.
- (7) Unsuitable thinner.

Repair

Allow the paint finish dry thoroughly, sand wet, then re-spray.

Off color, Color Mismatching

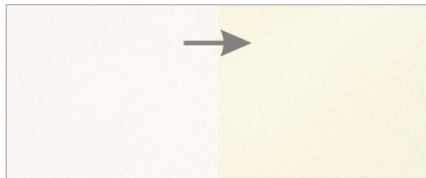
The new sprayed color of the repaired parts is different from the original color of the car being repainted.

Cause

- (1) Poor color mixing technique or poor spray of spot repair.
- (2) Incorrect application technique, too wet, too dry or poor coverage.
- (3) Color of the mixed paint is different from the color swatch.
- (4) Finish color changes under different light.
- (5) Wrong color formula.
- (6) Insufficient stirring of color tinter.
- (7) Insufficient mixing with hardener or thinner.

Repair

- (1) For small color mismatch, polish the paint finish.
- (2) In serious cases, fine sand and re-spray with right formula.

Yellowing of Clear Coat

Clear coat has a yellow hue to it.

Cause

New paint:

- (1) Contaminated mixing equipment.
- (2) Defective clear coat or /and hardener.

Old paint:

- (1) Clear coat too thin.
- (2) Contaminated hardener, no cross link.
- (3) Defective clear coat.
- (4) Influence of corrosive conditions.

Prevention

- (1) Ensure lids are tightly replaced after using hardeners.
- (2) Follow recommendations per Technical Data Sheets.
- (3) Use recommended hardener.

Repair

Allow the finish properly dry. Sand and repaint.

Transparency, Poor Hiding

The under coat or existing finish is visible through the topcoat.

Cause

- (1) Insufficient number or/and film thickness of color coat applied.
- (2) Colors not well stirred.
- (3) Colors over thinned.
- (4) Topcoat over compounded or polished.
- (5) Substrate's color was not correct and uniform.
- (6) Inadequate lighting in spray area.

Prevention

- (1) Use thinner according to recommended ratio.
- (2) Stir color thoroughly.
- (3) Use proper undercoat.
- (4) Install adequate lighting device.
- (5) Compound or polish in appropriate technique.

Repair

Apply sufficient coats of color until hiding is achieved. Or sand and repaint.

Bleeding

Existing finish color or peroxide hardener from polyester body filler seeping through the topcoat, causing a discoloration of the new finish.

Cause

- (1) Solvent in the new topcoat dissolves soluble dyes or pigments in the existing finish. This is usually true with older shades of red or maroon.
- (2) Apply top coat on undercoat not thoroughly dry.
- (3) Existing finish not well sealed.
- (4) Use of too much hardener in the polyester putty or filler.
- (5) Insufficient mixing of the polyester putty or filler.

Prevention

- (1) Test existing finish by spraying a small area.
- (2) Use sealer on existing finish.
- (3) Mix polyester putty with recommended hardener by weight and mix thoroughly.
- (4) Ensure the undercoat is properly dry.

Repair

Sand down to existing finish, isolated with proper sealer and repaint.

Chalking



A chalky white appearance on the surface of the paint film.

Cause

- (1) Pigment is no longer held and protected by resin, resulting in a powder-like surface and lack of gloss due to
- ① Nature weathering of the paint film:
- ② Use improper thinner, or/and hardener:
- ③ Inadequate paint film thickness:
- ④ Repeat exposure to harsh environment or strong sunlight.

Prevention

- (1) Use recommended thinner/hardener.
- (2) Avoid exposure to strong sunlight and harsh environment.

Repair

Compound and polish to restore gloss. In severe cases, sand and repaint topcoat.

Fading



Color pigments changed after exposure to prolonged sunlight.

Cause

- (1) Inferior paint used for refinishing.
- (2) Repeated exposure to strong sunlight or corrosive atmosphere or contaminations .
- (3) Use inappropriate hardener which lower the properties of the paint film.

Prevention

- (1) Use quality paint for refinishing.
- (2) Protect the vehicle from bright sunlight when not in use.
- (3) Keep vehicle clean and well maintained.
- (4) Use recommended hardener per Technical Data Sheet.

Repair

Sand and repaint.

Car paint application flow chart

A	Surface Preparation	1. Remove contamination thoroughly 2. Could prime with etch primer to ensure good adhesion 3. Allow the surface to dry for 30 minutes after degreased			For Plastic Parts: 1. Clean surface with suds and wash with clean water; 2. Sand with P400-600 and degrease			
B	Fast Epoxy Primer	Fast Epoxy Primer			Plastic Primer	2 in 1 Plastic Primer		
		Substrate	Sanded existing finishes, metal and fiber reinforced plastics, etc.			Substrate	Plastic parts	
	Mixing Ratio	Item	Weight	Volume	Mixing Ratio	Ready for use	2 in 1 Plastic primer:E-1 = 1: 0.3-0.5	
		Epoxy Primer	100 parts	3.5 parts	No. of Coats	2 coats, 1-2um in total	2 coats, 15-25um in total	
		5651 Fast Drying Hardener	20 parts	1 parts	Flash-off Time	5-10 minutes between coats,20°C		
		5750 Thinner	20-30 parts	1 parts	Drying Time	10-15 minutes/20°C	30 minutes/20°C	
	Pot Life	20°C, 3-4 hours			Recoatability	Recoat after dry	Sand with P600-800 after dry before recoating	
	No. of Coats	2-3 coats, 40-60um in total			Note	1. No need to mix with hardener 2. Recommend to spray a thin coat to avoid peeling off 3. Due to the variety of plastic parts, it is recommended to take a test before application		
	Flash-off Time	20°C, 5-10 minutes between coats						
	Drying Time	20°C		60°C				
5-6 hours		50-60 minutes						
Sanding	Sand with P240-400 dry or P600-800 Wet			C	Note	1. Mix with hardener by right ratio. Blend them well to avoid cracking or poor curing; 2. Spread a thin coat once on the surface. Deep repair area better spread with several thin coats with thickness less than 1.5mm a coat to avoid sand hole, bubbling and cracks. 3. The putty hardener is flammable, explosive and irritating to skin. Avoid contact with skin.		
Substrate	Sanded bare metal or epoxy primer							
Mixing Ratio	Putty : Hardener = 100 parts: 2-3 parts (Weight)							
Pot Life	Refer to the technical data sheet.							
Putty	Sanding Time							
	Sanding	Wet sanding: First sanding wet with P80-240, second sanding wet with P320-400. Dry sanding:The drying time for dry sanding is 2 hours						
Small sand holes of putty can be filled with filler.								

Car paint application flow chart

D	Substrate	Dried and sanded existing finishes, all kinds of primer and putty.				Pot Life	20°C, EC-5641 fast drying hardener: 45 minutes; EC-5642 Standard hardener: 1.5 hours			
	2K Primer Surfacer	Mixing Ratio	Temperature	Item	Weight	Volume	No. of Coats	2-3 coats. 50-80um in total		
			<25°C	EC-5442 primer surfacer	100 parts	3 parts	Flash-off Time	5-10 minutes, 20°C		
				EC-5641 fast drying hardener	25 parts	1 parts	Drying Time	2-3 hours (20°C) or 45 minutes (60°C)		
				E-1 Thinner	25-40 parts	1-1.5 parts	Sanding	Sand with P400-600 dry or P800-1000 wet.		
			≥25°C	EC-5442 primer surfacer	100 parts	3 parts	Note	1. After sanding of 2K primer surfacer, spread thin coat of putty or filler to cover small holes or dent, then sand the area again. 2. Recoat with 2K primer surfacer to provide optimum coverage and unified color. 3. After drying and sanding, recoat with topcoat.		
				EC-5642 Standard hardener	25 parts	1 parts				
	E-2 or E-3 Thinner	25-40 parts		1-1.5 parts						
	E	Substrate	Dried and sanded existing finishes, 1K or 2K primer surfacer.				Substrate	Dried and sanded existing finishes, 1K or 2K primer surfacer.		
	2K Topcoat	Mixing Ratio	Temperature	Paint (100 parts)	Hardener (50 parts)	Thinner (right proportion)	1K Basecoat	Temperature	Paint (1 part)	Thinner (0.6-0.8 parts)
< 18°C			2K topcoat	Fast drying	E-1 Thinner	< 15°C		1K Basecoat	E-5 Thinner	
18-30°C			2K topcoat	Standard	E-2 Thinner	15-30°C		1K Basecoat	E-1/E-2 Thinner	
>30°C			2K topcoat	Slow drying	E-3 Thinner	>30°C		1K Basecoat	E-3 Thinner	
Pot Life		20°C, Fast drying hardener: 2 hours; Standard or slow drying hardener: 4 hours				No. of Coats	2-3 coats. total 15-25um			
No. of Coats		2-3 coats, 40-60um in total				Flash-off Time	At 20°C, 5-10 minutes between coats, allow 15-20minutes air-drying time before applying clear coat.			
Flash-off Time		5-10 minutes between coats, 20°C, allow 15-20minutes air-drying time before baking				Substrate	1K Basecoat			
Drying Time		Temperature	Dust Free	Tack Free	Dry to Handle	Thorough Dry	Mixing Ratio	Please refer to the technical data sheet.		
		20°C	45 minutes	2-3 hours	10 hours	7 days	Application	Spray lightly one mist coat, then spray two wet coats.		
		60°C	5 minutes	15 minutes	30 minutes	60 minutes	Flash-off Time	At 20°C, 5-10 minutes between coats, allow 15-20minutes air-drying time before baking		
						Drying Time	Please refer to technical data sheet.			

Car paint application flow chart

Note	<ol style="list-style-type: none"> Remains of moisture in the sanding marks is harmful to the property of paint film. If the substrate is prepared with P800-1000 wet, blow dry the surface with spray gun. At temperature lower than 15°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C. At ambient temperature higher than 30°C, Add Retarder Solvent as thinner to avoid blushing. Details please refer to the product data sheet of Retarder Solvent. In the event of fisheyes during application, Add 0.5-1% Anti Silicon in the paint remained and re-spray the affected area. In the overlap area of new and existing finish, apply Thinner SRA directly to achieve an invisible transition. Details please refer to the technical data sheet of Thinner SRA. The products mixed with hardener, should be used out soon and can not restore for future use. Clean equipments immediately with solvent after application. 	Note	<ol style="list-style-type: none"> If the existing finish is not compatible, 2K primer should be used as a sealing layer before applying the basecoat otherwise there may be problems such as lifting, peeling, blistering, flooding, etc. At temperature over 30°C or in high humidity, it is recommended to use retarder solvent to avoid mottling. To avoid problems of mottling or poor adhesion, the metallic paint film should not be thicker than 25um. Better effect could be achieved if the extra silver powder could be removed with tack rag after the flash-off of every layer. At temperature lower than 15°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C. At ambient temperature higher than 30°C, Add Retarder Solvent as thinner to avoid blushing. Details please refer to the technical data sheet of Retarder Solvent. In the events of fisheyes during application, Add 0.5-1% Anti Silicon in the paint remained and re-spray the affected area. In the overspray area, apply directly Thinner SRA to achieve an invisible transition. Details please refer to the technical data sheet of Thinner SRA. When mixed with hardener, the products should be use out soon and can not restore for future use. 	
F	Application equipment	Polisher, Clean Cloth, Pad.	Note	Make sure that the pad is free of dust and particles. Clean and wash the pad with suitable cleaner.
Polishing	Application steps	<ol style="list-style-type: none"> Use P1200 or P1500 for wet sanding to sand out dust particles or sagging area of paint film. Compound to remove sanding marks. Polish to remove compound haze and restore gloss. Seal the shine with glaze 		

EASICOAT COLOURBASE'S CHARACTERISTIC TABLE E3

Item	Description	Characteristic	Item	Description	Characteristic
C10	White	Standard White	B10	White	Standard White
C20	Black	Black With Yellow Shade	B11	Transparent White	Yellow golden on the face and blue white on the flop
C21	Extra Black	High Jetness Blue Shade Black	B22	General Black	Yellow shade black
C30	Violet Blue	Violet On the face and flop	B23	Blue Black	Blue shade black
C31	Blue Toner	Blue with red flop	B25	Black	High jetness with high transparency
C32	Transparent Blue	Blue with a green face and red flop	B26	Extra Black	Extra black ,Blue shade if used individually
C40	Green	Green with a blue cast	B30	Violet Blue	Violet on the face and flop
C41	Yellow Green	Green with a yellow cast	B31	Blue Toner	Blue face and red flop
C50	Burgundy Red	Bright violet on the face and dark red on the flop, can't be used with white	B32	Transparent Blue	Green face and red flop
C51	Brick Red	Dirty red on the face and yellow on the flop	B34	Green Blue	Blue face and green flop
C52	Deep Red	Deep red face with slightly blue hue	B40	Green	Blue shade green
C53	Bright Red	Yellow shade red with violet hue	B41	Yellow Green	Yellow shade green
C54	Orange Red	Yellow shade red ,a little dark	B42	Golden Green	Golden face and green flop
C55	Violet Red	Blue shade violet red	B50	Burgundy Red	Bright violet face with dark red flop
C56	Peach Red	Bright violet red	B51	Transoxide Red	Giving a reddish golden shade in effect colors with dark flop
C57	Leadfree Orange Red	"Yellow shade red, leadfree "	B52	Brick Red	Opaque rusty red
C58	Ferrari Red	Yellow shade red. Good chromaticity.	B53	Bright Red	Yellow shade red with violet hue
C60	Mud Yellow	Dirty yellow on the face and the flop	B55	Violet Red	Blue shade violet red
C61	Medium Yellow	Red shade yellow	B56	Peach Red	Bright violet red
C62	Leadfree Medium Yellow	Red shade yellow, leadfree	B58	Maroon Red	Dark red face and bright background
C63	Lemon Yellow	Green shade yellow	B59	Transparent Red	Violet shade red, high transparency
C64	Leadfree Lemon Yellow	Green shade yellow, leadfree	B60	Mud Yellow	Opaque mud yellow
C70	Violet	Violet with a blue cast	B61	Transoxide Yellow	Greenish golden effect on the face and dark on the flop
			B63	Organic Yellow	Golden face and yellow green flop
			B65	Leadfree Lemon Yellow	Green shape yellow
			B66	Transparent Brown	Transparent brown toner
			B70	Violet	Red blue shade violet

EASICOAT COLOURBASE'S CHARACTERISTIC TABLE E3

Item	Description	Characteristic	Item	Description	Characteristic
S10	Extra Fine Silver	Extra fine white silver	P10	White Pearl	Standard silvery white pearl
S11	Fine White Silver	White fine silver	P11	Fine white Pearl	Fine ,white pearl
S12	Medium Fine White Silver	Flake size similar to S41, white side	P30	Blue Pearl	Standard blue pearl
S20	Medium Silver	Good whiteness,coarser than S43	P31	Fine Blue Pearl	Finer than P30
S21	Medium White Silver	Flake size between S41 and S43, White side	P40	Green Pearl	Standard green pearl
S30	Coarse Silver	Coarse sparkle silver	P50	Red Pearl	Bright red pearl
S31	Extra Coarse Silver	Extra coarse sparkle silver	P51	Fine Red Pearl	Finer than P50
S40	Extra Fine Bright Silver	Extra fine sparkle silver ,strong metallic effect	P60	Yellow Pearl	Standard yellow pearl
S41	Small Bright Silver	White ,bright silver ,coarser than S11	P61	Golden Pearl	Standard golden pearl
S42	Small Sparkle Silver	Coarser than S40, strong metallic effect	P63	Golden Yellow Pearl	Bright ,yellow golden pearl
S43	Medium Bright Silver	Medium,bright silver ,good whiteness on the flop	P65	Copper Pearl	Standard copper pearl
S44	Medium Sparkle Silver	Coarser than S42, strong metallic effect	P70	Violet Pearl	Standard violet pearl
S46	Coarse Sparkle Silver	Coarser than S44, strong metallic effect	P71	Violet Red Pearl	Red face blue flop
			PX1	Crystal White Pearl	Crystal effect white pearl
			PX3	Crystal Blue Pearl	Crystal effect blue pearl
			PX4	Crystal Green Pearl	Crystal effect green pearl
			PX5	Crystal Red Pearl	Crystal effect red pearl
			PX6	Crystal Golden Pearl	Crystal effect golden pearl
			PX7	Crystal Copper Pearl	Crystal effect copper pearl