

Application Process of Unic[®] Automotive Refinish

1

Substrate treatment

- Remove the oil, rust, etc.
- Clean the substrate completely.
- Keep the substrate still for half an hour after cleaning.

↓ 2

Spray two component epoxy primer

• Suitable substrate	OEM paints, stainless steel, wood, aluminum, galvanized sheet, putty, galvanized steel, glass fibre reinforced plastic			
• Sanding	Sand after the finish become drying and solid, wet sanding with P800#~P1000#			
• Mix ratio (by volume)	2K Epoxy Primer UN-2126: 3 parts Hardener UN-8101 or UN-8102 or UN-8103: 1 part Thinner UN-6001 or UN-6002 or UN-6003: 1~2 parts			
• Pot life	4 hours@20°C			
• Spray Equipment	Gravity type: 1.2~1.5mm, 3~4Pa Suction type: 1.2~1.7mm			
• Flash-off	5~10 minutes between coats			
• Temperature	10°C	20°C	40°C	70°C
Non cohesive time	60 minutes	15minutes	10minutes	5minutes
Drying time before sanding	24 hours	12 hours	2 hours	30 minutes

Precautions

1. Remove oil and then sand the surface with P180 before spray, use degreaser to clean the surface. Keep it 10 minutes before spray.
2. The epoxy primer must be sanded if the drying time exceeds 24 hours@20°C before spraying the new surface.
3. It is a must to use the Unic supporting hardener and thinner.
4. Close the tin cover shortly after taking some paints from the tin.


3

Scrape putty	<ul style="list-style-type: none"> • Mix Ratio (by weight) 	Putty UN-2001: 100 parts Hardener UN-8101 or UN-8102 or UN-8103: 2~3 parts
<div style="background-color: #fff9c4; padding: 5px; margin-bottom: 5px;">Procedure</div> <ol style="list-style-type: none"> 1. Scrape and fill up the putty on the metal surface in order to fill up the defects on the surface. 2. Please scrape and fill up the dents for many times for the deeper dents. The scrape can not be done before drying each time in order to avoid the blisters and sand holes. 3. Before spray: P80~P180 by dry sanding, After spray: P80~P180~P360 by wet sanding. 4. Sand and repair the surface after drying. 		


4

Spray 2K primer surfacer	• Suitable Substrate	OEM paint, steel surface, Fiber Reinforced Plastics, surface of putty
	• Unapplicable Substrate	Galvanized steel, stainless steel
	• Colour	Light yellow, grey, white
	• Mix Ratio	2K primer surfacer UN-8201, UN-8203, UN-8204: 5 parts Hardener UN-8101 or UN-8102 or UN-8103: 1 part Thinner UN-6001, UN-6002, UN-6003: 1 part
	• Pot Life	2 hours@20°C
	• Spray Tool and Pressure	Gravity type: 1.2~1.5mm, 4Pa Suction type: 1.4~1.6mm (Spray 30~50μm)
	• Spray	2~3 layers
	• Flash-off	5~10 minutes between coats
	• Drying Time Before Sanding	3 hours@20°C 30 minutes@60°C
	• Sanding	Before spray: P180~P400 by dry sanding After spray: P800~P1000 by wet sanding
<div style="background-color: #fff9c4; padding: 5px; margin-bottom: 5px;">Precautions</div> <ol style="list-style-type: none"> 1. 2K surfacer can be sprayed after sanding and removing the oil and stain on the surface of the putty, epoxy primer, old paints. 2. 30μm must be kept after sanding on the intermediate coating layer. 		



Spray the following topcoat:

*1K metallic paint or pearl paint (M & P series)

• Suitable Substrate	OEM paint, Unic brand middle coating		
• Unapplicable Substrate	Thermal plasticity acrylic paint or alloy base coat		
• Colour	According to the choices of the customers		
• Sanding	Before spray: P600~P800 by dry sanding After spray: P1000 by wet sanding		
• Mix Ratio (by volume)	Temperature	1 part	0.8~1 parts
	<15°C	1K Basecoat	Thinner UN-6001
	15°C~25°C	1K Basecoat	Thinner UN-6002
>25°C	1K Basecoat	Thinner UN-6003	
• Spray Tool and Pressure	Gravity type: 1.2~1.5mm, 3~4Pa Suction type: 1.4~1.6mm		
• Spray Method	2-3 single coating to coverage		
• Drying Time	Varnish can be sprayed within 15 minutes to 5 hours		

Precautions

1. The result will be perfect if the users use Unic brand supporting thinner.
2. It is highly recommended to use light metallic paint 1008,8001-1,222 or 808 varnish, otherwise it will become yellow.

*2K solid colour paint (S series)

• Suitable Substrate	OEM paint, steel surface, Fiber Reinforced Plastics, surface of putty			
• Colour	According to the choices of the customers			
• Sanding	Before spray: P360~P400 by dry sanding or P600~P800 by wet sanding After spray: P360~P400 by wet sanding or P800~P1000 by wet sanding			
• Mix Ratio (by volume)	Temperature	2 parts	1 part	0.5~0.8
	<15°C	2K solid paint	Hardener UN-8101	Thinner UN-6001
	15°C~25°C	2K solid paint	Hardener UN-8102	Thinner UN-6002
>25°C	2K solid paint	Hardener UN-8103	Thinner UN-6003	
• Spray Tool and Pressure	Gravity type: 1.2~1.5mm, 4Pa Suction type: 1.4~1.6mm			
• Pot Life	2.5 hours@20°C			
• Spray Method	2-3 single coating to coverage (volatilization time of each layer: 15 to 20 minutes)			
• Drying Time	Temperature	Non cohesive dust	Touchable with finger	Drying & Curing
	20°C	1 hour	1~2 hours	24 hours
	60°C	5 minutes	10 minutes	60 minutes

Precautions

1. Light colour paint is not allowed to add varnish for spray, otherwise the colour will become yellow.
2. The basecoat should be polished by 800# sand paper before spray the finish coat.
3. Keep the basecoat dry before spray the finish coat, otherwise the blisters will appear.



2K Clearcoat

• Suitable Substrate	Unic brand base coating			
• Colour	Clear, free of extraneous matters			
• Mix Ratio (by volume)	Temperature	2 parts	1 part	0.1~0.2 parts
		Clearcoat	Hardener	Thinner
	<15°C	UN-1008	UN-8101	UN-6001
	15°C~25°C	UN-8008	UN-8102	UN-6002
	>25°C		UN-8103	UN-6003
• Pot Life	4 hours@20°C			
• Spray Viscosity	16~22 seconds@20°C			
• Spray Tool and Pressure	Gravity type: 1.2~1.5mm, 3~4Pa Suction type: 1.4~1.6mm, 60°m			
• Spray Method	2-3 single coating to coverage (volatilization time of each layer: 15 to 20 minutes)			
• Drying Time	24 hours@20°C, 45 minutes@70°C			

Precautions

1. Keep it for 15 to 20 minutes after spray, and then bake it.
2. Keep the baking room dry when baking, otherwise the gloss will disappear.
3. Add 15% quick dry liquid for fast solidity.
4. Choose the right hardener according to the temperature.
5. It is suitable to spray the whole car body.



Polishing & waxing

- Sanded with sand paper, remove the dust particles and curtaining, then polish again.
- Polish with wax stone, then polish with sand paper, make the surface flat and glossy.
- Use the wax water to polish the surface in order to keep the gloss for long time.

Precautions

1. Do not wash the wool ball with corrosive materials.
2. Make sure the wool ball does not include sands or other hard material.