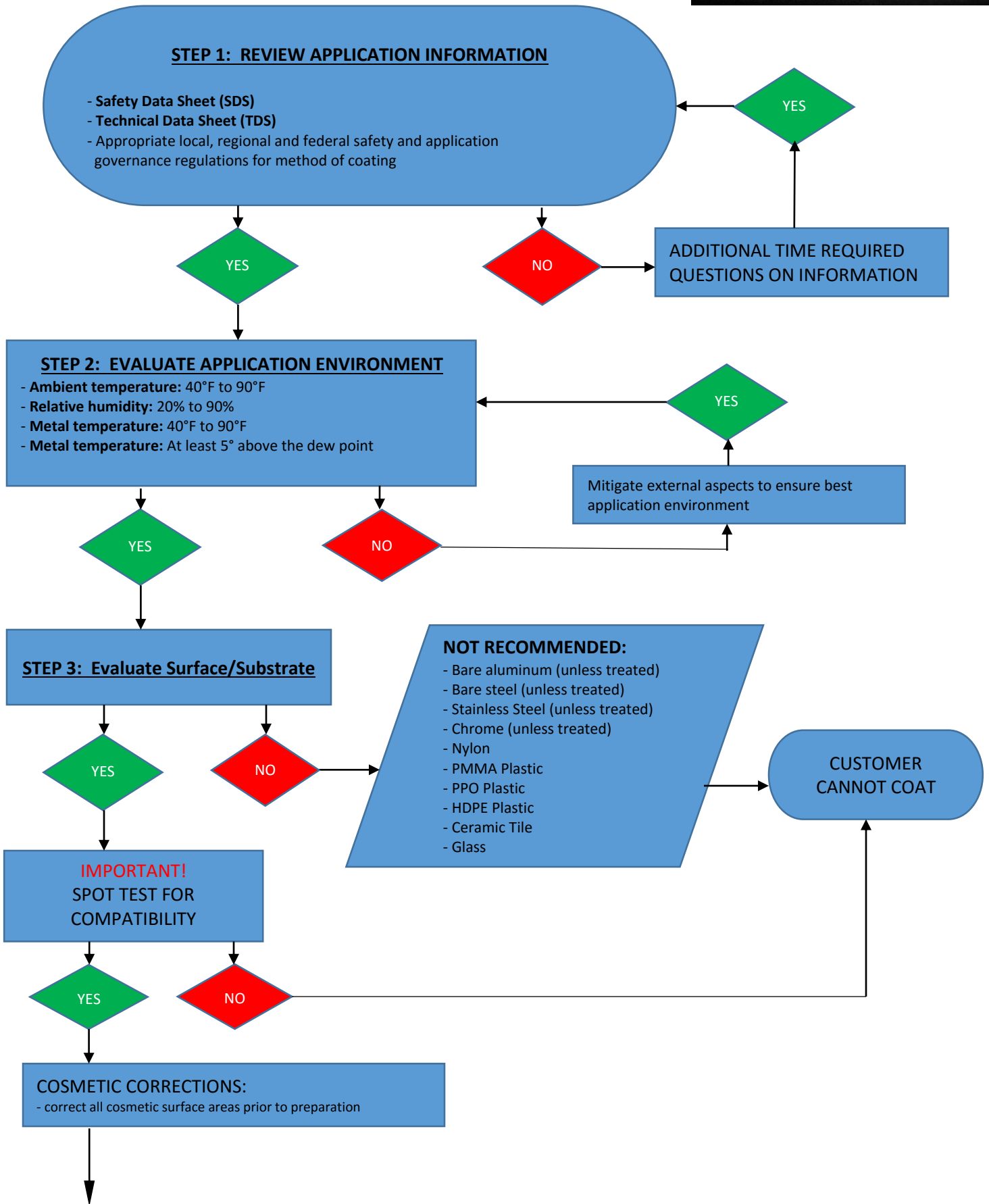


# NANO-CLEAR® NCI APPLICATION INSTRUCTIONS



#### STEP 4: REVIEW SURFACE PREPARATION OPTIONS:

##### **Freshly Painted Surfaces:**

- Apply after underlying paint tack-free time (typically 3-6 hours)
- Apply directly over 2K epoxy, 2K PU topcoatings or powder coatings.
- Apply Nano-Clear NCI as per TDS.

##### **Fully Cured Painted Surfaces:**

- Sand paint using 400 grit orbital sander, then solvent clean using paint thinner to remove excess debris.
- Apply Nano-Clear NCI as per TDS.

##### **Oxidized Painted Surfaces:**

- Repair any structural damage (rust or chipping) using two-component epoxy primer.
- **Oxidized Paint MUST** be sanded using 400 grit paper with orbital sander; solvent clean & dry

#### STEP 5: DETERMINE APPLICATION METHOD

##### **AIR SPRAY EQUIPMENT**

Spray Gun: HVLP or LVLP  
Fluid tip: 1.4 to 1.5mm  
Fluid line: 3/8"  
Pressure pot: 15-20 PSI  
Pressure at gun: 29-30 PSI

##### **AIRLESS SPRAY EQUIPMENT**

Tip size: Graco 419 or 519 orifice  
Pump: 30:1 or 40:1  
Pump pressure: 800 psi

##### **WIPE ON/ROLLER**

Nano-Clear may also be applied using a "wipe-on" application process. The use of a ShurLine Deck Pad Applicator or lint-free microfiber applicator is recommended. The "wipe-on" application process will not achieve as good leveling and film build as spray coating.

#### STEP 6: SAFETY REQUIREMENTS

REVIEW SAFETY DATA SHEET (SDS)

#### STEP 7: APPLICATE

##### **Recommended Film Build:**

- Number of spray coats: Apply 2-3 wet coats with 2-10 min. between wet coats to allow for solvent evaporation.
- Avoid recoating additional coats after 20 min. as flow and leveling will be effected.
- Recommended (WFT): 2-3 mil per wet coat or 6 mil wet film build thickness.
- Recommended (DFT): 50 micron or 2 mil dry film build thickness

**Solvent Flash:** Allow 2-10 min between wet coats at 72°F to allow for solvent evaporation

**Thinning:** None required as Nano-Clear® has very low viscosity

\*\* Nano-Clear® is a moisture sensitive system. It is important to close containers immediately after use to avoid moisture contamination. \*\*

#### STEP 8: CLEAN UP/DISPOSITION

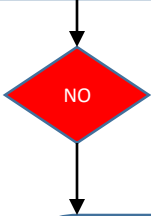
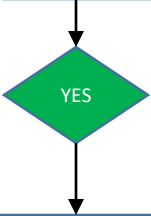
- Clean equipment immediately using paint thinner, MEK or acetone. Never clean spray equipment with water or alcohol.
- Dispose of waste products per applicable local regulations.

#### STEP 9: CURING COATING

- Cure time @ 72°F, 50% R.H.
  - Dust free: ~20-30 minutes
  - Tack Free: ~30-40 minutes
  - Handle: ~4 hours
  - Dry Hard: 24 hours @ 72°
- \* Lower temperatures and lower humidity conditions will slow-down the curing rate.  
\* Higher temperatures and higher humidity conditions will speed-up the curing rate.

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**STEP 10: APPLIED PRODUCT REVIEW**  
REQUIRES CORRECTIONS?



**BUFFING & POLISHING (if needed):**

- **Equipment:** orbital sander and orbital polishing equipment.
- **Sandpaper:** 1000 grit paper, then 1500, then 2000 to 2500 grit paper.
- **Compound:** Heavy cut compound with wool pad @ 1200 to 1400 RPM.
- **Polishing:** 3M SRC (scratch resistant clears) polishing paste with wool @ 1200 to 1400 RPM.
- **Final Polish:** use light to medium cut polishing paste with wool pad @ 1200 to 1400 RPM.

**COATING MAINTENANCE:**  
SURFACE MAINTENANCE/CLEANING

- use low pH soap and water for clean-up.
- use lint-free microfiber cloths to clean and dry surface
- use paint-thinner to remove graffiti.

