

Work instructions and technical bulletin WATER-TRANSFER-PRINT		
Trait	WT-DIRECT water-transfer-print is a special print method to refine lacquered surfaces. With this method exclusive designs for the interior- and exterior area are possible. WT-DIRECT water-transfer-print was aligned specially for 1K as the case may be WB lacquer- and clear coat system.	
Products and additions	Water-transfer-print films in 50 cm and 80 cm width Water-transfer-print activator A Water-transfer-print activator B or spray ready mixed in aerosol cans as well	
Hoop Order number	Please gather the order number and size of trading unit from the order blank	
Raw material basis	WT-DIRECT water-transfer-print films: polyvinyl-alcohol	
Usability Underground oriented	WT-DIRECT water-transfer-print films can be applied on: • 1 K systems without reservations but not on 2 K systems • After drying WB BASE COAT minimum 30 minutes at room temperature	
Cleaning	Before you coat the underground with WT-DIRECT water-transfer-print film you have to wipe the underground with a duster. Don't degrease water lacquer with silicone remover or other cleaning supplies.	
Mixture ratio of the water-transfer-print-activator by weight	2 weight-tracts activator A 1 weight-tracts activator B	
Pot life	In mixed situation: 6 months by 20°C	
Spray viscosity	15-16 seconds DIN 53221 by 20°C	
Processing instructions	The cabin-and material temperature should have between +18°C and +25°C while machining	
Dimension of the jets and injection pressure	Jet dimension in mm	Injection pressure in bar
	SATAJET 3000 HVLP	1,0
Working temperature	Water temperature in the dipping-bowl 25 - 28°C	
Filling level of the tap water	Dipping bowl full till the overflow. Before initial filling, the bowl has to be cleaned with the right abstergent agents.	
Aquatic change	Aquatic change after quality losing while processing. At the duct launching of the effluent the local launching-approval-regulations have to be received.	
Film soaking time before activating	60 - 90 seconds depending on film	
Activator – residence time	Up to 30 seconds depending on film, room temperature and air moistur	
Operating premises of the dipping bowl	- turn pump and heater ON - angle thermostat of the filter bowl. Once-only adjustment.	

Designation according to Ordinance on Hazardous Substances in theirs at a time validly form, see details on the hoop label.

Only to lacquer vehicles by a professional, considering the producer advocacies in the bulletin. For job safety you have to consider the information of the workers' compensation board of the chemical industry „process of coating material“.

The made statements were determined as standard values at labor and in practice. The product information, including any assurances concerning the product-qualification, result to the best from one's knowledge and conform to today's state-of-the-art.

Training hints

Instructions on hazards and protective measures on the basis of company rulings (TRGS 555). These instructions must be given upon employment and afterwards at least once per year.

Recommended restriction of use Use as a solvent only in industrial manufacturing processes

		<ul style="list-style-type: none"> - wait till the working temperature is achieved and heater is off. - change filter pad (filter nature: WTD filter pad) of the filter bowl by constant rising water level of the filter box. - preset timer to film-soaking-time - the water pump has to be OFF before you insert the water transfer print film
	<p>Machining</p>	<ol style="list-style-type: none"> 1. Colouring, drying times and material type from WT-DIRECT or similar WB or 1 K varnish need to be observed (the drying times need to be observed; the water-transfer-print need to be done within max. 24h). Shiny varnish is not porous enough; therefore the coating does not adhere. 2K-varnish cannot be etched with activator. 2. Cut film (Blank of the coating face + 5cm, minimal 25cm x 25cm) 3. Cut film in slant 1cm deep ca. 45° cuttings, at the brim around, cut in intervals of 3 to 5 cm or stick little glue strips in the same interval at the brim. 4. Lay limitation-blank sheets onto the water surface (2 - 3cm distance to the film) 5. Lay the wet film between thumb and forefinger, compress fingers for 3 seconds and lay film with the gluey side onto the water (touch film diagonal, let sag mid and lay onto water with one sag side). Press out bubbles with dry finger or by soft blowing with the mouth. 6. Press start-button of the timer 7. After the sound of the blip – press stop-button 8. Spray activator covering, a gleam in the light, onto the film. (Before beginning with the process turn on the vacuum device, put on dust mask and gloves.) If you apply the activator too thick the film will become blurred on the component. Productiveness of the activator is ca. 20 to 30 mg/m², conforming 35 to 55 meter film-length, 50 cm width for one liter. 9. Observe residence time of the activator. 10. Do dipping process slowly with few centimetres per second.

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		<p>When dipping by hand, shake soft in dipped condition till the film breaks off at the brim. The machining time (see 2.3) need to be observed. The time till the film is melting on the water is depending on the film. The dipping-angle can be geometry-dependent up to 80°. No other film will adhere on an already covered face. You can wash off the film-overlap. By further dipping processes you have to paste the already covered face.</p> <p>11. Clean the tracts with warn water till the lubricating film is gone. By afloating water you have to rinse it afterwards with fresh water.</p> <p>12. Let the tracts dry well.</p> <p>13. Decor-flaws can be corrected</p> <p>14. If you have got flaws, you can take a paintbrush soaked with spray-ready activator, displace color from the film and transfer it.</p> <p>15. Apply clear coat</p>		
	Re-coating	Overspray able with any usual clear coats from any repair sectors.		
	Cleaning of the equipment	Clean with LESONAL/SIKKENS multi-thinner or LESONAL/SIKKENS nitro-thinner.		
	Drying	by	20°C	60°C
	Storage stability	Dust-free Handle bar re-coat able with clear coat	15 min 30 min 45 min	5 min 10 min 15 min
	Designation	WT-DIRECT water-transfer-printing films: Activator A: Activator B: Details are not valid for dawn original-hoops by +20°C.	24 months by RT 24 months by RT 24 months by RT	
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		Protect from frost	Protect from heat	

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