



PAINTING WITH LIWREA® AK5

- ANNEX A -

GENERAL INFORMATION

- Coating booth at 20/25°C;
- LIWREA® must be stored in an ambient temperature above 10°C;
- The surface which requires coating must be at a temperature between 10°C and 30°C;
- LIWREA® is ready for use and only 5-7% of distilled water must be added before the application.

Take Notice:

The paint may be applied without the use of the coating booth, but only in ambient where the temperature is above 10°C. When painting, dust particles may settle on the surface, causing some cosmetic imperfections.

PRELIMINARY CLEANING OPERATIONS

1. Clean the surface with anti-silicone water based LICLEAN (cod. LW0015); then dry it completely with air and possibly antistatic cloths because residual water can compromise the success of the work.

SPRAY GUN ADJUSTMENT OPERATIONS (Mod. WALMEC GENESI HTE 1.3)

- Fully turn the first knob to an open position;
- Turn the second knob 3,5 full rotations;
- Fully turn the third knob to an open position;
- 1.3 nozzle;
- Air pressure 3 bar;
- Insert the provided filter into the spray gun tank.

MASKING

Cover the parts that are not to be painted and remove the protection when the LIWREA® is still wet. If this is NOT possible, be very careful when removing the protection. The dried product may adhere to the edges of the paper and then detach from the support.

PAINTING

1. Filter the product with traditional paper disposable filters;
2. Add 1,5% of LIFORCE 120 hardner (cod. LW0011) in LIWREA® AK5. Using the catalyst will improve the product's resistance to atmospheric agents, therefore it is recommended for countries with rain and snow fall or for external general application;
3. Add 5-7% of distilled water;
4. If you want to change the colour, add various coloured pigments as described by the desired RAL colour description of LIWREA® Multiral software;
5. Apply approximately 150 microns wet of LIWREA® AK5 paint which corresponds to about 3 layers in total. Each layer of paint deposited on the surface must be at least 50 microns wet of LIWREA® AK5 paint. The paint must be applied wet on wet surface as described below:

First, second and third layer

- Apply 3 layers of paint wet on wet (if the paint tends to drip wait few seconds before applying the next layer);
- Paint from a distance of about 15/20 cm;
- Low painting speed;
- Drying at room temperature.

Take Notice:

If you want to get thicker layers, let the first 3 layers dry completely, then paint over other layers using the wet on wet method. A thicker layer can reduce the glossiness of the surface.

When the 3 layers of paint are completely dry, raise the temperature of the oven to 50/60°C and leave in oven for 60 minutes. Leave the vehicle covered all night at a temperature above 10°C. The next day return the vehicle to the customer.