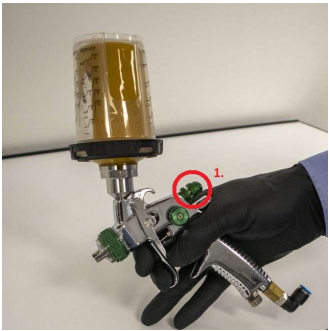


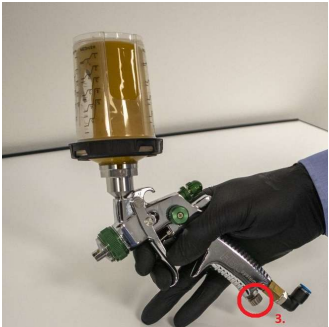
Wheel Paint machine

- 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

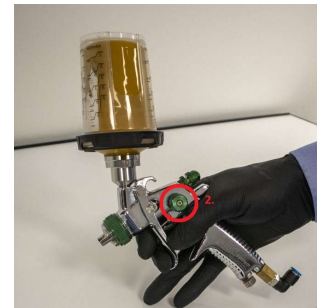
Paint Gun settings



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

The screenshot shows the WHEELRESTORE app interface. At the top, there is a home icon and a wheel size selector set to 17". Below this is a 'Select' section with a folder icon and a dropdown menu showing '4: training'. To the right of the 'Select' section is a 'Create new' button with a plus icon and a wheel icon. Below these are three buttons: 'Edit' (pencil icon), 'Create new' (plus icon), and 'Continue' (wrench icon). The main area displays a list of wheel options with their respective PCD values: 475 [mm], 180 [mm], 180 [mm], and 1357 [mm]. To the right of the wheel options are input fields for ET (0 [mm]), outer wheel diameter (200 [mm]), wheel width (200 [mm]), center diameter (1 [mm]), and a yellow information icon. Annotations with green arrows point to various elements: 'Enter wheel size' points to the 17" selector; 'Select saved wheel' points to the '4: training' dropdown; 'Create a new wheel if not saved' points to the 'Create new' button; 'Edit saved wheel' points to the 'Edit' button; 'Enter ET' points to the ET input field; 'Enter outer wheel diameter' points to the outer wheel diameter input field; 'Enter wheel width' points to the wheel width input field; 'Enter center diameter: If PCD is ≤ 120 -> enter 180mm If PCD is ≥ 120 -> enter 200mm Both values should be the same!' points to the center diameter input field; 'Wheel edge width default set to 1 mm' points to the center diameter input field; and 'Once data is entered click here' points to the 'Continue' button.

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

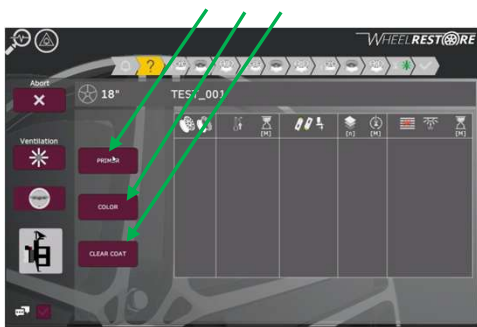
Enter center diameter:
If PCD is ≤ 120 -> enter 180mm
If PCD is ≥ 120 -> enter 200mm
Both values should be the same!

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

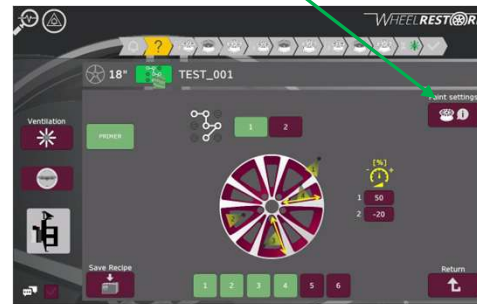


4. Click to confirm

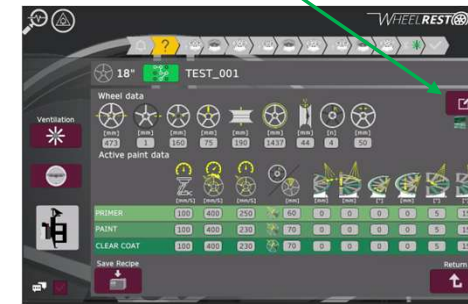
5. Click here to go to Robot and Paint settings



6. Click here to go to Robot and Paint settings



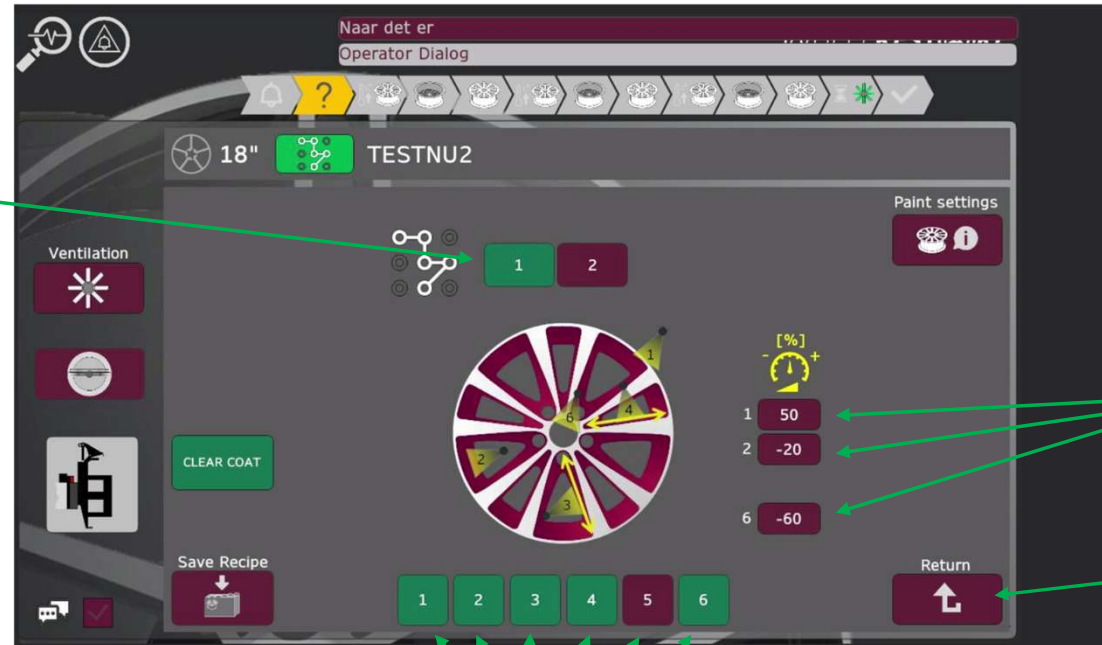
7. Click here to edit the robot and paint settings



8. Click here to go back

Robot settings

Select paint pattern
(default is pattern 1)



Select higher (+) 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



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

[Click here to edit](#)

✓ 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