

## 1. Vehicle Preparation

- 1.1 Wash the vehicle and make sure you do not use any wax-based products. If you use an automatic car wash, select the basic wash.
- 1.2 Dry the vehicle afterwards. You can either use a pressurized dryer system or let it air dry over night.
- 1.3 Clean the vehicle with AutoSpruehFolie PRECLEANER and blow it off roughly.
- 1.4 Tape the vehicle properly.  
  
Tape every spot you don't want to have coated or remove if possible e.g. door handles, side indicators, spray nozzles etc.  
  
Important!  
The masking tape/paper should not touch the surface, which will be coated, or you might have trouble removing it. Hard edges must be removed after the last coat is completed when the surface is still wet.  
  
*Our Tip:* Note down where exactly you need to remove the masking tape on the wet surface.
- 1.5 Clean the vehicle again with AutoSpruehFolie PRECLEANER.
- 1.6 Remove dust particles.



## 2. Material Preparation / Spray Gun

- 2.1 Choose the right spray gun (Recommendation: HVLP). Important is the right tip (see Technical Data Sheet) Usually we recommend using a spray gun with a tip size between 1,4 - 1,6 mm and pressure at around 2,0 - 2,5 bar.
- 2.2 Stir material carefully. Set a viscosity of approx. 18 seconds in a DIN 4mm cup.
- 2.3 Fill the material into the spray gun using a 190µm strainer for solvent varnishes.

## 3. Painting process

## 3.1 Lay down the base coats

Spray two coats of AutoSpruehFolie clear glossy as a base. This ensures an optimal adhesion of the product. In case the room temperature surpasses 20 °C, you can further thin the product.

*Our Tip:* Use the "round jet" option on your spray gun for corners and hollow spaces.

## 3.2 Use the 3rd to the 6th coat for spraying your desired color.

*Application tip for color:*

Mix your desired Colour Tint into the transparent 3L AutoSpruehFolie can. The Colour Tint bottle should be rinsed with thinner or AutoSpruehFolie to ensure you get all of the remaining color. The same procedure can be used with effect color pigments.

*Additional Information:*

Color tints and effect pigments can be mixed together.

Important tip:

- Let each coat air out for about 15-20 minutes before applying the next one.
- Apply material evenly on the surface.
- The goal is a dry film thickness of around 100 – 120 µm.
- Remove masking tape for hard edges while the surface is still wet.



## 4. Drying

- 4.1 In the best case let the coating dry for at least 8 hours at room temperature or overnight. Another option would be oven drying at 60°C for about 30-40 minutes.

### 5. Apply Clear Coat (without Clear Coat: directly to point 6)

Before using AutoSpruehFolie clear coats or water-based varnishes for coloring, you have to apply a bonding agent on top of the AutoSpruehFolie.

The bonding agent is used as a tool to increase the adhesive properties of the clear coats or the water-based varnishes.

The AutoSpruehFolie has to be completely dry before applying the bonding agent. Spray the bonding agent across the whole surface before applying die AutoSpruehFolie clear coat or water-based varnishes. Please see the Technical Data Sheet for further information.

- 5.1 After the drying time is completed, tape hard edges again.
- 5.2 Carefully mix the clear coat (see Technical Data Sheet).
- 5.3 Ensure the surface is dust free – using an air compressor.
- 5.4 Now you can evenly apply the clear coat repeating the procedure 2 - 3 times.  
Important: Consider the drying time on the Technical Data Sheet.
- 5.5 Remove masking tape on hard edges while the surface is still wet.
- 5.6 Let the last coat dry completely.
- 5.7 Using the oven drying method, dry the clear coat at 60°C for about 30 – 40 minutes.

### 6. Finish

- 6.1 Remove the masking tape/paper everywhere.
- 6.2 Install all parts back on the vehicle.
- 6.3 Now you can seal the surface with AutoSpruehFolie SEALER.

