

The operation and the handling with water-transfer-print-systems and Activator from WT-Direct GMBH

To get a consistent and an optimal effect, we recommend the following equipment sold by us

1. For small tracts the SATA Mini Jet 1.0 SR
2. And for bigger tracts the SATA JET 3000 HVLP 1,0 die set

The equipment is optimized for a fast, easy and uninterrupted manufacturing act.

Basic principle

You have to apply the water-transfer-film afloat on the water surface. The tract you need to coat you have to dip it into the water-transfer-film which is laying on the water surface in doing so the pattern from the water-transfer-film is going to be transfused onto the tract.

The succession is:

- To clean up and to degrease the tract you want to coat (please use detention primer when it is out of plastic.)
- Painting of the underground in the matching color from WT-Direct GMBH
- To apply the water-transfer-film into the bowl and then wait 1 minute
- Spray the activator consistent and laminar onto the water-transfer-film with the SATA spray gun.
- Dip the painted tract now into the water through the water-transfer-film
- Take the coated tract out of the water and clean it with a water sprinkler
- Concluding you have to cover the dried tract with a 2K clear paint to protect the pattern

Preparation of the tracts you have to coat

The tracts you have to coat have to be free from water soluble particles and they may not have any water sensitive exhibits like electronics because the tracts have to be dipped into the water-transfer-bowl.

Tracts from cars or other tracts have to be developed, from mobile phones you have to detach the cover of the electronics.

The tracts need to be cleaned and degreased or rather be edited with plastic etch primer.

Concluding you have to cover the tracts with WT-Direct 1 K basecoat. As paint color choose the base color of the pattern you have to apply. For example brown for a wood grain, grey for cut aluminum or black for a dark carbon-look.

The tracts have to be absolutely dry and greaseless before you coat them with film.

Activator

You have to fill the activator functional into the SAT MINIJET 1,0 SR or rather SATA JET 3000 HVLP 1,0. The amount of the activator variegates a little bit from film to film and also it depends a bit to the room temperature.

Preparation of the bowl

Fill the water-transfer-print-bowl with normal tap water till the brink of the overflow. Put on the heater of the bowl and make sure that the water has a constant temperature around 26°C - 27°C.

Preparation of the film

Cut out enough film for the tract you want to coat. Keep in mind that there need to be enough film that the film is able to cover all rough edges and cavities of the tract.

First put the film onto a straightly and clean area.

Tip: Cut the film in a distance of circa 3 cm in a 45° angle so that the film can't convolve when he is inlaid into the bowl. The film has to lay on the water with the glue-side.

Coating the tracts

Apply the film on the water surface now. Lay the film on the water with the glue-side. (Important!) Keep in mind that the water surface is calm. By light blowing with your mouth onto the floating film you will achieve a wave less, wrinkle-free and air hole free overlie of the film on the water.

Now you can see that the film is rolling in at the border which you can circumvent with the cut in. Exactly after one minute you applied the film on the water, you have to spray the activator consistent and laminar with the SATA spraying gun on it. Keep the SATA spraying gun in a distance of ca. 20 - 30cm to the film. Do not take too much activator because the film should only be fogged. After the spraying you have ca. 30 seconds to convert the film.

After the spraying with activator the film expands as you can see pretty well.

Now dip the tract directly after the spraying in a crude 45° angle slowly and calm into the film.

After the tract was completely under water, pull it out of the bowl.

Information:

It is very important to dip the tract consistent into the bowl through the film. By infiltration of the tract into the water by hand a bucking could be possible because the resistance of the water is not consistent, particularly when the tracts got vents or holes. It is advisable to paste them from behind. In that case it is advisable to use a dipping-arm who makes sure a consistent dipping into the water.

The film does not stick on itself. Therefore it is possible to dip the tract twice in special circumstances.

Cleaning the tracts

Now clean the tract with the sprinkler to remove the remaining film. In no case you should use a normal water tap or a high pressure water jet because both will corrode the recent applied film. You will achieve the best result when the water jet has got a temperature of 27°C.

Best clean the tracts directly after the dipping.

Completion of the tracts / Clear coat

When the coated tracts are dry, you have to apply the base coat depending on the coated tract. Through this the coat will be very abrasion-resistant.

Cleaning the water

After every workday please skim the film-leftovers, which are floating on the water surface with a water strainer. You don't have to skim the film-leftovers on the bottom of the bowl. They don't bother.

Also you do not have to change water if you want to apply different pattern on several tracts one after another. Skimming the water surface is absolute enough.

Typical problems - and how you can avoid them

Problem: The film abrogates directly after applying onto the water surface.

Reason: The film is laying on the water with the wrong side. The film has to lay on the water with the glue-side.

Problem: The film is not vouching on the surface.

Reason: The underground is not greaseless or not coated.

If you have got any further questions, don't hesitate to contact us.

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