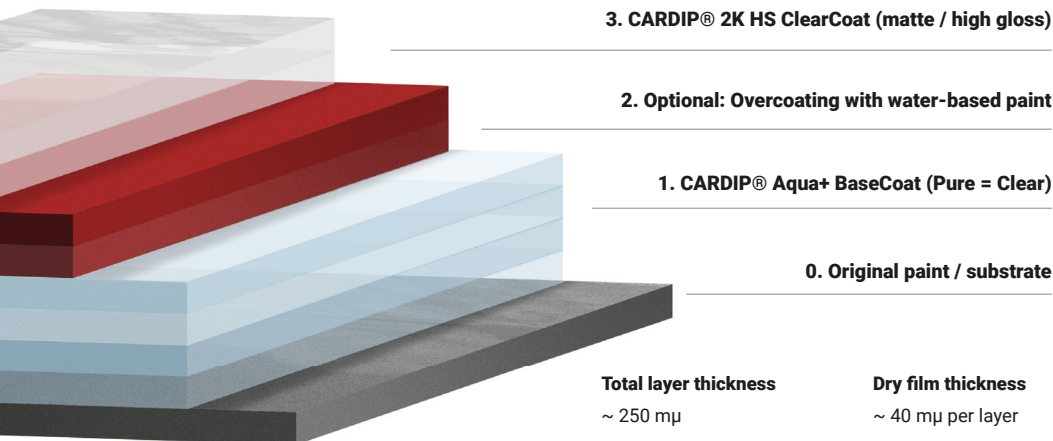


Technical instructions

CARDIP® peelable paint

For processing by the painting specialist!

The CARDIP® peelable paint is built up in a multi-layer process from the 1K-Aqua+ BaseCoat 5080 (film base) and 2K-ClearCoats. The surface is always coated with at least 4 layers of CARDIP Aqua+ BaseCoat 5080. For a clear protective film, this is followed by the clearcoat in 2 layers. For a colored film, a water-based paint in the desired color can be applied before the clearcoat, or alternatively a solvent-based paint with the addition of CARDIP Elastosol 404.



The substrate must have an intact paint with a 2K clear coat (all modern automotive paints) that is at least 4 weeks old. During application, ensure that the specified layer structure is adhered to on all (vehicle) areas and check the substrate for function and compatibility with CARDIP® products. Required dry film thickness for functioning peelable paint coating: min. 150 µm.

Adhesion tip: Sand heavily stressed areas such as the undersides of bumpers and sills before coating the surface (!) with fine (!) abrasive sandpaper (P1500) in order to achieve stronger adhesion of the film to these areas. After removal of the film, these areas can simply be polished up again.

1. PREPARATION



1.1 Cleaning

Before starting work, wash the vehicle or component thoroughly. Remove all impurities from the surface.



1.2 No silicone / grease

Avoid the use of cleaners containing silicone and grease. Avoid the use of polishes and waxes before coating.



1.3 Drying

Dry the vehicle or component completely, especially in the crevices and interior areas.



1.4 Disassembly

Inspect the vehicle or component for interfering parts (door handles, emblems, trim strips, rubbers, etc.) and dismantle if necessary. **Spray entire vehicles in as many individual parts as possible to keep overspray to a minimum and to achieve the best possible surface finish!**



1.5 Masking

Mask off the vehicle or component as for painting. Mask off headlights, radiator grilles, trim strips and windows cleanly and accurately to achieve an optimum result. Use whole strips of tape to achieve sharp edges and reliably cover the components that are not to be coated. **So that the spray film does not bond between individual parts, make sure that there is a gap of min. 1mm everywhere. (fingernail test)**



1.6 Cleaning

After preparing the vehicle for coating, clean the vehicle with CARDIP® ETA-Cleaner 101 to remove all grease and contaminants from the surface. **Do not use other degreasers, especially water-based cleaners, as this may lead to incompatibility with the CARDIP® Aqua+ BaseCoat 5080!**

Tip 1.6 Disassembly: When coating entire vehicles you should dismantle as many components as possible and do not spray on the entire vehicle. For example, engine hoods, bumpers, etc. By disassembly of the large components less overspray is produced during application and you will achieve a smoother surface.

Tip 1.7 Masking: In the interior areas of the vehicle (door entry, trunk entrance, etc.) place tape and masking paper about 5mm in front of the outer edge to cover the interior. For the sharp last outer edge in interior areas we recommend the use of 3M 06800 Transition Tape. Alternatively, tape a ,soft' finishing edge with masking tape.

Tip 1.8 Cleaning: Immediately before coating, we recommend cleaning the surface with a tack cloth.

2. COATING / APPLICATION

2.1 CARDIP® AQUA+ BaseCoat 5080 (Pure = Clear)

For processing, Aqua+ BaseCoat 5080 must be diluted 5:1 or 20% with Aqua+ Reducer 500. After adding, ensure thorough homogenization and sieve.

Apply the Aqua+ BaseCoat 5080 directly at the beginning and with each subsequent layer to maximum wet layers on flow. In order to avoid overcoating, we recommend the application on standing surfaces. Allow each layer to flash off completely before applying the next layer. The applied layer is flashed off as soon as the light blue marker has completely disappeared. Apply Aqua+ Basecoat 5080 to components and car bodies from bottom to top.

Note on intermediate drying:

For faster flash-off, we recommend the strongest possible air circulation at a max. of 35° C / 95° F for 10-15 min. Never heat Aqua+ BaseCoat 5080 above 35° C / 95° F, as the surface will close and the light blue marking agent will no longer be able to escape if drying is too fast!

After 4 full layers of Aqua+ BaseCoat 5080, all areas of the vehicle should be completely coated and there should be a layer thickness of about 120-160 µm of transparent film. Depending on the requirements profile, more layers can be applied, even partially, for even higher film thicknesses. This is particularly recommended for heavily stressed areas such as sills or bumpers.

Now there are 2 options to choose from:

1st option: Clear stone chip protection film / paint protection film

For a clear protective film, finish the application with 2 full layers of CARDIP 2K HS ClearCoats 8080 / 8091 according to key point 2.2!

2nd option: Colored film coating

For a colored film coating, apply a usual water-based automotive paint in the color of your choice (e.g. Spies-Hecker; Glasurit; Nexa; PPG, etc.) on top of the at least 4 layers of Aqua+ BaseCoat 5080 you applied previously. Apply the waterborne paint in exactly the same way as for classic coating according to the system specifications. **Always spray a dusty adhesive layer first.** Solvent-based coatings should only be used with the addition of CARDIP Elastosol 404. Please refer to the corresponding technical data sheet. After achieving the desired color, finish the application with 2 full layers of CARDIP 2K HS ClearCoats 8080 / 8091 according to key point. 2.2!

2.2 CARDIP® 2K HS ClearCoats 8080 UltraGloss / 8091 Matte

The coating must be completely dry before applying the clearcoat. Intermediate drying at 35°C / 95°F for 15 min. is recommended before applying the clearcoat.

Both variants of CARDIP 2K HS ClearCoat are applied in a minimum of 2 layers wet on flow. Use the CARDIP Thinner Slow 850. A flash-off time of 15 min. should be observed between the layers. If necessary, a 3rd layer of clearcoat can be applied.

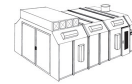
✓ The coating is now finished.

2.4 Finishing

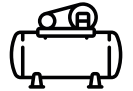
Remove the masking paper and adhesive tape and reassemble the disassembled components. When removing the adhesive tape, make sure that the film has not bonded to the adhesive tape at any point. If it does, separate the bond with a clean cut. While reassembling the components make sure that the film coating inbetween of certain components cannot come loose due to excessive pressure or movement. Directly underlay contact points / friction points with adhesive tape or fleece and do not overtighten fastening points.



Paint spray gun
full spectrum



paint booth
25 °C / 77 °F



Compressed air
1,7 Bar gun

For the processing of CARDIP® AQUA+ BaseCoat 5080 we recommend: SATA JET 5000B RP/HVLP
1.2- 1.3 mm or equivalent.

Tip Option 1: Clear paint protection (PPS)

Special case: For colors that react sensitively to discoloration caused by coatings (white, silver, black) apply, especially in the case of partial coatings, a waterborne paint in the original car color according to option 2 to prevent visible differences in color on the single areas.

For the application of CARDIP® 2K HS ClearCoats 8080/8091 we recommend:
SATA JET 5500B RP 1.2 mm or equivalent.

Mixing ratio ClearCoat gloss / matte:
2:1; 2 parts clearcoat to 1 part hardener
+ approx. 15% thinner.

If necessary, the thinner ratio can be increased.
Use the CARDIP Thinner Slow 850.

Tip: For an even more uniform result, you can finish the glossy version of the clearcoat in the same way as a conventional lacquer, by sanding and polishing. You can sand both dry and wet. Sanding marks up to P1500 grain can be polished up by a sanding polish.

Alternatively, the clearcoat can also be intermediately sanded with P800/P1000 and then reapplied to achieve an even smoother surface and more color depth.

2.3 Drying after clearcoat



Room temperature
25 °C / 77 °F



Drying oven 45 °C / 113 °F
Before and after oven drying
30 min. of resting time