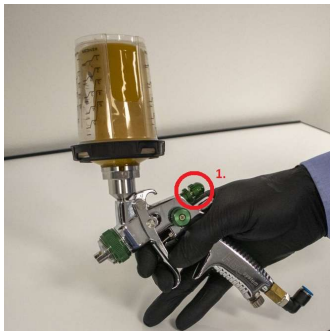
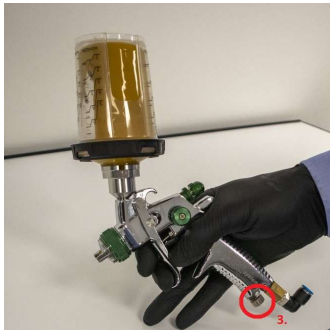
Wheel Paint machine

- Ideal object temperature is 20 degrees Celsius / 70 degrees Fahrenheit.
- Ideal paint temperature (Aerosol) is 30 degrees Celsius / 80 degrees Fahrenheit.
- Mixing ratio WP300 Wheel Paint system is 1:1 or 2:1 with thinner, as indicated in the formular
- Mixing ratio S534 Syrox is 5:1 with S940 basecoat thinner
- Wheel Paint system 998 is ready to use
- Mixing ratio of the 840P Diamond Cut Clearcoat is 5:1 plus 50% thinner. E.g., 100 grams Clearcoat, 20 grams of hardener, 50 grams Thinner
- Mixing ratio of the UV Clear coat: ready to use
- Mixing ratio of the 845 Diamond cut clear coat is: 1:1:1 e.g. 50 parts of 842 Clear coat, 50 parts of 844 Activator, 50 parts of 843 Thinner

Paint Gun settings

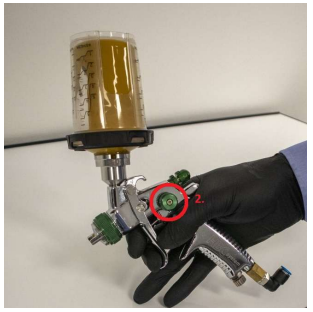


Opening of the trigger (#1.) of the paint gun is set to 3 MM.



Air inlet (#2.) is fully opened.

Fan pattern: Air cap (#3.) is fully opened



Operating pressure when using the paint gun is 2 bar

Paint settings Color

- WP300 Base coat (solvent color):
  - 2 Coats
  - Flash-off time between coats: 4 min.
  - Flash-off time after 2nd coat; 10 min.
- S534 Syrox Base coat (waterborne colors):
  - 2,5 coats; 2 full coats, 1 fast coat
  - Flash-off time between coats; 5 min. (until matt)
  - Flash-off time after last coat; 10 min. (until matt)
- 998 Alloy Wheel Paint (waterborne colors, ready mixed)
  - 2 coats
  - Flash-off time between coats: 5 min. (until matt)
  - Flash-off time after 2nd coat: 10 min. (until matt)

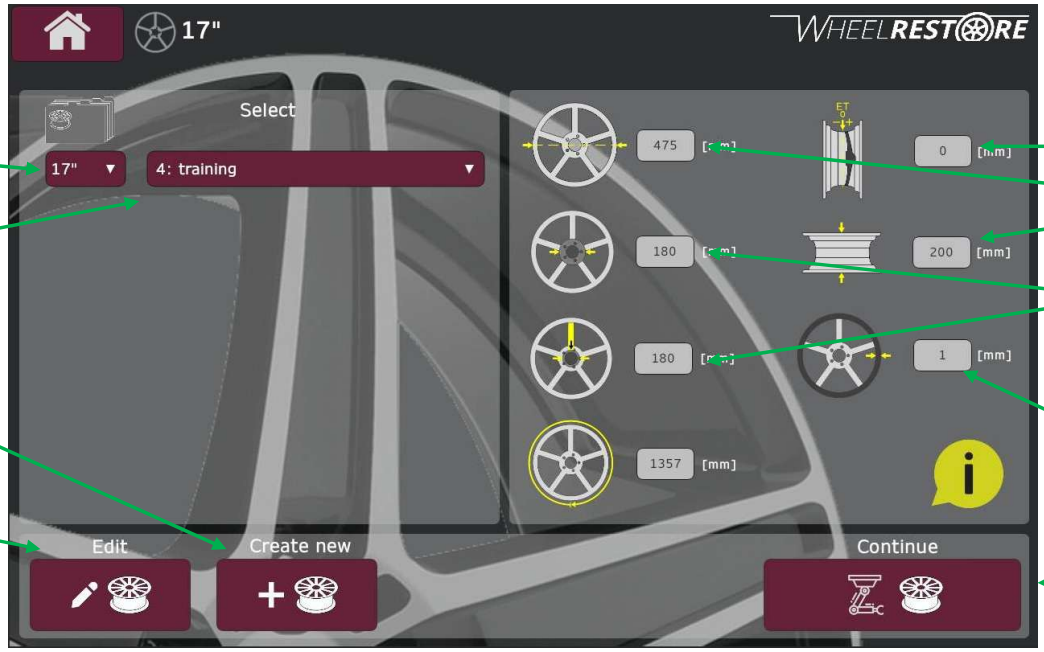
Paint settings Color

- 846 – 847 - 848 Wheel Paint 3 in 1 product (Solvent color):
  - 2-3 Coats (depending on coverage)
  - Flash-off time between coats: 4 min.
  - Flash-off time after 2nd coat; 5 min.

Paint settings Clear Coat

- 845 Diamond Cut Clear coat:
  - 2 Coats
  - Flash-off time between coats; 2 min.
  - Flash-of time after 2nd coat; 5 min.
  - Curing time by IR lamp 15 - 20 min. (object temperature 60oC.)
- 840P Diamond Cut Clear Coat:
  - 2 Coats
  - Flash-off time between coats; 5 min.
  - Flash-of time after 2nd coat; 5 min.
  - Curing time by IR lamp 15 - 20 min. (object temperature 60oC.)
- 881 UV Clear Coat:
  - 2 Coats
  - Flash-off time between coats: 3 min.
  - Flash-off time after 2nd coat: 5 min.
  - Curing time by UV lamp: 5 min.

Wheel data



Enter wheel size

Select saved wheel

Create a new wheel if not saved

Edit saved wheel

Enter ET

Enter outer wheel diameter

Enter wheel width

Enter center diameter:

If PCD is ≤ 120 -> enter 180mm

If PCD is ≥ 120 -> enter 200mm

Both values should be the same!

Wheel edge width default set to 1 mm

Once data is entered click here

Paint selection, robot and paint settings

1. Select primer, color and/or clearcoat

2. Click to edit the settings

3. Click to select the product and activate/edit the settings

4. Click to confirm

5. Click here to go to Robot and Paint settings

6. Click here to go to Robot and Paint settings

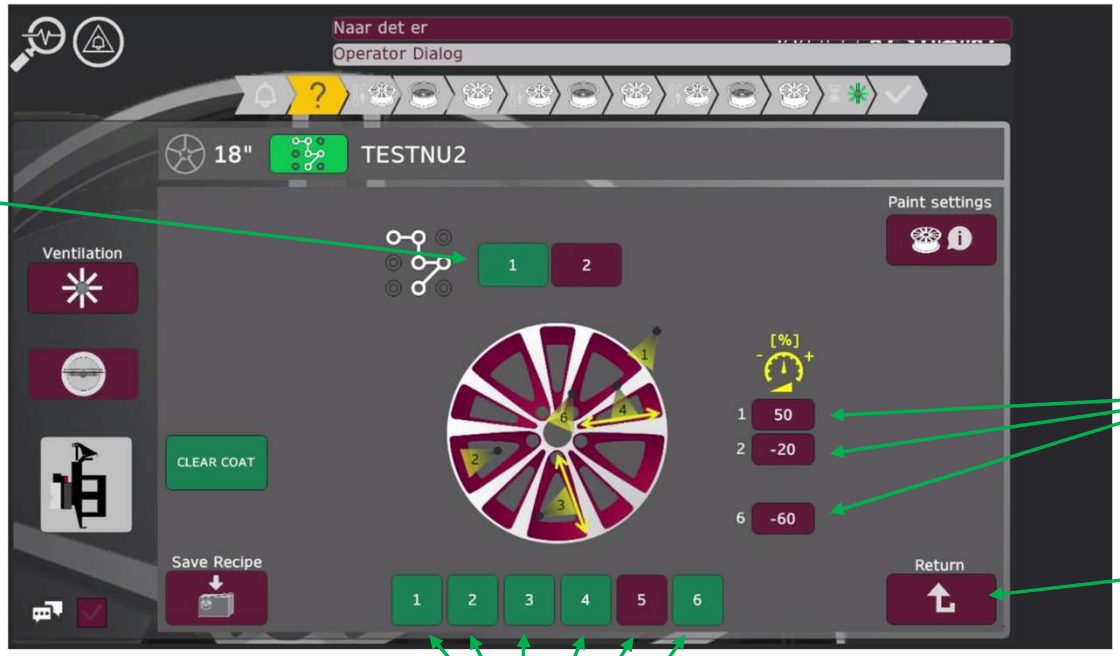
7. Click here to edit the robot and paint settings

8. Click here to go back

Robot settings

Select paint pattern

(default is pattern 1)



Select higher (+) of slower (-) speed on the selected paint direction

Click here to go back

Select paint directions

*If painting direction 6 is activated the diameter of the center cap must be adjusted (see next slide)

Wheel dimensions & Paintgun settings

Click here to edit

If painting direction 6 is activated the diameter of the center cap must be the same value as the outer center diameter
If PCD is ≤ 120 -> enter 180mm
If PCD is ≥ 120 -> enter 200mm

Set inner height to 20mm

Set inner angle to 15

Set outer angle to 15

Click here to go back

Click here to save the profile on this wheel

Set this value to -10 to get more paint on the outer edge (flat surface)

Click here to change the robot speed while painting the first (fast) coat and the second (full) coat. First coat set to 500, second coat set to 300