

# **SIM** **Paint and Material Settings**

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# SIM Spray® Paint and Material Settings

## Paint - HVLP:

<b>Name:</b>	VRSim HVLP Primer				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	30.5 - 63.5 µm		
<b>Viscosity:</b>	40 Centistoke	<b>% Solids:</b>	40	<b>Flash Time:</b>	15 minutes
<b>Application:</b>	<b>Distance:</b>	18 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.7 BAR	<b>Fluid Pressure:</b>	N/A	
<b>Recommended Tip(s):</b>	1.2				

<b>Name:</b>	VRSim HVLP Color				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	30.5 - 63.5 µm		
<b>Viscosity:</b>	40 Centistoke	<b>% Solids:</b>	40	<b>Flash Time:</b>	15 minutes
<b>Application:</b>	<b>Distance:</b>	18 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.7 BAR	<b>Fluid Pressure:</b>	N/A	
<b>Recommended Tip(s):</b>	1.2				

<b>Name:</b>	VRSim HVLP Clear				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	30.5 - 63.5 µm		
<b>Viscosity:</b>	40 Centistoke	<b>% Solids:</b>	40	<b>Flash Time:</b>	15 minutes
<b>Application:</b>	<b>Distance:</b>	18 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.7 BAR	<b>Fluid Pressure:</b>	N/A	
<b>Recommended Tip(s):</b>	1.2				



# SIM Spray® Paint and Material Settings

## Paint - Airless:

<b>Name:</b>	VRSim Airless Primer				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	76.2 - 152.4 µm		
<b>Viscosity:</b>	1500 Centistoke	<b>% Solids:</b>	40	<b>Flash Time:</b>	15 minutes
<b>Application:</b>		<b>Distance:</b>	33 cm	<b>Speed:</b>	Normal
<b>Equipment:</b>		<b>Air Pressure:</b>	N/A	<b>Fluid Pressure:</b>	124.1 - 158.6 BAR
<b>Recommended Tip(s):</b>		517			

<b>Name:</b>	VRSim Airless Color				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	76.2 - 152.4 µm		
<b>Viscosity:</b>	1500 Centistoke	<b>% Solids:</b>	40	<b>Flash Time:</b>	15 minutes
<b>Application:</b>		<b>Distance:</b>	33 cm	<b>Speed:</b>	Normal
<b>Equipment:</b>		<b>Air Pressure:</b>	N/A	<b>Fluid Pressure:</b>	124.1 - 158.6 BAR
<b>Recommended Tip(s):</b>		517			

<b>Name:</b>	VRSim Airless Clear				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	76.2 - 152.4 µm		
<b>Viscosity:</b>	1500 Centistoke	<b>% Solids:</b>	40	<b>Flash Time:</b>	15 minutes
<b>Application:</b>		<b>Distance:</b>	33 cm	<b>Speed:</b>	Normal
<b>Equipment:</b>		<b>Air Pressure:</b>	N/A	<b>Fluid Pressure:</b>	124.1 - 158.6 BAR
<b>Recommended Tip(s):</b>		517			

## Paint - Air-Assisted Airless:

<b>Name:</b>	VRSim AAA Primer				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	63.5 - 127 µm		
<b>Viscosity:</b>	1500 Centistoke	<b>% Solids:</b>	40	<b>Flash Time:</b>	15 minutes
<b>Application:</b>	<b>Distance:</b>	28 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.8 BAR	<b>Fluid Pressure:</b>	55.2 - 82.7 BAR	
<b>Recommended Tip(s):</b>	517				

<b>Name:</b>	VRSim AAA Color				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	63.5 - 127 µm		
<b>Viscosity:</b>	1500 Centistoke	<b>% Solids:</b>	40	<b>Flash Time:</b>	15 minutes
<b>Application:</b>	<b>Distance:</b>	28 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.8 BAR	<b>Fluid Pressure:</b>	55.2 - 82.7 BAR	
<b>Recommended Tip(s):</b>	517				

<b>Name:</b>	VRSim AAA Clear				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	63.5 - 127 µm		
<b>Viscosity:</b>	1500 Centistoke	<b>% Solids:</b>	40	<b>Flash Time:</b>	15 minutes
<b>Application:</b>	<b>Distance:</b>	28 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.8 BAR	<b>Fluid Pressure:</b>	55.2 - 82.7 BAR	
<b>Recommended Tip(s):</b>	517				



# SIM Spray® Paint and Material Settings

## Aerospace:

<b>Name:</b>	Chromate Free Epoxy Primer				
<b>Process(es):</b>	HVLP				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	38.1 - 76.2 µm		
<b>Viscosity:</b>	20 Centistoke	<b>% Solids:</b>	43	<b>Flash Time:</b>	2 hours
<b>Application:</b>	<b>Distance:</b>	18 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.7 BAR	<b>Fluid Pressure:</b>	N/A	
<b>Recommended Tip(s):</b>	1.2				

<b>Name:</b>	Polyester Urethane				
<b>Process(es):</b>	HVLP				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	50.8 - 88.9 µm		
	2	<b>Coat Thickness:</b>	50.8 - 88.9 µm		
<b>Viscosity:</b>	20 Centistoke	<b>% Solids:</b>	43	<b>Flash Time:</b>	3 hours
<b>Application:</b>	<b>Distance:</b>	18 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.7 BAR	<b>Fluid Pressure:</b>	N/A	
<b>Recommended Tip(s):</b>	1.2				

## Automotive:

<b>Name:</b>	Urethane Primer				
<b>Process(es):</b>	HVLP				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	25.4 - 50.8 µm		
	2	<b>Coat Thickness:</b>	25.4 - 50.8 µm		
<b>Viscosity:</b>	70 Centistoke	<b>% Solids:</b>	38	<b>Flash Time:</b>	15 minutes
<b>Application:</b>	<b>Distance:</b>	18 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.7 BAR	<b>Fluid Pressure:</b>	N/A	
<b>Recommended Tip(s):</b>	1.2				

<b>Name:</b>	Urethane Base				
<b>Process(es):</b>	HVLP				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	38.1 - 76.2 µm		
	2	<b>Coat Thickness:</b>	38.1 - 76.2 µm		
<b>Viscosity:</b>	70 Centistoke	<b>% Solids:</b>	40	<b>Flash Time:</b>	30 minutes
<b>Application:</b>	<b>Distance:</b>	18 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.7 BAR	<b>Fluid Pressure:</b>	N/A	
<b>Recommended Tip(s):</b>	1.2				

<b>Name:</b>	High Solids Urethane Clearcoat				
<b>Process(es):</b>	HVLP				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	50.8 - 88.9 µm		
	2	<b>Coat Thickness:</b>	50.8 - 88.9 µm		
<b>Viscosity:</b>	35 Centistoke	<b>% Solids:</b>	35	<b>Flash Time:</b>	30 minutes
<b>Application:</b>	<b>Distance:</b>	18 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.7 BAR	<b>Fluid Pressure:</b>	N/A	
<b>Recommended Tip(s):</b>	1.2				

## Building Trades:

<b>Name:</b>	Interior-Exterior Primer				
<b>Process(es):</b>	Airless				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	88.9 - 139.7 µm		
<b>Viscosity:</b>	1000 Centistoke	<b>% Solids:</b>	43	<b>Flash Time:</b>	30 minutes
<b>Application:</b>	<b>Distance:</b>	30 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	N/A	<b>Fluid Pressure:</b>	165.5 - 206.9 BAR	
<b>Recommended Tip(s):</b>	517				

<b>Name:</b>	Interior-Exterior Latex				
<b>Process(es):</b>	Airless				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	76.2 - 127 µm		
	2	<b>Coat Thickness:</b>	76.2 - 127 µm		
<b>Viscosity:</b>	1200 Centistoke	<b>% Solids:</b>	47	<b>Flash Time:</b>	1 hour
<b>Application:</b>	<b>Distance:</b>	30 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	N/A	<b>Fluid Pressure:</b>	165.5 - 206.9 BAR	
<b>Recommended Tip(s):</b>	517				

<b>Name:</b>	Urethane Acrylic Primer				
<b>Process(es):</b>	Air-Assisted Airless				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	63.5 - 127 µm		
<b>Viscosity:</b>	1800 Centistoke	<b>% Solids:</b>	32	<b>Flash Time:</b>	15 minutes
<b>Application:</b>	<b>Distance:</b>	28 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.8 BAR	<b>Fluid Pressure:</b>	55.2 - 82.7 BAR	
<b>Recommended Tip(s):</b>	517				



# SIM Spray® Paint and Material Settings

<b>Name:</b>	Urethane Enamel				
<b>Process(es):</b>	Air-Assisted Airless				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	50.8 - 101.6 µm		
	2	<b>Coat Thickness:</b>	50.8 - 101.6 µm		
<b>Viscosity:</b>	1600 Centistoke	<b>% Solids:</b>	30	<b>Flash Time:</b>	15 minutes
<b>Application:</b>		<b>Distance:</b>	28 cm	<b>Speed:</b>	Normal
<b>Equipment:</b>		<b>Air Pressure:</b>	0.5 - 0.8 BAR	<b>Fluid Pressure:</b>	55.2 - 82.7 BAR
<b>Recommended Tip(s):</b>		517			



## Furniture & Cabinetry:

<b>Name:</b>	Urethane Acrylic Primer				
<b>Process(es):</b>	Air-Assisted Airless				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	63.5 - 127 µm		
<b>Viscosity:</b>	1800 Centistoke	<b>% Solids:</b>	32	<b>Flash Time:</b>	15 minutes
<b>Application:</b>	<b>Distance:</b>	28 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.8 BAR	<b>Fluid Pressure:</b>	55.2 - 82.7 BAR	
<b>Recommended Tip(s):</b>	517				

<b>Name:</b>	Urethane Enamel				
<b>Process(es):</b>	Air-Assisted Airless				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	50.8 - 101.6 µm		
	2	<b>Coat Thickness:</b>	50.8 - 101.6 µm		
<b>Viscosity:</b>	1600 Centistoke	<b>% Solids:</b>	30	<b>Flash Time:</b>	15 minutes
<b>Application:</b>	<b>Distance:</b>	28 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.8 BAR	<b>Fluid Pressure:</b>	55.2 - 82.7 BAR	
<b>Recommended Tip(s):</b>	517				

<b>Name:</b>	Wood Stain				
<b>Process(es):</b>	HVLP				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	25.4 - 88.9 µm		
<b>Viscosity:</b>	65 Centistoke	<b>% Solids:</b>	32	<b>Flash Time:</b>	15 minutes
<b>Application:</b>	<b>Distance:</b>	18 cm	<b>Speed:</b>	Normal	
<b>Equipment:</b>	<b>Air Pressure:</b>	0.5 - 0.7 BAR	<b>Fluid Pressure:</b>	N/A	
<b>Recommended Tip(s):</b>	1.2				



# SIM Spray® Paint and Material Settings

<b>Name:</b>	Oil Based Polyurethane				
<b>Process(es):</b>	HVLP				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	30.5 - 63.5 µm		
	2	<b>Coat Thickness:</b>	30.5 - 63.5 µm		
<b>Viscosity:</b>	90 Centistoke	<b>% Solids:</b>	50	<b>Flash Time:</b>	1 hour
<b>Application:</b>		<b>Distance:</b>	18 cm	<b>Speed:</b>	Normal
<b>Equipment:</b>		<b>Air Pressure:</b>	0.5 - 0.7 BAR	<b>Fluid Pressure:</b>	N/A
<b>Recommended Tip(s):</b>		1.2			



# SIM Spray® Paint and Material Settings

## Structural:

<b>Name:</b>	Industrial Urethane Primer				
<b>Process(es):</b>	Airless				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	63.5 - 127 µm		
<b>Viscosity:</b>	130 Centistoke	<b>% Solids:</b>	53	<b>Flash Time:</b>	15 minutes
<b>Application:</b>		<b>Distance:</b>	33 cm	<b>Speed:</b>	Normal
<b>Equipment:</b>		<b>Air Pressure:</b>	N/A	<b>Fluid Pressure:</b>	124.1 - 158.6 BAR
<b>Recommended Tip(s):</b>		517			

<b>Name:</b>	Acrylic Polyurethane				
<b>Process(es):</b>	Airless				
<b>Coat(s):</b>	1	<b>Coat Thickness:</b>	76.2 - 152.4 µm		
	2	<b>Coat Thickness:</b>	76.2 - 152.4 µm		
<b>Viscosity:</b>	300 Centistoke	<b>% Solids:</b>	57	<b>Flash Time:</b>	15 minutes
<b>Application:</b>		<b>Distance:</b>	33 cm	<b>Speed:</b>	Normal
<b>Equipment:</b>		<b>Air Pressure:</b>	N/A	<b>Fluid Pressure:</b>	124.1 - 158.6 BAR
<b>Recommended Tip(s):</b>		517			



# SIM Spray® Paint and Material Settings

## Blast:

<b>Name:</b>	VRSim Garnet			
<b>Process(es):</b>	Abrasive Blasting			
<b>Blast Rate:</b>	Moderate			
<b>Application:</b>	<b>Distance:</b>	53 cm	<b>Angle Range:</b>	15 - 45°

<b>Name:</b>	VRSim Plastic			
<b>Process(es):</b>	Abrasive Blasting			
<b>Blast Rate:</b>	Low			
<b>Application:</b>	<b>Distance:</b>	53 cm	<b>Angle Range:</b>	15 - 45°

<b>Name:</b>	VRSim Sodium Bicarbonate			
<b>Process(es):</b>	Abrasive Blasting			
<b>Blast Rate:</b>	Low			
<b>Application:</b>	<b>Distance:</b>	53 cm	<b>Angle Range:</b>	15 - 45°

<b>Name:</b>	VRSim Steel			
<b>Process(es):</b>	Abrasive Blasting			
<b>Blast Rate:</b>	High			
<b>Application:</b>	<b>Distance:</b>	53 cm	<b>Angle Range:</b>	15 - 45°



# SIM Spray® Paint and Material Settings

## Powder:

<b>Name:</b>	VRSim Powder			
<b>Process(es):</b>	Powder Coating			
<b>Powder Delivery:</b>	50 - 60%	<b>Coat Thickness:</b>	50.8 - 101.6 $\mu\text{m}$	
<b>Application:</b>	<b>Distance:</b>	25 cm	<b>Total Air:</b>	50 - 60 $\text{Nm}^3/\text{h}$
	<b>Current:</b>	60k - 70k $\mu\text{A}$	<b>Voltage:</b>	65 kV