

Finishing - Process Formulation



AUTO.1 MARZIALE ACLE 2026_FI.xlsx

Date: 2026.07.09

Technician:

Customer ACLE 2026 Project - N°:

Type of Leather: Automotive Leather Score: ● ● ● ● ●

Article: Smooth grain leather平纹 Trial - N°: F26236 A

Aim of Trial: No.1 MARZIALE Ultra-low BPF/BPS leather article超低双酚皮革 Color: red红色

Crust Material: T 26236A crust Piece Count: 3

Marking:

Type of Coat Stucco 补伤 Pre-Ground 预底涂 Base Coat 底涂 Hybrid Coat 半顶光 Top Coat 顶涂

Trial Tag:

PRODUCT TC 1808 1000

RODA® Care 1801 850

RODA® Ground 1401 150

Water水 70 100 130

EUDERM® Matt SN-C 90

EUDERM® Nappa Soft S2-A 80

RODA® Base 5103-A 290

RODA® CRYL1230 150

BAYDERM® Bottom ELW 180

EUDERM® Prebottom FGI 20

RODA® Lite pigment 07 颜料膏 113 110 10

AQUADERM® Additive XF 7 50

AQUADERM® MATT ID103 300

AQUADERM® MATT 102 200

RODA® PUR 1600 50

AQUADERM® FINISH QS 60

AQUADERM® Fluid H 10 10

OPTI-MATT™ UD4 Duller 300

RODA® Fix SR 04 300

AQUADERM® FINISH HW2/N 80

AQUADERM® Additive XF 20

AQUADERM® Additive SF 20 30

AQUADERM® Additive GF 30

RODA® Feel N4 40

ACRYSOL™ RM 819W x x x

AQUADERM® XL50 100 120

Viscosity (DIN cup 4#) 45" 28" 26"

Application

Stucco补伤 Roller 21SS/ 30-35 grs/sqm, buff with 400# paper 21SS辊涂30-35g/平方米, 400#砂纸磨革

Pre-Ground预底涂 Roller 21SS/ 40-45 grs/sqm, mill, Sandblast @ 90°C / 60bar / 2 sec 21SS辊涂40-45g/平方米, 压砂板90度60bar2秒

Base Coat底涂 Roller 5NPL, 100-110 grs/sqm, stake, Sandblast @ 90°C / 120bar / 3 sec 5NPL辊涂100-110g/平方米, 振软, 压砂板90度120bar3秒

Hybrid Coat半顶光 Roller 3NPL, 35-40grs/sqm 3NPL辊涂35-40g/平方米

Top Coat顶涂 Spray x 1, 28-30grs/sqm, stake after overnight 喷一遍, 28-30g/平方米, 次日振软

Remarks

Our application recommendations are in line with our present state of knowledge. They do not, however, exempt the customer from performing his own tests to determine the suitability of the supplied products for their intended purposes. Application of the products lies outside the scope of our control and therefore comes within the customer's sphere of responsibility. We guarantee the satisfactory quality of our products subject to general terms of sale and delivery. Above data are based on the current state of knowledge. However, buyer is not released from his obligation to examine the material on receipt. Seller makes no warranty of merchantability or fitness for