

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, depending on formula
- 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

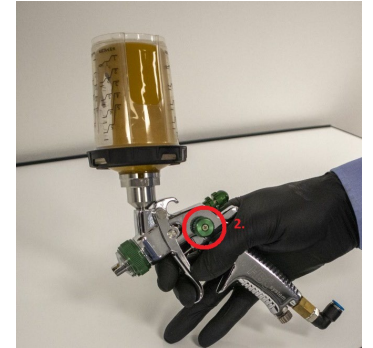


Opening of the trigger (#1.) of the paint gun is set to 3 MM.



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

The screenshot shows the 'Wheel data' input screen of the Wheel Restore software. The interface includes a top navigation bar with a home icon, a wheel size selector set to '18"', and a title bar 'Naar det er Operator Dialog'. The main area is titled 'Select' and features a dropdown menu showing '4: TESTNU2'. Below this, there are four wheel icons with associated numerical inputs: 498 [mm], 165 [mm], 165 [mm], and 1437 [mm]. To the right of these are three more inputs: 1 [mm], 225 [mm], and 0 [mm]. At the bottom, there are three buttons: 'Edit' (with a pencil icon), 'Create new' (with a plus icon), and 'Continue' (with a wheel icon). A yellow information icon is also present. Green arrows point from text labels to specific UI elements.

Enter wheel size

Select saved wheel

Create a new wheel if not saved

Edit saved wheel

Wheel edge width default set to 1 mm

Enter outer wheel diameter

Enter wheel width

Enter outer center diameter (where spokes stop)

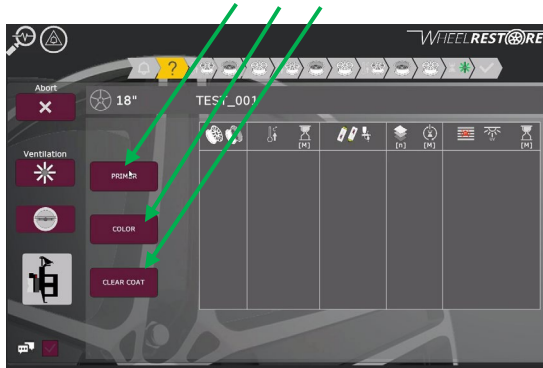
Enter ET

Enter center diameter (center cap)

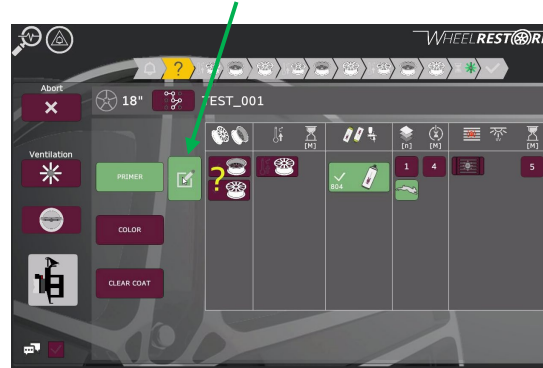
Once data is entered click here

Paint selection, robot and paint settings

1. Select primer, color and/or clearcoat



2. Click to edit the settings

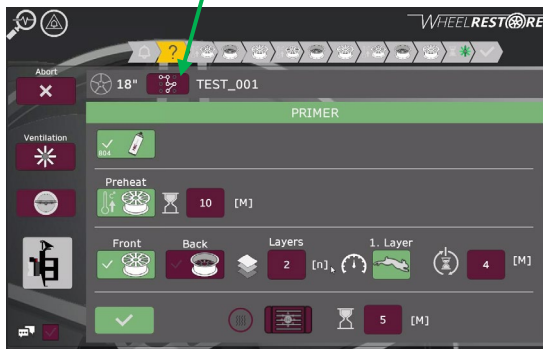


3. Click to select the product and activate/edit the settings

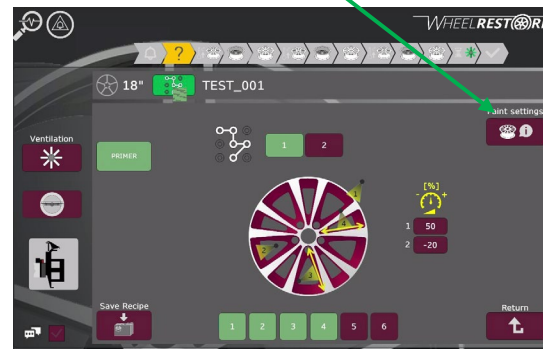


4. Click to confirm

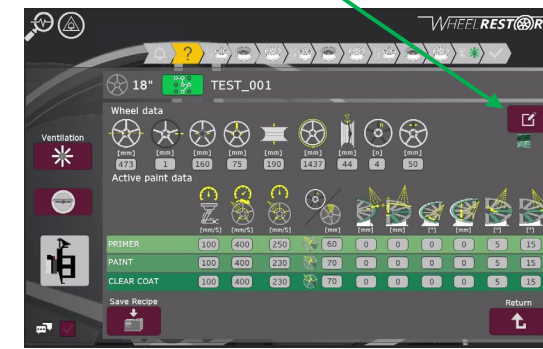
5. Click here to go to Robot and Paint settings



6. Click here to go to Robot and Paint settings

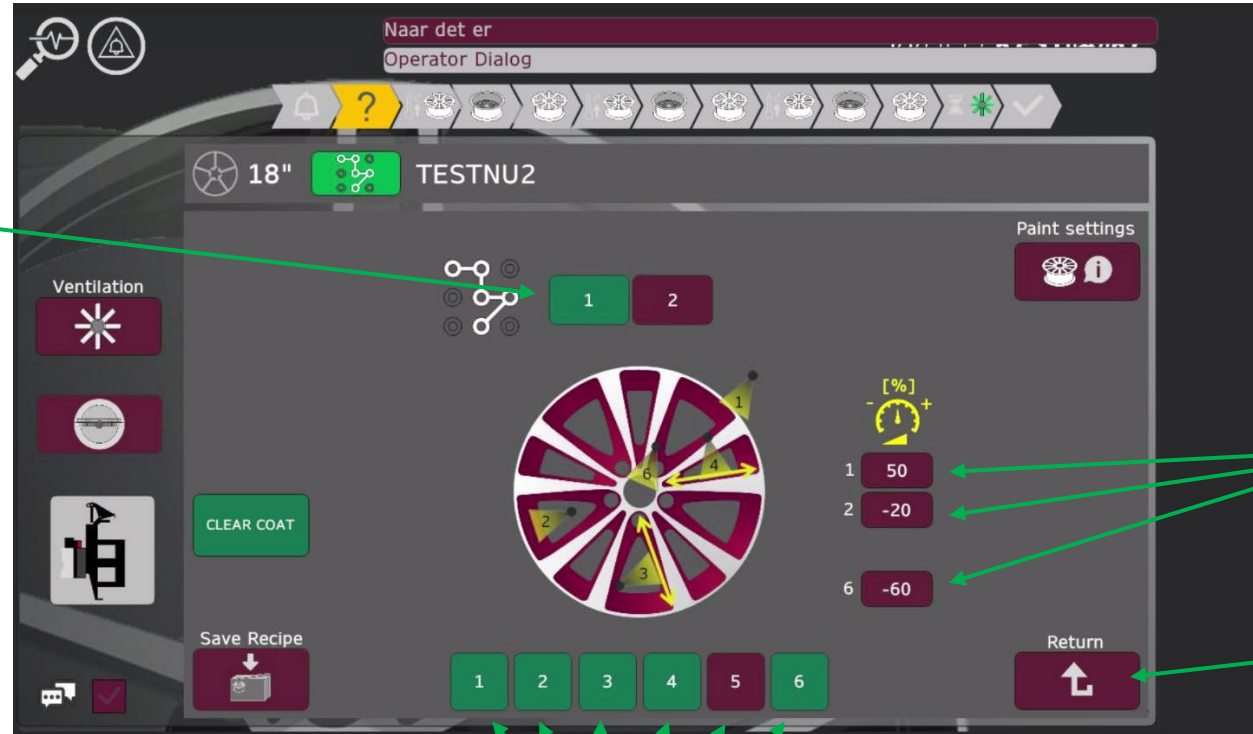


7. Click here to edit the robot and paint settings



8. Click here to go back

Robot settings



Select paint pattern
(default is pattern 1)

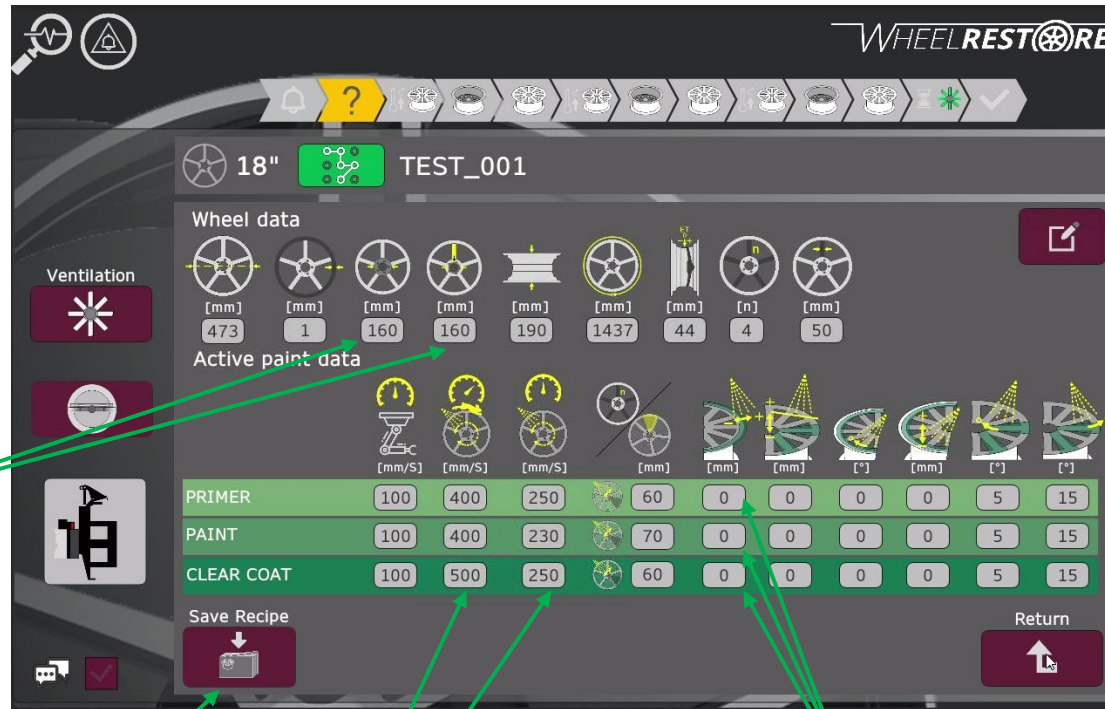
Select higher (+) or slower (-) speed on
the selected paint direction

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 changed to the same value as the outer center diameter

[Click here to go back](#)

[Click here to save the profile on this wheel](#)

Change 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.