

ORACOLOR® APPLICATION INSTRUCTIONS



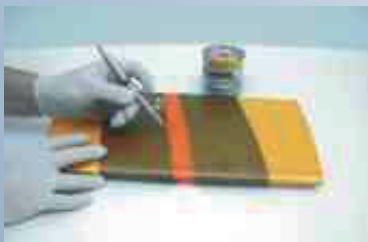
ORACOVER® can be buffed with 000 grade steel wool.



Before painting/spraying clean with **ORACOLOR®** thinner.



Apply the **EASYPLOT®** masking film with the help of the **ORACOVER®** felt blade (ref. no. 0915), avoid bubbles.



Remove the **EASYPLOT®** masking film immediately after you finished painting.

Preparation of paint: Mixing ratio: 2 : 1.

Hardener for spraying: Ref. No. 100-997, viscosity for spraying: 16-25 s., DIN 4 - flow cup.

Hardener for brushing: Ref. No. 100-998, viscosity for brushing: 30-60 s, Din 4 - flow cup.

Application time: 30-60 min. (depending on room temperature and application).

Application temperature: 5°-35 °C (relative air moisture c. 70% - 80%).

Thinner: for brushing 3-10%, for spraying up to 30%, depending on spraying system and nozzle type.

Spraying / Airbrush:

By reservoir cup and airgun (e.g. Evolution, Sata...).

Injection pressure: 2,0-3,0 bar (depending on consistency and colour).

Spraying runs: depending pm surface, colour and dilution.

Nozzle: 0.2-1.6 mm, distance c. 20-60 cm, with an angle of 40° - 60°.

Work steps: 2-3 (depending on surface, colour and consistency).

Brushing: by brush

Worksteps: 2-3 (depending on surface, colour and consistency).

Drying:

Airing time: 10-20 min. (temperature of object and surroundings 21°C).

Non-adhesive: 3 h. Sprayable: 16 h (depending on colour and gloss level)

Grindable: 24 h.

Consumption:

Depending on surface, consistency, application and desired colour shade: c. 120-130 ml/sqm.

Storage:

Approx. 1 year in closed container. Keep cool and dry.

Cleaning of tools:

Clean with **ORACOLOR®** thinner immediately after use.

Safety Provisions:

- Do not inhale atomised spray, use suitable protection (gloves, face masks o.s.)
- Avoid contact with eyes and skin
- In case of accidental swallowing see a doctor immediately.
- Must be used only in well-aired rooms.

General Advice:

For best results the surface of the object to be painted has to be suitably prepared if necessary, and on the other hand the paint has to be adjusted to the surface regarding specific film qualities like colour gradient, grip etc. You can easily check this by dropping a drop of paint onto the surface to be painted. The drop must show a good gradient and filming, i.e. it must not contract or diverge in bubbles. Otherwise prepare the surface accordingly (sand, degrease, clean etc.).

Paint applied too thickly or a wrong paint consistency (too thin or too thick), as well as a too short distance lead to bad results (stripes, bubbles). Generally all surfaces must be clean, dry, grease free and stable. Uneven surfaces can be levelled with **ORACOLOR®** filler (ref. No. 100-999).

Spraying

For multiple layers spray in intervals of 15 min. When spraying **ORATEX®** fabric covering spray in several steps, with atomised spray. For best results take care to use the right nozzle for the paint consistency and the spray pressure. We recommend to test first.

Brushing

For several layers brush in intervals of 60 min. Also in this case test first. The first layer should be very thin (thin by up to 10%). When painting wood we recommend to lightly sand upright fibres after the first layer has been applied.