

General Clearcoating Guidelines

BDESIGNS has no control over your decal and/or paint application and therefore takes no responsibility for any losses or personal injury of any kind, incurred by you or any other party. If you are not experienced in decal application or automotive finishing, we recommend a local professional shop(s) apply the decals and/or automotive finishes. For decals, it is highly recommended you use an installer who is experienced in motorcycle decal application.

READ DIRECTIONS THOROUGHLY BEFORE STARTING

WARNING!

Wear appropriate PPE (Personal Protective Equipment) for working with finishing materials. See MSDS information for the paint products you purchased. You must follow all safety guidelines, warnings and recommendations when working with any type of finishing material. Do not work with finishing materials indoors. Work only in approved finishing environments with proper ventilation. Finishing materials are toxic and explosive!

Tools and Material Required

- Only use high quality PPG Acrylic Urethane clear coat finish. We have not tested any other manufacturer's clear coat product. If you use a PPG competitors' product, it is **your** responsibility to ensure it is an equivalent product. Base coat products must also be compatible with the clearcoat finish. **Do not use any type of spray can paint, lacquer paint, enamel paint, etc. The solvents are too harsh in these products and may damage the decals.**
- Hardener(s) and reducer(s)
- Paint filters, measuring cups, solvents for cleanup (can use the reducer mentioned above), masking tape if required, etc.
- 800 or 1000 or 1200 grit wet sandpaper (see instructions below for clarification of grits).
- An ammonia based cleaner such as Windex
- Vinyl gloves so you don't get fingerprint "grease" on the application areas.

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Most if not all, motorcycle OEM's clear coat their decals on fuel tanks to prevent fuel spillage from attacking the graphics adhesive backing and colouring, so we recommend that you to clear coat any decals that may be subjected to fuel spillage. Some manufacturers clear coat over all decals. Individual bike model instruction sheets will specify that, but you can clearcoat over all decals if you wish to. It will greatly extend the life of the decals.

The steps below are only a guideline to follow after your parts are primed and ready for painting. Not all body shops use exactly the same methods. **The choice of method, application of decals and finish and responsibility of a quality outcome belongs to your painter.**

Procedures

1. Paint base coat color(s).
2. Apply two layers of clear coat to bond to the base coat colour as per the application, times and specifications of the finishing product.
3. Allow at least a week for proper curing time before installing decals. Paint will off-gas as it cures, and can attack the adhesive backing of the decals. The off-gassing **may** also cause small bubbles to appear after the decal has been applied. Paint cure times can vary depending on air moisture content, temperature, paint chemical composition and how much hardener is used. Professional painters use more or less hardener in the paint to speed or slow the cure time.
4. Wet sand the entire clear coated surface to create the proper surface for bonding of the decals and final clearcoating application. You need to get rid of any clear coat gloss, but make sure not to sand through the clear coat. Be very careful on edges, corners or other irregular areas. Use 800 or 1000 or 1200 grit wet sandpaper which will allow for proper bonding of subsequent clear coats. **The selection of the previously mentioned grit is up to the discretion of your painter – whatever they are comfortable with.** Remember that 800 grit is more aggressive and you can sand through faster and hit the basecoat – something you do not want to do! 1200 grit is less aggressive, but will take

longer to sand. If any decals that are being applied have a clear backing, the finer 1200 grit is recommended. Again, be careful not to sand through.

5. Read our "General Decal Application" instructions for materials and procedures to clean surfaces and install the decals
6. Clean surface again after decal application using an ammonia based cleaner such as "Windex. Use vinyl gloves when cleaning and handling to prevent finger print "grease" contamination.
7. Spray on your final clear coat layers to completely cover entire bodywork surface and decals. Take care when laying down multiple coats of clear. Ideally, spray one overall thin coat for your first coat. Check your material specs for time between coats as per application specifications, and then finish with the second heavier coat of clear coat. Generally, you should not apply more than the equivalent of 2 heavy, or 3 moderate coats of clear during the same application day. If you need more coats of clear, wait 2 days, wet sand as per above and then apply up to 2 more coats. Too much clear coat in one application day is a bad thing. However, your painter may apply two thin and one heavy coat, or one thin and two moderate coats, or 3 moderate coats in one day. The number and "weight" of coats is **entirely** up to your painter and their experience – whatever they are comfortable and experienced with. Again, the choices of application and responsibility of a quality outcome, is your painters'.
8. Let fully cure for at least 3 days before putting the part back in service.