

Green Lights Up Our Future



PRODUCT INSTRUCTION BOOK

Waterborne
Refinish

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EXwell Waterborne Basecoat is high-performance 1K waterborne color system based on polyurethane copolymer. It is ideal for spot, panel and overall repair and repainting of all types of motor vehicles.



Properties:

VOC compliant, significantly reduces solvent emissions into the environment.

High coverage power and high productivity with 1.5 coats, no flash off time between coats






Easy and accurate color matching, excellent color consistency between wet and dry

Excellent fade-out capacity to achieve invisible blends

Imperfect paint film can be sanded out and repainted without needs to repaint the whole application area

Substrates:

All OEM finishes, dried existing finishes and 2K primer; plastic parts should be coated with plastic primer to promote adhesion.

Surface preparation:		Clean the surface with appropriate cleaner and dry thoroughly		
 Mixing Ratio: (by Volume)	Exwell Basecoat:	50	or	40
	Binder:	50		60
	Controller:	10-15 for solid color		10-15 for solid color
		20-30 for metallic/pearl color	20-30 for metallic/pearl color	
	Controller selection:			
		Relative Humidity 10%~40%	Relative Humidity 40%~100%	
	< 30℃	WB1041	WB1042	
>30℃	WB1042	WB1043		
Spray Viscosity		25-35 seconds (DIN 4 at 25 ℃)		
 Spray Gun		Nozzle		
	Gravity Conventional	1.3-1.4mm		
	HVLP	1.2-1.3mm		
	Pressure feed	0.85-1.2mm		
 Pressure		Panel or Overall painting	Spot painting	
	Gravity Conventional	2.5-3.2 bar	2.0-2.5 bar	
	HVLP	0.7 bar	0.5 bar	
	Pressure feed	2.5-3.0 bar	2.5-3.0 bar	
 Number of Coats	1.5 coats Apply one medium wet coat at a gun distance of 20-25cm from the surface to achieve 75% opacity, followed immediately by one light coat(0.5 coat) without flash-off time increasing the gun distance to 30-40cm from the surface. All coats are wet-on-wet with 70% overlap.			
	 Flash Off	No flash off time between coats. Dry until matte finish with air drying equipment before applying clear coat.		
Dry Film Thickness		15um(±5um)		
Theoretial Coverage		8-12 square meters per liter at recommended DFT		

Notes:

1. The substrate must be well prepared and cleaned before application of the basecoat(dry sanding with P400/P600, or wet sanding with P800 or finer).
2. Exwell waterborne basecoat should be stored and applied with container and spray equipment of plastic, stainless steel or metal with anticorrosion coatings.
3. The Exwell waterborne basecoat should be stirred well on a mixing machine before use.
4. The drying time of the paint film depends on the ambient temperature, humidity and the speed of the air flow
5. If small particles or paint defects occurred in painting, sand out the defected area after the paint film is dried, then refinish.
6. The basecoat mixing with controller should be used within the day.
7. Clean the spray equipment immediately after use with suitable dedicated waterborne equipment cleaning machine. Rinse with DI water.
8. Storage: 5°C -35°C. Ideally at cool and dry place at 20°C with minimum temperature fluctuation.
9. Shelf life: 2 years in originally sealed cans

WB1010 Filp Controller

Used to lighten up the side tone of metallic color and create a darker face with larger metallic sparkle

WB1010	Quantity of addition	Remarks
	Depends on the color effect, maximum 20%	After the color is matched with WB1010, add controller before application

Notes:

1. Storage: 5°C -35°C . Ideally at cool and dry place at 20°C with minimum temperature fluctuation.
2. Shelf life: 2 years in originally sealed cans



Binder WB1020/WB1021/WB1022

Used to mix with Exwell waterborne basecoat for color matching and application

	Suitable for	Mixing Ratio
WB1021 Binder for Solid Color	solid color	Solid Color: WB1021=5:5 or 4:6
	metallic & pearl color with low metallic or pearl content	Metallic/pearl color : WB1021+WB1020 = 5:5 or 4:6
WB1022 Binder for Effect Color	metallic & pearl color with high metallic or pearl content	Metallic/pearl color : WB1022+WB1020 = 5:5 or 4:6
WB1020 Balancer	metallic & pearl color, combined with WB1021 or WB1022	1:1 with WB1021 or WB1022

Notes:

1. The viscosity of the WB1020 Balancer is high. The mixing ratio with Binder WB1021 or WB1022 can be adjusted according to the spraying viscosity needed.
2. For solid color, Binder WB1021 can be used without Balancer. For high metallic or pearl color, Binder WB1022 must be used with Balancer WB1020.
3. Storage: 5°C -35°C. Ideally at cool and dry place at 20°C with minimum temperature fluctuation.
4. Shelf life: 2 years in originally sealed cans

WB1030/WB1031 Blending Agent

Used for spot or panel repair to achieve invisible blends

	Ambient temperature	Humidity	Remarks
Wb1030 Standard Blending Agent	10°C-30°C	10%-100%	Spray Blending Agent to the blending area before standard basecoat application
Wb1030 Slow Blending Agent	30°C-40°C	10%-80%	

Notes:

1. Apply Blending Agent to the blending area before spraying basecoat.
2. Spray Exwell waterborne basecoat using standard 1.5 coats techniques. Extend the second coat beyond the first coat into the wet blending coat. Apply a light third coat with reduced pressure to achieve an invisible blend.
3. Apply clear coat on the whole panel after the basecoat dried
4. Storage: 5°C -35°C . Ideally at cool and dry place at 20°C with minimum temperature fluctuation.
5. Shelf life: 2 years in originally sealed cans

WB1041 / WB1042 / WB1043 Controller

Used to adjust the viscosity of the Exwell waterborne basecoat for spraying. Use suitable controller according to the ambient temperature and humidity

	Mixing ratio	Ambient Temperature	Relative Humidity
WB1041 Controller -Low Humidity	10%-30%	10°C-30°C	10%-40%
WB1042 Controller -Standard	10%-30%	10°C-30°C	40%-100%
WB1043 Controller -High Temperature	10%-30%	30°C-40°C	10%-40%

Notes:

1. The addition quantity of the Controller depends on the spraying viscosity needed.
2. The basecoat mixed with Controller should be used within the day.
3. Storage: 5°C-35°C . Ideally at cool and dry place at 20°C with minimum temperature fluctuation.
4. Shelf life: 2 years in originally sealed cans

WB1075 Hardener

Matched with Exwell waterborne basecoat for applying 3-stage colors. Or used for engine bay/interior color without needs of recoating with clear coat. It reacts and cross links with the basecoat to form a hard and glossy paint film with good chemical and physical resistance.

Mixing ratio	3- stage Color	Engine Bay/Interior Color
	100 parts - basecoat	100 parts - basecoat
	5 parts - WB1075	10 parts - WB1075
Pot life (after mixed with WB1075)	Solid color: 90-120 mins	Solid color: 45-60 mins
	Effect color: 45-90 mins	Effect color: 30-60 mins

Notes:

1. Mix Exwell waterborne basecoat with WB1075 Hardener first before mixing with Controller for application;
2. Storage: 5°C -35°C . Ideally at cool and dry place at 20°C with minimum temperature fluctuation.
3. Shelf life: 1 years in originally sealed cans

WB2010 Coagulant

Used in treatment of waste water to separate the solid from liquid components for the purpose of reducing chemical waste.

USE

1. Add 1% of WB2010 into the waste water
2. Stir for 5-10 minutes for efficient flocculation
3. Allow the waste solid to settle out for 10 minutes
4. Filter out the waste solid from the liquid using suitable mesh
5. Dispose of the solid waste and the filtrate in accordance with the local regulations for chemical waste.

The filtrate should be disposed of in accordance with local regulations for chemical waste and should not be disposed of into the public sewer without obtaining official authorizations.

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