

Showell
Professional refinish system

P³
PROFIT
PERFECT
PROFESSIONAL

SHOWELL

CAR PAINT

PRODUCT INSTRUCTION

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Showell
Professional refinish system



SHOWELL PREMIUM REFINISH



PROFIT

Fast drying Time-efficiency High yield rate



PERFECT

Good Build High Gloss Perfect paint film



PROFESSIONAL

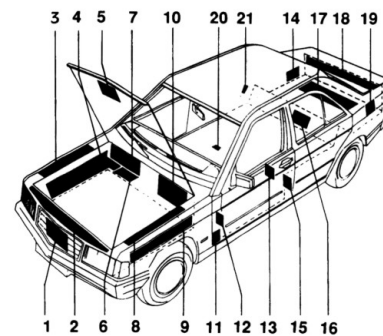
High Performance Products Professional Manufacturing Facilities



LOCATION GUIDE OF ORIGINAL COLOR CODE IN VEHICLE BODY

How to locate the color code

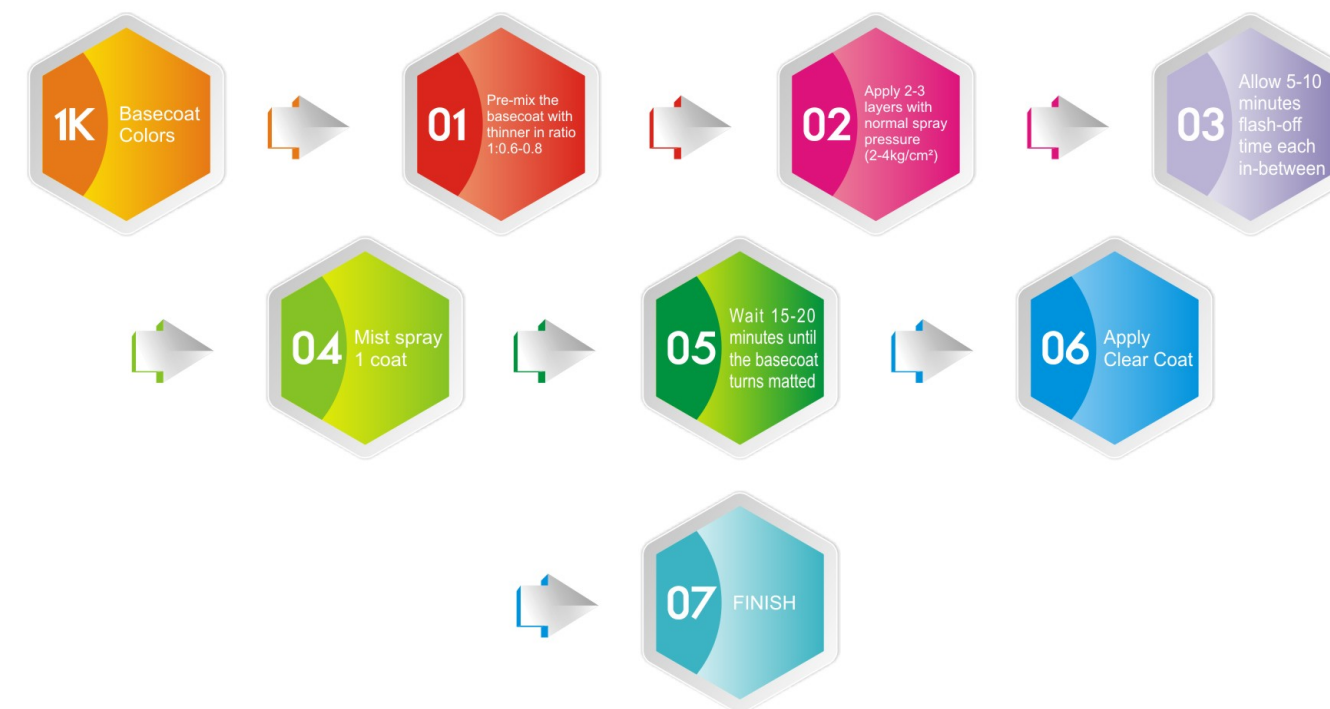
Most of the vehicle bodies have information ID cards with color code. Locations of those ID cards are different among manufactures with different car models.



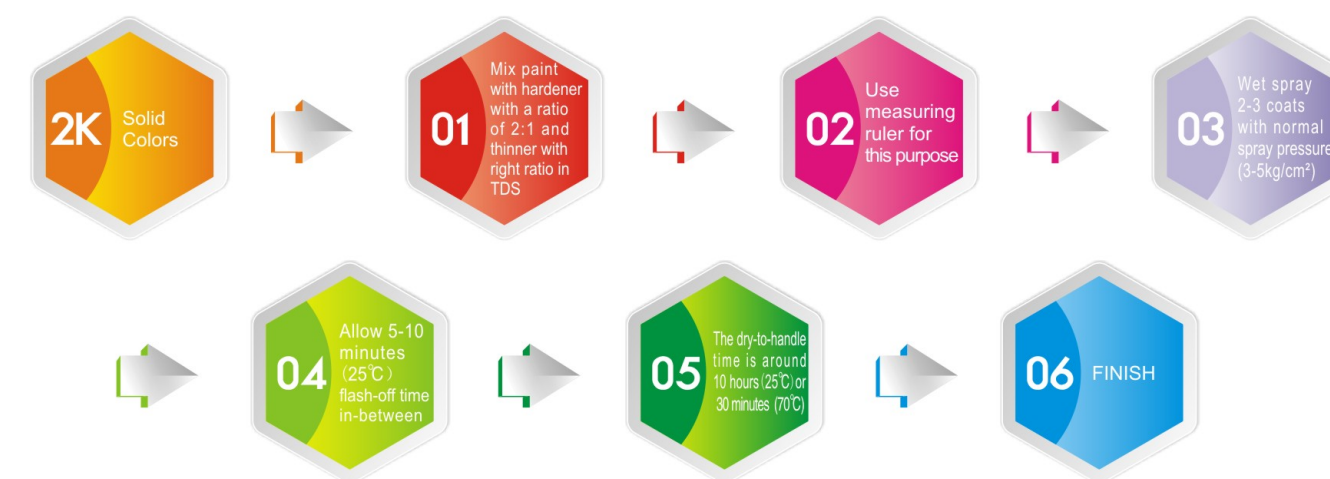
The following table shows the location of color code in vehicles:

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



2K Solid Colors Application Flow Chart

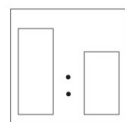
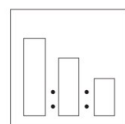
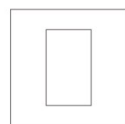




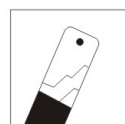
PICTOGRAPH



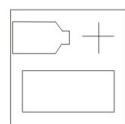
Cleaning


 Mixing ratio–
2 components

 Mixing Ratio–
3 components


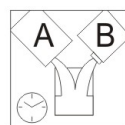
Ready for use



Use measuring rulers



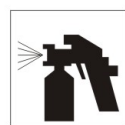
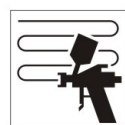
Add hardener



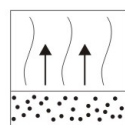
Pot Life



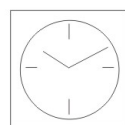
Gravity feed spray gun


 Suction feed
spray gun


No. of coats



Flash–off time



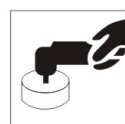
Drying time


 Dry sanding
by machine

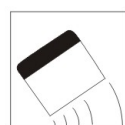

Wet sanding by hand



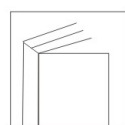
Dry sanding by hand



Polishing



Use spreader


 Refer to product
Instruction

CONTENTS

Showell

SW-2K Solid Colors	001
SW-1K Basecoat Colors	002
SW-899 High Solid Clear Coar	003
SW-877 Glamour HS Clearcoat	004
SW-822 High Velocity Clear Coat	005
SW-833 Fast Drying Clear Coat	006
SW-811 Standard Clear Coat	007
SW-8520 1K Binder, SW-8530 1K Flip Controller	008
SW-2K Hardener	009
SW-S Thinner	010
SW-8440 2K Primer Surfacer	011
SW-8352 Epoxy Primer	012
SW-8340 Plastic Primer	013
SW-8910 Degreaser	014
SW-8920 Thinner SRA	014
SW-8930 Anti-Silicon	015
SW-8940 Matting Agent	015
SW-8960 Retarder Solvent	016
SW-8980 Quick Drier	016
SW-8950 Softening Agent	017
P998 Alloy Putty	017

Showell Automotive Refinish Mixing Ratio

Showell Automotive Refinish Application Procedure







Mixing ratio here is volume ratio



SW-2K Solid Colors

Characteristic: Superior 2K topcoat solid colors with low VOC, good hardness, high gloss and build, excellent protective and covering power, long lasting bright color.

Substrates: Sanded and dried existing finished, Showell 1K or 2K primer, self substrate with isolation spray.

	Surface Cleaning:Remove wax, silicon or other contaminations with degreaser.					
	Mixing Ratio (Volume)	Solid Colors	+	Hardener	+	Thinner
	<18℃	2		1		0.2-0.6
	18–24 ℃	SW-2K		SW-8611		S-1
	25–30 ℃	SW-2K		SW-8612		S-1/S-2
	> 30 ℃	SW-2K		SW-8612		S-2/S-3
		SW-2K		SW-8613		S-3
	Pot Life at 25 ℃: SW–8611 Fast Hardener: 2Hours; SW-8612 Standard Hardener/ SW–8613 Slow Hardener: 4Hours.					
	Spray Gun Set Up	Gravity Feed	1.2–1.5mm	3–5kg/cm ²		
		Suction Feed	1.4–1.7mm	3–5kg/cm ²		
	Conventional:3–4 bar RP:2.0–2.5 bar HVLP:2.0 bar					
	Coats & Thickness	2–3 coats, 40–60um				
	Flash–Off Time	At 25 ℃, 5–10Mins between coats				
	Air–Drying Time	Allow 15–20Mins air drying time before force drying				
	Problem Solving	Wet sand small particles and runs after fully dried with P2000 sanding paper, then polish with wax.				
	Drying Time	Temperature	Dust Free	Tack Free	Dry To Handle	
		25 ℃	45Mins	1Hours	10Hours	
		70 ℃	5Mins	15Mins	30Mins	
Shelf life	2 years in original sealed can at cool and dry place at 20℃					
Packaging	1L, 3.75L					




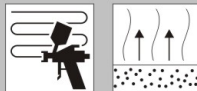
Note:

1. Remains of water 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.
2. At temperature lower than 15℃, air-dry at ambient temperature is not recommended. Allow a full bake at 60℃.
3. At ambient temperature higher than 30℃, add Retarder Solvent into thinner to avoid blushing. Details please refer to the technical data sheet of Retarder Solvent.
4. In the event of fisheyes during application, add 0.5-1% Anti Silicon in the paint remained and re-spray the affected area.
5. 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.
6. The products mixed with hardener should be used up soon and can not restore for future use.
7. Clean equipments immediately with solvent after application.

SW-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 finished, 1K or 2K primer, self substrate with isolation spray.

	Surface Cleaning:Remove wax, silicon or other contaminations with degreaser .															
	Mixing Ratio (Volume) <15℃ 15–30 ℃ > 30 ℃	<table><tr><th>Basecoat</th></tr><tr><td>1</td></tr><tr><td>SW-1K</td></tr><tr><td>SW-1K</td></tr><tr><td>SW-1K</td></tr></table>	Basecoat	1	SW-1K	SW-1K	SW-1K	+	<table><tr><th>Thinner</th></tr><tr><td>0.6–0.8</td></tr><tr><td>S–5</td></tr><tr><td>S–1</td></tr><tr><td>S–2</td></tr></table>	Thinner	0.6–0.8	S–5	S–1	S–2		
Basecoat																
1																
SW-1K																
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Packaging	1L, 3.75L															

Note:





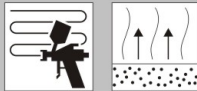

1. If the existing finish is not compatible, 2K primer surfacer should be used as a sealing layer before applying the basecoat otherwise there may be problems such as lifting, peeling, blistering, flooding, etc.
2. At temperature over 30℃ or in high humidity, it is recommended to use SW-8960 Retarder Solvent to avoid mottling.
3. Because of the high transparency of metallic basecoat, the primer surfacer should be in consistent color and flat without any sand scratches, seediness, or unevenness so as to prevent defects of mottling, poor metallic effect, etc.
4. To avoid problems of mottling or poor adhesion, the metallic paint film should not be thicker than 25um.
5. Better effect could be achieved if the extra silver powder could be removed with tack rag after the flash-off of every layer.



SW-899 High Solid Clear Coat

Characteristic:High density, low VOC, high gloss and build, hard surface, long lasting bright gloss, excellent weathering and chemical resistance.

Substrates:1K Basecoat

	Surface Cleaning:Clean the dust and particles with tack cloth.																							
	Mixing Ratio (Volume)	Clear Coat	+	Hardener	+	Thinner																		
	<18℃	2		1		0-0.2																		
	18–24 ℃	SW-899		SW-8631		S-1																		
	25–30 ℃	SW-899		SW-8632		S-1/S-2																		
	> 30 ℃	SW-899		SW-8632		S-2/S-3																		
		SW-899		SW-8633		S-3																		
	SW-8631 High Solid Fast Drying Hardener: 2 hours; SW-8632 High Solid Standard Hardener or SW-8633 High Solid Slow Drying Hardener: 4 hours																							
	<table><tr><td rowspan="2">Spray Gun Set Up</td><td>Gravity Feed</td><td>1.2–1.5mm</td><td>3–5kg/cm²</td></tr><tr><td>Suction Feed</td><td>1.4–1.7mm</td><td>3–5kg/cm²</td></tr><tr><td colspan="4">Conventional:3–4 bar RP:2.0–2.5 bar HVLP:2.0 bar</td></tr></table>						Spray Gun Set Up	Gravity Feed	1.2–1.5mm	3–5kg/cm ²	Suction Feed	1.4–1.7mm	3–5kg/cm ²	Conventional:3–4 bar RP:2.0–2.5 bar HVLP:2.0 bar										
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	70 ℃	5Mins	30Mins	20Mins																				
Shelf life	2 years in original sealed can at cool and dry place at 20℃																							
Packaging	4L																							





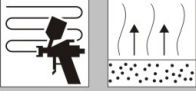

Note:

1. When ambient temperature is lower than 15℃, air-dry is not recommended. Allow a full bake at 60℃.
2. At ambient temperature higher than 30℃, add Retarder Solvent into thinner to avoid blushing. Details please refer to the technical data sheet of Retarder Solvent.
3. In the events of fisheyes during application, add 0.5-1% Anti Silicon in the paint remained and respray the affected area.
4. In the overspray area, apply directly Thinner SRA to achieve an invisible transition. Details please refer to the technical data sheet of Thinner SRA.
5. When mixed with hardener, the products should be used up soon and can not restore for future use.
6. Clean equipments immediately with solvent after application.

SW-877Glamour Clearcoat

Characteristic:High Performance double component clear coat, high gloss, good build, strong chemical resistant, excellent color and gloss protective power, suitable for overall spraying and refinish.

Substrates:1K Basecoat

	Surface Cleaning:Clean the dust and particles with tack cloth.																	
	Mixing Ratio (Volume) <18℃ 18–24 ℃ 25–30 ℃ > 30 ℃	Clear Coat 2 SW-877 SW-877 SW-877	+	Hardener 1 SW-8611 SW-8612 SW-8612 SW-8613	+	Thinner 0-0.2 S-1 S-1/S-2 S-2/S-3 S-3												
	Pot Life at 25 ℃ : 3-4 hours																	
	<table><tr><td rowspan="2">Spray Gun Set Up</td><td>Gravity Feed</td><td>1.2–1.5mm</td><td>3–5kg/cm²</td></tr><tr><td>Suction Feed</td><td>1.4–1.7mm</td><td>3–5kg/cm²</td></tr><tr><td colspan="4">Conventional:3–4 bar RP:2.0–2.5 bar HVLP:2.0 bar</td></tr></table>					Spray Gun Set Up	Gravity Feed	1.2–1.5mm	3–5kg/cm ²	Suction Feed	1.4–1.7mm	3–5kg/cm ²	Conventional:3–4 bar RP:2.0–2.5 bar HVLP:2.0 bar					
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Drying Time	Temperature	Dust Free	Tack Free	Dry To Handle														
	25 ℃	25Mins	8Hours	10Hours														
	60 ℃	----	30Mins	40Mins														
Shelf life	2 years in original sealed can at cool and dry place at 20℃																	
Packaging	4L																	

Note:





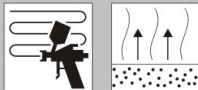

1. When ambient temperature is lower than 15℃, air-dry is not recommended. Allow a full bake at 60℃.
2. At ambient temperature higher than 30℃, add Retarder Solvent into thinner to avoid blushing. Details please refer to the technical data sheet of Retarder Solvent.
3. In the events of fisheyes during application, add 0.5-1% Anti Silicon in the paint remained and respray the affected area.
4. In the overspray area, apply directly Thinner SRA to achieve an invisible transition. Details please refer to the technical data sheet of Thinner SRA.
5. When mixed with hardener, the products should be used up soon and can not restore for future use.
6. Clean equipments immediately with solvent after application.



SW-822 Extra Fast Drying Clearcoat

Characteristic:Acrylic polyol modified resin, double component extra fast drying clearcoat with hard build. Easy to apply. suitable for spot fast repair.

Substrates:1K Basecoat

	Surface Cleaning : Clean the dust and particles with tack cloth.										
	Mixing Ratio (Volume)	<table><tr><td>Clear Coat</td><td rowspan="3">+</td><td>Hardener</td></tr><tr><td>2</td><td>1</td></tr><tr><td>SW-822</td><td>SW-8621</td></tr></table>	Clear Coat	+	Hardener	2	1	SW-822	SW-8621		
Clear Coat	+	Hardener									
2		1									
SW-822		SW-8621									
	Pot Life at 25 °C : SW-8621 Extra Fast Drying Clearcoat: 1 hour										
	Spray Gun Set Up: Gravity Feed 1.3–1.4mm 1.6–2.0 bar										
	Coats & Thickness	2 coats, 40um									
	Flash-Off Time	Do not need flash-off time									
	Air-Drying Time	Allow 15–20 mins air drying time before force drying									
	Drying Time	<table><tr><td>Temperature</td><td>Dust Free</td></tr><tr><td>10 °C</td><td>25–30 Mins</td></tr><tr><td>15 °C</td><td>12–15 Mins</td></tr><tr><td>25 °C</td><td>8–10 Mins</td></tr></table>	Temperature	Dust Free	10 °C	25–30 Mins	15 °C	12–15 Mins	25 °C	8–10 Mins	
Temperature	Dust Free										
10 °C	25–30 Mins										
15 °C	12–15 Mins										
25 °C	8–10 Mins										
Re-application	If there are particles and 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										


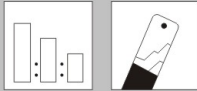



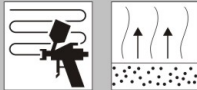

Note:

1. At the temperature lower than 10°C, air-dry at ambient temperature is not recommended. Allow a full bake at 60°C.
2. Suitable for spot fast repairing. If needed excellent gloss and paint film effect, HS clearcoat is recommended.
3. In the event of flasheyes during application, add 0.5-1% Anti Silicon in the paint remained and re-spray the affected area.
4. 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.
5. The clearcoat mixed with hardener should be used up soon and can not restore for future use.
6. Clean equipments immediately with solvent after application.

SW-833 Extra Drying Clear Coat

Characteristic:Two-pack extra fast drying medium and high solid clear coat, high gloss and hardness, easy application, suitable for overall refinish.

Substrates:1K Basecoat

	Surface Cleaning:Remove wax, silicon or other contaminations with degreaser.																			
	Mixing Ratio (Volume) ≤25℃	<table><tr><td>Clear Coat</td><td rowspan="3">+</td></tr><tr><td>2</td></tr><tr><td>SW-833</td></tr></table>	Clear Coat	+	2	SW-833	<table><tr><td>Hardener</td><td rowspan="3">+</td></tr><tr><td>1</td></tr><tr><td>SW-8600</td></tr></table>	Hardener	+	1	SW-8600	<table><tr><td>Thinner</td><td rowspan="3"></td></tr><tr><td>0.1-0.3</td></tr><tr><td>S-1</td></tr></table>	Thinner		0.1-0.3	S-1				
Clear Coat	+																			
2																				
SW-833																				
Hardener	+																			
1																				
SW-8600																				
Thinner																				
0.1-0.3																				
S-1																				
	Pot Life at 25 ℃: SW-8600 Extra Fast Drying Hardener: 2Hours																			
	Flash-off Time: Continuous wet-spray without flash-off time between coats is better for painting leveling. Allow 10Mins air drying time before force drying.																			
	<table><tr><td rowspan="2">Spray Gun Set Up</td><td>Gravity Feed</td><td>1.2-1.5mm</td><td>3-5kg/cm²</td></tr><tr><td>Suction Feed</td><td>1.4-1.7mm</td><td>3-5kg/cm²</td></tr><tr><td colspan="4">Conventional:3-4 bar RP:2.0-2.5 bar HVLP:2.0 bar</td></tr></table>	Spray Gun Set Up	Gravity Feed	1.2-1.5mm	3-5kg/cm ²	Suction Feed	1.4-1.7mm	3-5kg/cm ²	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																				
	<table><tr><td>Coats & Thickness</td><td colspan="3">2-3 coats, 40-60um</td></tr><tr><td>Flash-Off Time</td><td colspan="3">At 25 ℃, 5-10Mins between coats</td></tr><tr><td>Air-Drying Time</td><td colspan="3">Allow 15-20Mins air drying time before force drying</td></tr><tr><td>Problem Solving</td><td colspan="3">Wet sand small particles and runs after fully dried with P2000 sanding paper, then polish with wax.</td></tr></table>	Coats & Thickness	2-3 coats, 40-60um			Flash-Off Time	At 25 ℃, 5-10Mins between coats			Air-Drying Time	Allow 15-20Mins air drying time before force drying			Problem Solving	Wet sand small particles and runs after fully dried with P2000 sanding paper, then polish with wax.					
Coats & Thickness	2-3 coats, 40-60um																			
Flash-Off Time	At 25 ℃, 5-10Mins between coats																			
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Problem Solving	Wet sand small particles and runs after fully dried with P2000 sanding paper, then polish with wax.																			
	<table><tr><td rowspan="3">Drying Time</td><td>Temperature</td><td>Tack Free</td><td>Dry To Handle</td></tr><tr><td>25 ℃</td><td>15Hours</td><td>3Hours</td></tr><tr><td>70 ℃</td><td>5Mins</td><td>15Mins</td></tr></table>	Drying Time	Temperature	Tack Free	Dry To Handle	25 ℃	15Hours	3Hours	70 ℃	5Mins	15Mins									
Drying Time	Temperature		Tack Free	Dry To Handle																
	25 ℃		15Hours	3Hours																
	70 ℃	5Mins	15Mins																	
Shelf life	2 years in original sealed can at cool and dry place at 20℃																			
Packaging	1L																			

Note:







1. When ambient temperature is lower than 10°C, air-dry is not recommended. Allow a full bake at 60°C.
2. At ambient temperature higher than 25°C, add Retarder Solvent into thinner to avoid blushing. Details please refer to the technical data sheet of Retarder Solvent.
3. It is suitable for small area and overall spraying, but if pursuing excellent paint film effect, high solid clear coat is recommended.
4. In the events of fisheyes during application, add 0.5-1% Anti Silicon in the paint remained and respray the affected area.
5. In the overspray area, apply directly Thinner SRA to achieve an invisible transition. Details please refer to the technical data sheet of Thinner SRA.
6. When mixed with hardener, the products should be used up soon and can not restore for future use.
7. Clean equipments immediately with solvent after application.



SW-811 Standard Clear Coat

Characteristic:High Performance double component mirror effect clear coat, high gloss, good build, strong chemical resistant, excellent color and gloss protective power.

Substrates:1K Basecoat

	Surface Cleaning:Clean the dust and particles with tack cloth.																			
	Mixing Ratio (Volume)	Clear Coat	+	Hardener	+	Thinner														
	<18℃	2		1		0.5														
	18–24 ℃	SW-811		SW-8601		S-1														
	25–30 ℃	SW-811		SW-8602		S-1/S-2														
	> 30 ℃	SW-811		SW-8603		S-2/S-3														
						S-3														
	Pot Life at 25 ℃: SW–8601 Fast Hardener: 2Hours; SW–8602 Standard Hardener/ SW–8603 Slow Hardener: 3Hours.																			
	<table><tr><td rowspan="2">Spray Gun Set Up</td><td>Gravity Feed</td><td>1.2–1.5mm</td><td>3–5kg/cm²</td></tr><tr><td>Suction Feed</td><td>1.4–1.7mm</td><td>3–5kg/cm²</td></tr><tr><td colspan="4">Conventional:3–4 bar RP:2.0–2.5 bar HVLP:2.0 bar</td></tr></table>					Spray Gun Set Up	Gravity Feed	1.2–1.5mm	3–5kg/cm ²	Suction Feed	1.4–1.7mm	3–5kg/cm ²	Conventional:3–4 bar RP:2.0–2.5 bar HVLP:2.0 bar							
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Drying Time	Temperature	Dust Free	Tack Free	Dry To Handle																
	25 ℃	30Mins	1–2Hours	8Hours																
	70 ℃	5Mins	10Mins	20Mins																
Shelf life	2 years in original sealed can at cool and dry place at 20℃																			
Packaging	1L Or 4L																			

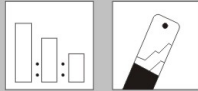
Note:

- 1.When ambient temperature is lower than 15℃, air-dry is not recommended. Allow a full bake at 60℃.
2. At ambient temperature higher than 30℃ , add Retarder Solvent into thinner to avoid blushing. Details please refer to the technical data sheet of Retarder Solvent.
3. In the events of fisheyes during application, add 0.5-1% Anti Silicon in the paint remained and respray the affected area.
4. In the overspray area, apply directly Thinner SRA to achieve an invisible transition. Details please refer to the technical data sheet of Thinner SRA.
5. When mixed with hardener, the products should be used up soon and can not restore for future use.
6. Clean equipments immediately with solvent after application.

SW-8520 1K Binder, SW-8530 1K Flip Controller

Characteristic:Specially developed for SW-1K metallic basecoat. Able to speed up air drying time. Help the orientation of silver & pearl particles. Improve the application property.

Match With:SW-1K Basecoat

SW-8520 1K Binder	Speed up air drying time, help the orientation of silver & pearl particles, and improve the application property.
SW-8530 1K Flip Controller	Control silver arranging. The more binder is used, the sparser is the orientation of silver arranging, with darker face and lighter sides.
 Mixing Ratio (Volume)	1.Addition of SW-8520 to SW-1K metallic basecoat is 15-40% of total volume. 2.In 3-stage pearl colors, add 50-70% SW-8520 into the pearl colors accordingly. 3.For basecoat colors with low opacity, such as red pearl colors, addition of SW-8520 should be less than 15% so as not to affect the hiding power of the paint. 4.20% of SW-8530 can be used to lighten the side tone while having little effect on the face of the color. 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℃
Packaging	SW-8520 1K Binder: 3.75L ; SW-8530 Flip Controller: 1L



SW-2K Hardener

A Series of yellow resistant hardener, specially designed for SW 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:SW-2K Solid Colors, SW-811 Standard Clear Coat, SW-877 Glamour Clear Coat, SW-833 Extra Fast Drying Clear Coat.

Characteristic:

SW-8601 Fast Drying Hardener	Medium solid fast drying hardener, suitable for spot repair and low temperature application .
SW-8602 Standard Hardener	Medium solid standard drying hardener, suitable for spot repair and overall refinish at 18-30°C.
SW-8603 Slow Drying Hardener	Medium solid slow drying hardener, suitable for spot repair and overall refinish above 30°C.
SW-8611 Fast Drying Hardener	High solid Fast Drying hardener, suitable for spot repair and low temperature application below 18°C
SW-8612 HS standard Hardener	High solid standard hardener, suitable for spot repair and overall refinish at 18-30°C.
SW-8613 Slow Drying Hardener	High solid slow drying hardener, suitable for spot repair and overall refinish above 30°C.
SW-8600 Extra Fast Drying Hardener	Extra fast drying hardener, suitable for SW-833 Extra Fast Drying Clear Coat.
Shelf life	2 years in original sealed can at cool and dry place at 20°C
Packaging	1L

Note:

- 1.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.
- 2.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.
- 3.Please wear proper personal protective equipments during application, such as gas mask and so on, as it is irritating to respiratory system.

SW-S Thinner

High quality thinner, specially developed for SW 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:

S-5 Fast Drying Thinner	1K basecoat only, with very fast evaporation speed, suitable for spot repair or application below 15°C.
S-1 Standard Drying Thinner	Standard thinner for 1K basecoat and 2K products, with medium evaporation speed, suitable for spot repair or application at 15-25°C.
S-2 Slow Drying Thinner	For 1K basecoat and 2K products, with slow evaporation speed, suitable for spot repair or overall refinishing or application at 25-30°C.
S-3 Extra Slow Drying Thinner	2K products only, with very slow evaporation speed, suitable for overall refinishing, large area application or application over 30°C.
Notes	If temperature and humidity is too high, we suggest to add 10-30% SW-8960 Retarder Solvent
Shelf life	2 years in original sealed can at cool and dry place at 20°C
Packaging	1L or 4L






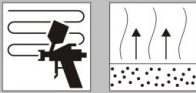


SW-8440 2K Primer Surfacer

Characteristic :Multi-purpose double pack primer surfacer . With strong filling power and fine adhesion between coats.

Has excellent flexibility and impact resistant which can increase gloss and build topcoat.

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

Characteristic:




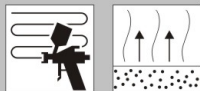



	Surface Cleaning:Remove wax, silicon and other contaminations with degreaser.																														
	<table><tr><td>Mixing Ratio (Weight)</td><td>2K Primer</td><td>+</td><td>Hardener</td><td>+</td><td>Thinner</td></tr><tr><td>(Volume)</td><td>4</td><td></td><td>1</td><td></td><td>1-1.5</td></tr><tr><td><25℃</td><td>3</td><td></td><td>1</td><td></td><td>1-1.5</td></tr><tr><td>> 25 ℃</td><td>SW-8440</td><td></td><td>SW-8641</td><td></td><td>S-1</td></tr><tr><td></td><td>SW-8440</td><td></td><td>SW-8641</td><td></td><td>S-2/S-3</td></tr></table>	Mixing Ratio (Weight)	2K Primer	+	Hardener	+	Thinner	(Volume)	4		1		1-1.5	<25℃	3		1		1-1.5	> 25 ℃	SW-8440		SW-8641		S-1		SW-8440		SW-8641		S-2/S-3
Mixing Ratio (Weight)	2K Primer	+	Hardener	+	Thinner																										
(Volume)	4		1		1-1.5																										
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> 25 ℃	SW-8440		SW-8641		S-1																										
	SW-8440		SW-8641		S-2/S-3																										
	Pot Life at 25 ℃: SW-8641 Primer Fast Hardener: 45Mins; SW-8642 Primer Standard Hardener: 1Hour.																														
	Coats & Thickness:2-3 coats, 30-50um Flash-off time:25 ℃, 5-10 Mins																														
	<table><tr><td>Spray Gun</td><td>Gravity Feed</td><td>1.4-1.6mm</td><td>3-5kg/cm²</td></tr><tr><td>Set Up</td><td>Suction Feed</td><td>1.7-1.8mm</td><td>3-5kg/cm²</td></tr><tr><td>Conventional:</td><td>1.5-2.5bar</td><td>RP:0.5-2.0bar</td><td>HVLP:0.7-2.0bar</td></tr></table>	Spray Gun	Gravity Feed	1.4-1.6mm	3-5kg/cm²	Set Up	Suction Feed	1.7-1.8mm	3-5kg/cm²	Conventional:	1.5-2.5bar	RP:0.5-2.0bar	HVLP:0.7-2.0bar																		
Spray Gun	Gravity Feed	1.4-1.6mm	3-5kg/cm²																												
Set Up	Suction Feed	1.7-1.8mm	3-5kg/cm²																												
Conventional:	1.5-2.5bar	RP:0.5-2.0bar	HVLP:0.7-2.0bar																												
	Drying Time:25 ℃, 2-3Hours; 70 ℃, 45Mins. Dry Sanding: 400#-600# Wet Sanding:800#-1000#																														
Shelf life	2 years in original sealed can at cool and dry place at 20℃																														
Packaging	SW-8440:4kg; SW-8641:1L; SW-8642:1L																														

SW-8352 Epoxy Primer

Characteristic:Excellent rust-proofing. Excellent adhesion to steel, aluminium and galvanized steel.

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

Characteristic:

	Surface Cleaning:Remove wax, silicon and other contaminations with degreaser.															
	<table><tr><td rowspan="4">Mixing Ratio (Weight) (Volume)</td><td>Epoxy Primer</td><td rowspan="4">+</td><td>Hardener</td><td rowspan="4">+</td><td>Thinner</td></tr><tr><td>5</td><td>1</td><td>1-1.5</td></tr><tr><td>3.5</td><td>1</td><td>1</td></tr><tr><td>SW-8352</td><td>SW-8652</td><td>SW-8750</td></tr></table>	Mixing Ratio (Weight) (Volume)	Epoxy Primer	+	Hardener	+	Thinner	5	1	1-1.5	3.5	1	1	SW-8352	SW-8652	SW-8750
Mixing Ratio (Weight) (Volume)	Epoxy Primer		+		Hardener		+	Thinner								
	5				1			1-1.5								
	3.5				1			1								
	SW-8352	SW-8652		SW-8750												
	Pot Life at 20 °C: 4-6Hours															
	Coats & Thickness :2-3 coats, 40-60um Flash-Off Time :At 20 °C, 5-10Mins between coats															
	<table><tr><td rowspan="2">Spray Gun Set Up</td><td>Gravity Feed</td><td>1.4-1.8mm</td><td>3-5kg/cm²</td></tr><tr><td>Suction Feed</td><td>1.7-2.0mm</td><td>3-5kg/cm²</td></tr><tr><td colspan="4">Conventional:3-4bar RP:2.0-2.5bar HVLP:2.0bar</td></tr></table>	Spray Gun Set Up	Gravity Feed	1.4-1.8mm	3-5kg/cm²	Suction Feed	1.7-2.0mm	3-5kg/cm²	Conventional:3-4bar RP:2.0-2.5bar HVLP:2.0bar							
Spray Gun Set Up	Gravity Feed		1.4-1.8mm	3-5kg/cm²												
	Suction Feed	1.7-2.0mm	3-5kg/cm²													
Conventional:3-4bar RP:2.0-2.5bar HVLP:2.0bar																
	Drying Time:20 °C, 18-26Hours; 60 °C, 60-80Mins.															
	Dry Sanding : 240#-400# Wet Sanding: 600#-800#															
Shelf life	2 years in original sealed can at cool and dry place at 20°C															
Packaging	SW-8352:5kg; SW-8652:1L; SW-8750:1L															

Note:

- For oxidated iron and cast iron, shot blasted sa 2.5 class with roughness of 30-75 um, or acid wash oxidated parts, then get rid of rust.
- It is recommended to bake at 60-70℃ for 30 minutes when temperature is below 10℃ for better curing of paint film.
- Choose right hardener and thinner to avoid poor curing of paint film.



SW-8340 Plastic Primer

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

Substrates	PP plastic parts			
Surface Cleaning	Sanding with P400-P600, Remove wax, silicon or other contaminations with degreaser.			
No. of Coats	2 coats, total 4-5um			
Flash-off Time	5-10minutes at 25°C			
Spray Guns & Pressure	Gravity Feed 1.4-1.7mm	1.2-1.5mm 3-5kg/	3-5kg/ 1.4-1.7mm	3-5kg/cmSiphon Feed 3-5kg/cm ²
Time to Topcoat	10-15minutes at 25°C			
Shelf life	2 years in original sealed can at cool and dry place at 20°C			
Packaging	1L			


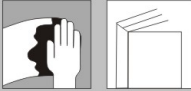
Note:

- 1.The product is ready for use.
- 2.It is recommended not to spray thickly to avoid peeling off.
- 3.Test is recommended before application due to the variety of plastic parts.

SW-8910 Degreaser

Characteristic:Able to remove grease, oil and other surface contaminations to avoid paint film defects.

Substrates:Existing finishes, primer, putty and metal

	Mixing Ratio: Ready for use .
	Usage: 1.Clean the substrate with water tore move 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.
Shelf life	2 years in original sealed can at cool and dry place at 20°C
Packaging	SW-8440:4kg; SW-8641:1L; SW-8642:1L



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.
- 3.Specialized and professional degreaser is recommended.

SW-8920 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.

	Mixing Ratio :The product is ready for use. Can mix with the paint remained in the spray gun in the ratio of 1: 1
	Appalachian Method: Spray lightly one coat over the overspray area with Thinner SRA right after the finish. Second coat in 20 seconds. Recommended pressure is 2kg/cm ²
Shelf life	2 years in original sealed can at cool and dry place at 20°C
Packaging	1L



SW-8930 Anti-Silicon

Characteristic: Additive for auto paint and topcoat. Able to remove fisheyes or craterings on the paint film.

Match With: 2K solid colors or clear coat.

	Mixing Ratio: Paint ready to use: SW-8930 Anti-Silicon= 1L: 0.5-2 tin cap(about 4-15g)
	Application Method :Wet spray one coat of paint mixed with Anti-Silicon on the fisheye affected paint film. Recommended spray pressure 3-5kg/cm ²
Shelf life	2 years in original sealed can at cool and dry place at 20°C
Packaging	1L




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 fully dried. Respray with paint mixed with Anti Silicon.

SW-8940 Matting Agent

Characteristic: Can be used to reduce the brightness of the paint film. Good matting ability with smooth paint film. Suitable for 1K and 2K system.

Match with: SW-2k topcoat, clear coat and 1K basecoat

<div><div></div><div></div></div>	<div>1K Basecoat:SW-8940 Matting Agent=(85-70):(15-30)</div> <div>2K Topcoat</div> <div><table><tr><td>Effect</td><td>+</td><td>SW-2K</td><td>+</td><td>SW-8940</td><td>+</td><td>SW Hardener</td></tr><tr><td>All Matte</td><td></td><td>30Parts</td><td></td><td>70Parts</td><td></td><td>15Parts</td></tr><tr><td>Half Matte(Egg Shell)</td><td></td><td>50Parts</td><td></td><td>50Parts</td><td></td><td>25Parts</td></tr><tr><td>Half Bright</td><td></td><td>70Parts</td><td></td><td>30Parts</td><td></td><td>35Parts</td></tr></table></div>	Effect	+	SW-2K	+	SW-8940	+	SW Hardener	All Matte		30Parts		70Parts		15Parts	Half Matte(Egg Shell)		50Parts		50Parts		25Parts	Half Bright		70Parts		30Parts		35Parts
Effect	+	SW-2K	+	SW-8940	+	SW Hardener																							
All Matte		30Parts		70Parts		15Parts																							
Half Matte(Egg Shell)		50Parts		50Parts		25Parts																							
Half Bright		70Parts		30Parts		35Parts																							
<div></div>	Application Method: Refer to the technical data sheet of the matching paint																												
Shelf life	2 years in original sealed can at cool and dry place at 20°C																												
Packaging	1L																												

Note:

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.

SW-8960 Retarder Solvent

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

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

	Mixing Ratio : Add 10-30% retarder solvent into S-2 or S-3 thinner when the ambient temperature is over 30°C
	Please refer to the technical data sheet of the matching products.
Shelf life	2 years in original sealed can at cool and dry place at 20°C
Packaging	SW-8440:4kg; SW-8641:1L; SW-8642:1L

SW-8980 Quick Drier

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

	1. At 10-15°C, and 5-6g SW-8980 Quick Drier into 1L ready mixed paint. 2. At 0-10°C, and 5-6g SW-8980 Quick Drier into 1L ready mixed paint. 3. Below 0°C, and 10-15g SW-8980 Quick Drier into 1L ready mixed paint.
Shelf life	2 years in original sealed can at cool and dry place at 20°C
Packaging	1L

Note:

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



SW-8950 Softening Agent

Characteristic:An additive for soft substrate. It mainly improves flexibility of primer and topcoat so as to adapt to the deformation of soft substrate and avoid the paint burst.

Substrates:2K solid colors, clear coat and 1K basecoat.

	1. Add 10-30% softening agent into 2k solid color according to flexibility of substrate. Then add hardener and thinner in suggested ratio. 2. When it is necessary, add softening agent less than 10% into 1K metallic color. Then add thinner before spraying.
Shelf life	2 years in original sealed can at cool and dry place at 20°C
Packaging	1L

P998 Alloy Putty

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 steel, galvanized and aluminium steel, epoxy primer.

	Surface Cleaning:Remove wax ,silicon and other contamination with degreaser
	Mixing ratio:putty: hardener=100:2 (weight) Mixing time:2-3 mins(25°C) Application Tool: Putty knife, soft rubber or plastic spreader.
	Dry to Sand: At 25° C, 15–25 minutes.
	Dry sanding with P120-P240

Note:

- 1.Stir well before use. Do not restore excess materials to can.
- 2.Mix with hardener by right ratio. Blend them well to avoid cracking or poor curing.
- 3.The putty hardener is flammable, explosive and irritating to skin. Avoid contact with skin.
- 4.Spread a thin coat once on the surface. Deep repair area better spread with several thin coats.
- 5.Do not apply topcoat on putty directly to avoid loss of gloss of topcoat.

Showell Automotive Refinish Mixing Ratio

Products	Hardener Ratio	Thinner Ratio	Coats & Thickness	Pot-life	Drying time	Dry sanding	Wet sanding	Products procedure
SW-8352 Epoxy Primer	SW-8650 Epoxy Hardener	SW-8750 Epoxy Thinner	Weight:100:20:20-30 Volume:3.5:1:1					
P998 Alloy Putty	Hardener		Weight:100:2					
SW-8440 Primer Surfacer	SW-8641 Primer Fast Hardener SW-8642 Primer Standard Hardener	S-1 Standard Thinner S-2 Slow Drying Thinner S-3 Extra Slow Drying Thinner	Weight:100:25:25-40 Volume:3.1:1:1.5					
SW-2K Solid Colors	SW-8611 Fast Drying Hardener SW-8612 Standard Hardener SW-8613 Slow Drying Hardener	S-1 Standard Thinner S-2 Slow Drying Thinner S-3 Extra Slow Drying Thinner	2:1:0.2-0.6					
SW-1K Basecoat Colors	SW-8601 Fast Drying Hardener SW-8602 Standard Hardener SW-8603 Slow Drying Hardener	S-1 Standard Thinner S-2 Slow Drying Thinner S-3 Extra Slow Drying Thinner	1:0.6-0.8					
SW-811 Standard Clear Coat	SW-8601 Fast Drying Hardener SW-8602 Standard Hardener SW-8603 Slow Drying Hardener	S-1 Standard Thinner S-2 Slow Drying Thinner S-3 Extra Slow Drying Thinner	2:1:0-0.2					
SW-866 Glamour Clear Coat	SW-8611 Fast Drying Hardener SW-8612 Standard Hardener SW-8613 Slow Drying Hardener	S-1 Standard Thinner S-2 Slow Drying Thinner S-3 Extra Slow Drying Thinner	2:1:0.2-0.4					
SW-833 Extra Fast Drying Clear Coat	SW-8600 Extra Fast Drying Hardener	S-1 Standard Thinner	2:1:0.1-0.3					
2-3 coats 40-60 μm	25°C 4-6 hours	16-20 hours 20°C 8-10 hours 30°C 40-50 hours 70°C	240#-400#	600#-800#	P998 Alloy Putty /SW-8440 Primer Surfacer /topcoats			
2-3 coats 40-60 μm	25°C 2-3 mins	15-25 mins 25°C	P120-240		SW-8440 Primer surfacer			
2-3 coats Total 30-40 μm	25°C SW-8641 Primer Surfacer Fast Hardener:45 mins SW-8642 Primer Surfacer Standard Hardener:1 hours	2-3 hours 25°C 45 mins 70°C	400#-600#	800#-1000#	Topcoats			
2-3 coats 40-60 μm	25°C SW-8641 Primer Surfacer Fast Hardener:2 hours SW-8642 Primer Surfacer Standard Hardener:4 hours	7 days 25°C 60 mins 70°C						
2-3 coats Total 15-25 μm	25°C SW-8601 Fast Drying Hardener:3 hours SW-8602 Standard Hardener:3 hours SW-8603 Slow Drying Hardener:3 hours	7 days 25°C 60 mins 70°C			SW-811 Standard Clear Coat /SW-866 Glamour HS Clear Coat			
2-3 coats Total 40-60 μm	25°C SW-8611 Fast Drying Hardener:2 hours SW-8612 Standard Hardener:2 hours SW-8613 Slow Drying Hardener:4 hours	7 days 25°C 60 mins 70°C						
2-3 coats Total 40-60 μm	25°C SW-8600 Extra Fast Drying Hardener:2 hours	6 days 25°C 60 mins 70°C						

Notes: Normally, if there is no specific instruction, the mixing ratio is by volume. Before usage, please refer to the TDS and MSDS.



Showell Automotive Refinish Application Procedure



1. Clean / Check / Mask
Wet sand with P2000 grit sandpaper; degrease, and check the substrate thoroughly with degreaser, and check the damaged panel to estimate the extent of damage and the type of existing coating. Mask the adjacent area.



2. Sand And Featheredge
Use 120 grit sandpaper to sand out the damaged paint film and featheredge. The width of the feather edge should be no less than 3 cm.



3. Clean Surface
Clean the substrate thoroughly by degreaser.



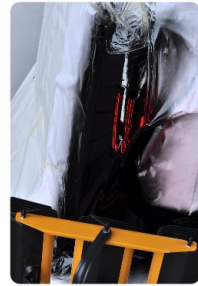
4. Apply Epoxy Primer
Epoxy primer mixing with its customized hardener enhances adhesive and anti-corrosive abilities. Epoxy primer will make performance better. After drying, dry sand with P240/P320 grit sandpaper.



5. Fill / Sand Polyester Putty
Apply polyester putty to the damaged area. After drying, dry sand and smooth the putty layer with P600/P1200P180. Then, wet sand the original paint film around with P240 grit sandpaper.



13. Polish
Wet sand with P2000 grit sandpaper; Compound and polish.



12. Dry Clear Coat
After sanding with P180 grit sandpaper, and then choose either air-drying or force drying.



11. Apply Clear Coat
Mix and apply clear coat. After drying, two coats; allow 5-10 minutes flash-off time between coats.



10. Apply Basecoat
Mix and apply basecoat. After drying, spray next coat after its previous coat turned matte (Total: 2-3 coats); allow 10-15 minutes flash-off time before applying clearcoat.



9. Dust / Clean / Mask
Clean the substrate thoroughly by degreaser, and backward mask the undamaged area nearby with paper.



8. Sand Primer Surfacer Smooth
Dry according to the technical requirement. With primer surfacer, dry sand with P600-P800 grit sandpaper, wet sand the edge of the damaged area by hand.

A
FAST EPOXY PRIMER

 8352 + 8652 + 8750
 Weight 100:20:20-30
 Volume 3.5:1:1

B
PUTTY

 P998

C
FAST 2K PRIMER SURFACER

 8440 + 8641 + 8642 + 8611 + 8612 + 8613
 Weight 100:25:25-40
 Volume 3:1:1-1.5

D
BASECOAT

 SW-2K Solid Colors + 8611 + 8612 + 8613
 Ratio 2:1:0.2-0.6
 SW-1K Solid Colors + 8611 + 8612 + 8613
 Ratio 1:0.6-0.8

E
CLEAR COAT

 SW-811 + 8601 + 8602 + 8603
 Ratio 2:1:0-0.2
 SW-877 + 8611 + 8612 + 8613
 Ratio 2:1:0.2-0.4
 SW-833 + 8600 + 8601
 Ratio 2:1:0.1-0.3

Note: The above information is for reference only