



dobte®

TECHNICAL DATA SHEET



Dobte Automotive Refinish Series

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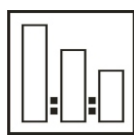
1-Stage Solid Colors

Product Description

Double component solid colors for repairing automotive finishes of spot, panel and overall repair.

Pre-treatment

Wet flat with P800-1000 grade paper or dry flat with P500-600 grade paper.
 Degrease with AK401
 Wash off residues and dry thoroughly.
 Re-clean with AK401. The use of a tack rag is recommended.



Mixing Ratio

Stir well before use. Twice per day for 15 mins on the mixing machine.

2 K Solid Colors 100 (vol) depending on color
AK260 Hardener 50 (vol)
AK321 Thinner 10-20 (vol)

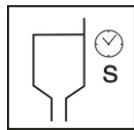
Mix well and strain before application.

Note: AK2601/AK3211 is for temperatures between 5°C-15°C

AK2602/AK3212 is for temperatures between 15°C-25°C

AK2603/AK3213 is for temperatures above 25°C

AK3214 Thinner is for temperatures above 35°C or when refinishing large surfaces.



Spray Viscosity

18 to 26 seconds DIN 4 cup at 25°C

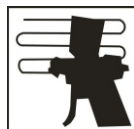
Potlife

4 hours at 25°C; 3 hours at 35°C



Spray Guns

HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm



Application

Apply topcoat over original stoved finishes or over AK700/AK1020 grey primers.

Number of spraycoats: 1 half wet + 1 wet coat

Flash-off: 10-20mins (Before Baking)

Film thickness: 40-60 µm



Drying

Drying	25°C	60°C
Dust free after	45 mins	5 mins
Ready for assembly after	6 hours	30 mins
Ready for polish after	24 hours	60 mins

Further Treatment

IR drying after flash-off time:

Step 1-short wave: 5 mins at a 80 cm distance

Step 2-medium wave: 20 mins at a 80 cm distance



Note

Polish after specified drying times and cooling.

1. Mix with Dobte series products to assure spray effect and paint performance.
2. Use different type of hardener & thinners as per different temperature.
3. Wear protective mask, glove and overall etc.

Basecoat 2c

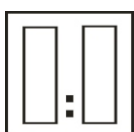
2-Stage Solid Colors

Product Description

Single component solid colors for repairing automotive 2-stage finishes of spot, panel and overall repair.

Pre-treatment

Wet flat with P1000-1200 grade paper or dry flat with P600-800 grade paper.
 Degrease with AK401
 Wash off residues and dry thoroughly.
 Re-clean with AK401. The use of a tack rag is recommended.



Mixing Ratio

Stir well before use. Twice per day for 15 mins on the mixing machine.

1K Solids 100 (vol) depending on color

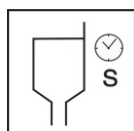
AK3211 (5°C-15°C)

AK3212 (15°C-25°C)

AK3213 (25°C-35°C)

AK3214 (>35°C) 100-120 (vol)

Mix well and strain before application.



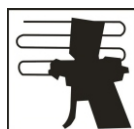
Spray Viscosity

16 to 22 seconds DIN 4 cup at 25°C



Spray Guns

HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm



Application

Apply basecoat over original stoved finishes or over AK700/AK1020 grey primers.

Number of spraycoats: 1 thin + 1 wet coat

Flash-off: 10-20mins

Film thickness: 15-20 µm

Further Treatment

After the flash-off, apply Dobte clear coat wet on wet.



Note

1. Mix with Dobte series products to assure spray effect and paint performance.
2. Use different type of thinners as per different temperature.
3. Wear protective mask, glove and overall etc.

Basecoat 2c

2-Stage Metallic Colors (Aluminum/Pearl/Crystal Pearl)

Product Description

Single component metallic colors for repairing automotive 2-stage finishes of spot, panel and overall repair.

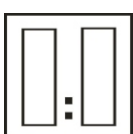
Pre-treatment

Wet flat with P1000-1200 grade paper or dry flat with P600-800 grade paper.

Degrease with AK401

Wash off residues and dry thoroughly.

Re-clean with AK401. The use of a tack rag is recommended.



Mixing Ratio

Stir well before use. Twice per day for 15 mins on the mixing machine.

1K Solids 100 (vol) depending on color

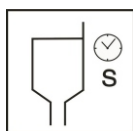
AK3211 (5°C-15°C)

AK3212 (15°C-25°C)

AK3213 (25°C-35°C)

AK3214 (>35°C) 100-120(vol)

Mix well and strain before application.



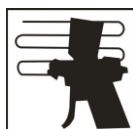
Spray Viscosity

16 to 22 seconds DIN 4 cup at 25°C



Spray Guns

HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm



Application

Apply basecoat over original stoved finishes or over AK700/AK1020 grey primers.

Number of spraycoats: 1 thin + 1 wetcoat + 1 mist coat to match effect

Flash-off: 5-10mins

Note: Before mist coat, enlarge the spray fan and

adjust spraying pressure & distance to be:	2.0 bar(HVLP)	10-15cm
	3.5bar(Conventional)	20-25cm

Film thickness: 15-20 µm

Further Treatment

After the flash-off, apply Dobte clear coat wet on wet.



Note

1. Mix with Dobte series products to assure spray effect and paint performance.
2. Use different type of thinners as per different temperature.
3. Wear protective mask, glove and overall etc.

Basecoat 2c

2-Stage Red Pearl

Product Description

Single component metallic colors for repairing automotive 2-stage finishes of spot, panel and overall repair.

Pre-treatment

Phase 1

Wet flat with P1000-1200 grade paper or dry flat with P600-800 grade paper.

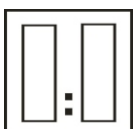
Degrease with AK401

Wash off residues and dry thoroughly.

Re-clean with AK401. The use of a tack rag is recommended.

Phase 2 (Optional)

Apply one thin layer of Dobte 1K solid colors that are close to red pearl; after one min's flash-off, apply one more wet layer of the same color.



Mixing Ratio

Stir well before use. Twice per day for 15 mins on the mixing machine.

1K Solids 100 (vol) depending on color

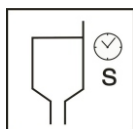
AK3211 (5°C-15°C)

AK3212 (15°C-25°C)

AK3213 (25°C-35°C)

AK3214 (>35°C) 100-120(vol)

Mix well and strain before application.



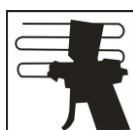
Spray Viscosity

16 to 22 seconds DIN 4 cup at 25°C



Spray Guns

HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm



Application

Apply basecoat over original stoved finishes or over AK700/AK1020 grey primers.

Number of spraycoats: 1 thin + 1 wetcoat + 1 mist coat to match effect

Flash-off: 5-10mins

Note: Before mist coat, enlarge the spray fan and

adjust spraying pressure & distance to be:	2.0 bar (HVLP)	10-15cm
	3.5bar (Conventional)	20-25cm

Film thickness: 15-20 µm

Further Treatment

After the flash-off, apply Dobte clear coat wet on wet.



Note

1. Mix with Dobte series products to assure spray effect and paint performance.
2. Use different type of thinners as per different temperature.
3. Wear protective mask, glove and overall etc.

Xirallic/Pearlescent Basecoat 3c

3-Stage Single Component Pearl/Crystal Pearl Colors

Product Description

Single component metallic colors for repairing automotive 3stage finishes.

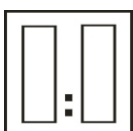
Pre-treatment

Wet flat with P1000-1200 grade paper or dry flat with P600-800 grade paper.

Degrease with AK401

Wash off residues and dry thoroughly.

Re-clean with AK401. The use of a tack rag is recommended.



Mixing Ratio

Stir well before use. Twice per day for 15 mins on the mixing machine.

Step1: 1K Solids 100 (vol) depending on color

AK3211 (5°C-15°C)

AK3212 (15°C-25°C)

AK3213 (25°C-35°C)

AK3214 (>35°C) 100-120 (vol)

Step1: Dobte crystal pearl colors 100 (vol) depending on color

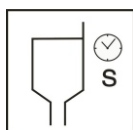
Ak3211 (5°C-15°C)

AK3212 (15°C-25°C)

AK3213 (25°C-35°C)

AK3214 (>35°C) 100-120 (vol)

Mix well and strain before application.



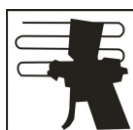
Spray Viscosity

16 to 22 seconds DIN 4 cup at 25°C



Spray Guns

HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm



Application

Apply basecoat over original stoved finishes or over AK700/AK1020 grey primers.

	Step 1 (1K Solids)	Step 2 (Pearls/Crystal Pearls)
Number of spraycoats:	1 thin + 1 wet coat	1wet + 1 mist coat to match effect
Film thickness:	15 µm	15um-25 µm
Flash-off:	5-10mins	

Note: Before mist coat, enlarge the spray fan and adjust spraying pressure & distance to be:

2.0 bar(HVLP)	10-15cm
3.5bar(Conventional)	20-25cm

Further Treatment

After the flash-off, apply Dobte clear coat wet on wet.



Note

1. Mix with Dobte series products to assure spray effect and paint performance.
2. Use different type of thinners as per different temperature.
3. Wear protective mask, glove and overall etc.

2K Clears

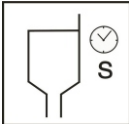
120S Mirror Effect Clear

Product Description

120S Mirror Effect Clears for application ranging from spot repair, panel repair to overall refinish.

Pre-treatment

Mirror Effect Clear is suitable to be applied on top of a clean and dust-free basecoat. See TDS of basecoat for other preparation of substrate.

	Mixing Ratio	120S Clear 100 (vol) AK125 Hardener 50 (vol) AK321 Thinner 10-20 (vol) Mix well and strain before application.. Note: AK1251/AK3211 is for temperatures between 5°C-15°C. AK1252/AK3212 is for temperatures between 15°C-25°C. AK1253/AK3213 is for temperatures above 25°C. AK3214 Thinner is for temperatures above 35°C or when refinishing large surfaces.												
	Spray Viscosity Potlife	18 to 26 seconds DIN 4 cup at 25°C 4 hours at 25°C; 3 hours at 35°C												
	Spray Guns	<table><tr><td>HVLP gravity-feed spraygun</td><td>1.2-1.3mm</td><td>1.8-2.0 bar</td><td>10-15 cm</td></tr><tr><td>Conventional gravity-feed spraygun</td><td>1.3-1.6mm</td><td>3.0-4.0 bar</td><td>15-20 cm</td></tr></table>	HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm	Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm				
HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm											
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm											
	Application	Number of spraycoats: 1 half wet + 1 wet coat Flash-off: 10-20mins (Before Baking) Film thickness: 40-60 µm												
	Drying	<table><tr><td>Drying</td><td>25°C</td><td>60°C</td></tr><tr><td>Dust free after</td><td>45 mins</td><td>5 mins</td></tr><tr><td>Ready for assembly after</td><td>6 hours</td><td>30 mins</td></tr><tr><td>Ready for polish after</td><td>24 hours</td><td>60 mins</td></tr></table>	Drying	25°C	60°C	Dust free after	45 mins	5 mins	Ready for assembly after	6 hours	30 mins	Ready for polish after	24 hours	60 mins
Drying	25°C	60°C												
Dust free after	45 mins	5 mins												
Ready for assembly after	6 hours	30 mins												
Ready for polish after	24 hours	60 mins												
	IR Drying	IR drying after flash-off time: Step 1-short wave: 5 mins at a 80 cm distance Step 2-medium wave: 20 mins at a 80 cm distance												
Further Treatment		Polish after specified drying times and cooling.												
	Note	1. Mix with Dobte series products to assure spray effect and paint performance. 2. Use different type of hardener & thinners as per different temperature. 3. Wear protective mask, glove and overall etc.												

2K Clears

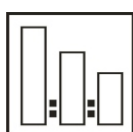
430S Medium Solid Clear

Product Description

430S Medium Solid Clears for application ranging from spot repair, panel repair to overall refinish.

Pre-treatment

430S Medium Solid Clear is suitable to be applied on top of a clean and dust-free basecoat. See TDS of basecoat for other preparation of substrate.



Mixing Ratio

430S Clear 100 (vol)
AK125 Hardener 50 (vol)
AK321 Thinner 10-20 (vol)

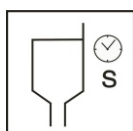
Mix well and strain before application..

Note: AK1251/AK3211 is for temperatures between 5°C-15°C.

AK1252/AK3212 is for temperatures between 15°C-25°C.

AK1253/AK3213 is for temperatures above 25°C.

AK3214 Thinner is for temperatures above 35°C or when refinishing large surfaces.



Spray Viscosity

18 to 26 seconds DIN 4 cup at 25°C

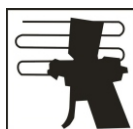
Potlife

4 hours at 25°C; 3 hours at 35°C



Spray Guns

HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm



Application

Number of spraycoats: 1 half wet + 1 wet coat
Flash-off: 10-20mins (Before Baking)
Film thickness: 40-60 µm



Drying

Drying	25°C	60°C
Dust free after	45 mins	5 mins
Ready for assembly after	6 hours	30 mins
Ready for polish after	24 hours	60 mins



IR Drying

IR drying after flash-off time:
Step 1-short wave: 5 mins at a 80 cm distance
Step 2-medium wave: 20 mins at a 80 cm distance

Further Treatment

Polish after specified drying times and cooling.



Note

1. Mix with Dobte series products to assure spray effect and paint performance.
2. Use different type of hardener & thinners as per different temperature.
3. Wear protective mask, glove and overall etc.

2K Clears

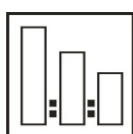
690S High Solid Clear

Product Description

690S High Solid Clears for application ranging from spot repair, panel repair to overall refinish.

Pre-treatment

690S High Solid Clear is suitable to be applied on top of a clean and dust-free basecoat. See TDS of basecoat for other preparation of substrate.



Mixing Ratio

690S Clear 100 (vol)
AK260 Hardener 50 (vol)
AK321 Thinner 5-15 (vol)

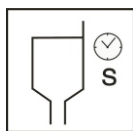
Mix well and strain before application..

Note: AK2601/AK3211 is for temperatures between 5°C-15°C.

AK2602/AK3212 is for temperatures between 15°C-25°C.

AK2603/AK3213 is for temperatures above 25°C.

AK3214 Thinner is for temperatures above 35°C or when refinishing large surfaces.



Spray Viscosity

18 to 26 seconds DIN 4 cup at 25°C

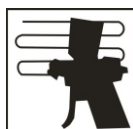
Potlife

4 hours at 25°C; 3 hours at 35°C



Spray Guns

HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm



Application

Number of spraycoats: 1 half wet + 1 wet coat
Flash-off: 10-20mins (Before Baking)
Film thickness: 40-60 µm



Drying

Drying	25°C	60°C
Dust free after	45 mins	5 mins
Ready for assembly after	6 hours	30 mins
Ready for polish after	24 hours	60 mins



IR Drying

IR drying after flash-off time:
Step 1-short wave: 5 mins at a 80 cm distance
Step 2-medium wave: 20 mins at a 80 cm distance

Further Treatment

Polish after specified drying times and cooling.



Note

1. Mix with Dobte series products to assure spray effect and paint performance.
2. Use different type of hardener & thinners as per different temperature.
3. Wear protective mask, glove and overall etc.

2K Clears

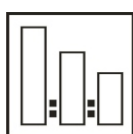
1060S Premium Crystal Clear

Product Description

Premium Crystal Clears for application ranging from spot repair, panel repair to overall refinish.

Pre-treatment

1060S Premium Crystal Clear is suitable to be applied on top of a clean and dust-free basecoat. See TDS of basecoat for other preparation of substrate.



Mixing Ratio

1060S Clear 100 (vol)
AK260 Hardener 50 (vol)
AK321 Thinner 5-15 (vol)

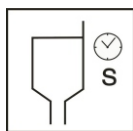
Mix well and strain before application..

Note: AK2601/AK3211 is for temperatures between 5°C-15°C.

AK2602/AK3212 is for temperatures between 15°C-25°C.

AK2603/AK3213 is for temperatures above 25°C.

AK3214 Thinner is for temperatures above 35°C or when refinishing large surfaces.



Spray Viscosity

18 to 26 seconds DIN 4 cup at 25°C

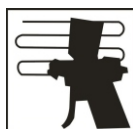
Potlife

4 hours at 25°C; 3 hours at 35°C



Spray Guns

HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm



Application

Number of spraycoats: 1 half wet + 1 wet coat
Flash-off: 10-20mins (Before Baking)
Film thickness: 40-60 µm



Drying

Drying	25°C	60°C
Dust free after	45 mins	5 mins
Ready for assembly after	6 hours	30 mins
Ready for polish after	24 hours	60 mins



IR Drying

IR drying after flash-off time:
Step 1-short wave: 5 mins at a 80 cm distance
Step 2-medium wave: 20 mins at a 80 cm distance

Further Treatment

Polish after specified drying times and cooling.



Note

1. Mix with Dobte series products to assure spray effect and paint performance.
2. Use different type of hardener & thinners as per different temperature.
3. Wear protective mask, glove and overall etc.

2K Clears

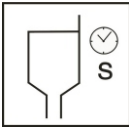
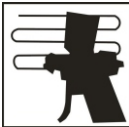
KS1 Ultra Cure Clear

Product Description

KS1 Ultra Cure Clears for application ranging from spot repair, panel repair to overall refinish.

Pre-treatment

KS1 Ultra Cure Clear is suitable to be applied on top of a clean and dust-free basecoat. See TDS of basecoat for other preparation of substrate.

	Mixing Ratio	KS1 Clear 100 (vol) AK125 Hardener 50 (vol) Mix well and strain before application.. Note: AK1251 is for temperatures between 5°C-15°C. AK1252 is for temperatures between 15°C-25°C. AK1253 is for temperatures above 25°C.			
	Spray Viscosity Potlife	18 to 26 seconds DIN 4 cup at 25°C 1 hour at 25°C; 30 mins at 35°C			
	Spray Guns	HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
		Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm
	Application	Number of spraycoats: 1 half wet + 1 wet coat Flash-off: 10-15 mins Film thickness: 40-60 µm			
	Drying	Drying	25°C	60°C	
		Dust free after	10 mins	5 mins	
		Ready for assembly after	30 mins	10 mins	
		Ready for polish after	60mins	15 mins	
	IR Drying	IR drying after flash-off time: Step 1-short wave: 5 mins at a 80 cm distance Step 2-medium wave: 20 mins at a 80 cm distance			
Further Treatment		Polish after specified drying times and cooling.			
	Note	1. Mix with Dobte series products to assure spray effect and paint performance 2. Use different type of thinners as per different temperature. Use AK1251/2/3 hardener for different temperatures. 3. Wear protective mask, glove and overall etc.			

Primers

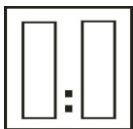
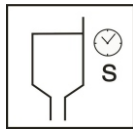
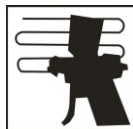
AK700 1K Primer Surfacers

Product Description

Fast-drying economical primersurfacer for covering minor defects on putty/existing finishes, and frequently used as a indication layer for sanding and filling.

Pre-treatment

Degrease with AK401.
Wash off residues and dry thoroughly.
Re-clean with AK401. The use of a tack rag is recommended.
Wet flat with P600-800 grade paper or dry flat with P320-360 grade paper.

	Mixing Ratio	AK700 Primer 100 (vol) 100 (g) AK3211 (5°C-15°C) Thinner AK3212(15°C-25°C) AK3213 (25°C-35°C) AK3214 (>35°C) 150-200 (vol) 120-160 (g) Mix well and strain before application.								
	Spray Viscosity	16 to 19 seconds DIN 4 cup at 25°C								
	Spray Guns	<table><tr><td>HVLP gravity-feed spraygun</td><td>1.2-1.3mm</td><td>1.8-2.0 bar</td><td>10-15 cm</td></tr><tr><td>Conventional gravity-feed spraygun</td><td>1.3-1.6mm</td><td>3.0-4.0 bar</td><td>15-20 cm</td></tr></table>	HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm	Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm
HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm							
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm							
	Application	<table><tr><td>Number of spraycoats:</td><td>1 thin + 1 wet coat</td></tr><tr><td>Flash-off:</td><td>5-8mins</td></tr><tr><td>Film thickness:</td><td>30-40 µm</td></tr></table>	Number of spraycoats:	1 thin + 1 wet coat	Flash-off:	5-8mins	Film thickness:	30-40 µm		
Number of spraycoats:	1 thin + 1 wet coat									
Flash-off:	5-8mins									
Film thickness:	30-40 µm									
	Drying	<table><tr><td>Drying</td><td>25°C</td></tr><tr><td>Dust free after</td><td>10 mins</td></tr><tr><td>Sand after</td><td>30-45 mins</td></tr></table>	Drying	25°C	Dust free after	10 mins	Sand after	30-45 mins		
Drying	25°C									
Dust free after	10 mins									
Sand after	30-45 mins									
Further Treatment		After the dust-free or sanding, apply Dobte basecoat or topcoat								
	Note	1. Mix with Dobte series products to assure spray effect and paint performance. 2. Use different type of thinners as per different temperature. 3. Wear protective mask, glove and overall etc.								

Primers

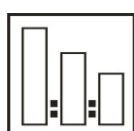
AK1020 2K Primer Surfacer

Product Description

Multi-purpose primer surfacer for covering putty/existing finishes, easy sanding, high efficiency with strong filling power and adhesion. Fine hardness is featured.

Pre-treatment

Degrease with AK401.
Wash off residues and dry thoroughly.
Re-clean with AK401. The use of a tack rag is recommended.
Wet flat with P600-800 grade paper or dry flat with P320-400 grade paper.



Mixing Ratio

AK1020 Primer	100 (vol)	100 (g)
AK030 Hardener	25 (vol)	25 (g)
AK321 Thinner	25-40 (vol)	20-35 (g)

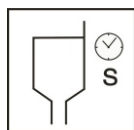
Mix well and strain before application..

Note: AK3211 is for temperatures between 5°C-15°C.

AK3212 is for temperatures between 15°C-25°C.

AK3213 is for temperatures above 25°C.

AK3214 Thinner is for temperatures above 35°C or when refinishing large surfaces.



Spray Viscosity

22 to 26 seconds DIN 4 cup at 25°C

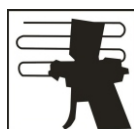
Potlife

2 hours at 25°C ; 1 hour at 35°C



Spray Guns

HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm



Application

Number of spraycoats: 1 thin + 1 wet coat

Flash-off: 5-10 mins

Film thickness: 40-60 µm



Drying

Drying	25°C	60°C
Dust free after	15 mins	5 mins
Sand after	4-5 hours	10 mins

Further Treatment

After the dust-free or sanding, apply Dobte basecoat or topcoat



Note

1. Mix with Dobte series products to assure spray effect and paint performance.
2. Use different type of thinners as per different temperature. Use AK030 hardener for different temperatures.
3. Wear protective mask, glove and overall etc.

Primers

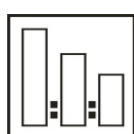
AK1030 Epoxy Primer

Product Description

Anti-corrosion epoxy primer for bare metal. Adhesive to steel, aluminum and galvanized steel.

Pre-treatment

Degrease with AK401 and washed with a tack rag.
Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper.
Clean with AK401.

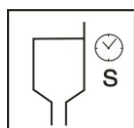


Mixing Ratio

Stir well before use.

AK1030 Primer	100 (vol)	100 (g)
AK030 Hardener	25 (vol)	25 (g)
AK031 Thinner	25-40 (vol)	20-35 (g)

Mix well and strain before application.



Spray Viscosity

22 to 26 seconds DIN 4 cup at 25°C

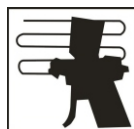
Potlife

4 hours at 25°C ; 1 hour at 35°C



Spray Guns

HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm



Application

Number of spraycoats:	1 thin + 1 wet coat
Flash-off:	5-10 mins
Film thickness:	20-30 µm



Drying

Drying	25°C	60°C
Dust free after	5 mins	5 mins
Sand after	12 hours	30 mins

Further Treatment

After the dust-free, apply Dobte 1K or 2K Primer Surfacer or AK1108 Poly Putty if large sand holes exist(optional)



Note

1. Mix with Dobte series products to assure spray effect and paint performance.
2. Use different type of thinners as per different temperature. Use AK030 hardener and AK031 thinner.
3. Wear protective mask, glove and overall etc.

Primers

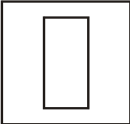
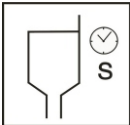
AK800R Plastic Primer

Product Description

Single-component primer to promote adhesion of paint to plastic parts. Suitable for PP, ABS, PC or PVC plastic substrates.

Pre-treatment

Degrease with AK401
Wash off residues and dry thoroughly.
Re-clean with AK401 The use of a tack rag is recommended.
Plastic substrates except PE should be wet flat with P600-800 grade paper or dry flat with P320-400 grade paper.

	Mixing Ratio	This product is ready for use.			
	Spray Viscosity	5 to 10 seconds DIN 4 cup at 25°C			
	Spray Guns	HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
		Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm
	Application	Number of spraycoats: 2 thin coats Flash-off: 5-10 mins Film thickness: 5-10 µm			
	Drying	Dust free at 25°C: 3mins			
Further Treatment		After the dust-free, apply Dobte 1K or 2K Primer Surfacer .			
	Note	1. Mix with Dobte series products to assure spray effect and paint performance. 2. Do Not spray too thick or it will affect adhesion power between layers. 3. Wear protective mask, glove and overall etc.			

Primers

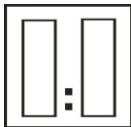
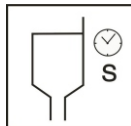
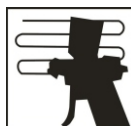
AK802R PP Plastic Primer (Grey)

Product Description

Single-component primer to promote adhesion of paint to plastic parts. Suitable for PP substrates.

Pre-treatment

Degrease with AK401.
Wash off residues and dry thoroughly.
Re-clean with AK401. The use of a tack rag is recommended.
Plastic substrates except PE should be wet flat with P600-800 grade paper or dry flat with P320-400 grade paper.

	Mixing Ratio	AK802R Primer 100 (vol) 100 (g) AK3211 (5°C-15°C) Thinner AK3212(15°C-25°C) AK3213 (25°C-35°C) AK3214 (>35°C) 100-150 (vol) 80-120 (g)								
	Spray Viscosity	10to 16 seconds DIN 4 cup at 25°C								
	Spray Guns	<table><tr><td>HVLP gravity-feed spraygun</td><td>1.2-1.3mm</td><td>1.8-2.0 bar</td><td>10-15 cm</td></tr><tr><td>Conventional gravity-feed spraygun</td><td>1.3-1.6mm</td><td>3.0-4.0 bar</td><td>15-20 cm</td></tr></table>	HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm	Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm
HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm							
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm							
	Application	<table><tr><td>Number of spraycoats:</td><td>1 thin + 1 wet coat</td></tr><tr><td>Flash-off:</td><td>5-10 mins</td></tr><tr><td>Film thickness:</td><td>15-20 µm</td></tr></table>	Number of spraycoats:	1 thin + 1 wet coat	Flash-off:	5-10 mins	Film thickness:	15-20 µm		
Number of spraycoats:	1 thin + 1 wet coat									
Flash-off:	5-10 mins									
Film thickness:	15-20 µm									
	Drying	Dust free at 25°C: 3mins								
Further Treatment		After the dust-free, apply Dobte 1Kor 2K Primer Surfacer .								
	Note	1. Mix with Dobte series products to assure spray effect and pain t performance. 2. Wear protective mask, glove and overall etc.								

Hardeners

Dobte Series Hardeners

Product Description

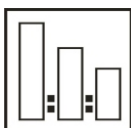
Yellow resistant hardeners to be added into 2K products to generate the chemical reaction between the hardener and acrylic resin.
Differ from ranges of temperatures and solid contents.

For 2K Topcoats & Clears:

	5°C-15°C	15°C-25°C	>35°C
2K Topcoats 1060S Clear 690S Clear	AK2601 Fast Hardener	AK2602 Standard Hardener	AK2603 Slow Hardener
430S Clear 120S Clear KS1 Clear	AK1251 Fast Hardener	AK1252 Standard Hardener	AK1253 Slow Hardener

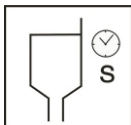
For 2K Primers:

AK020 for AK1020 2K Primer Surfacer, AK030 for AK1030 Epoxy Primer.



Mixing Ratio

Mix the 2K products with hardener and thinner as specified in the TDS.
Stir well before use
Please refer to the TDS of Clear Coats, 2K Topcoat, 2K Primer Surfacer, Epoxy Primer to get the corresponding mixing ratio.



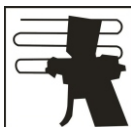
Spray Viscosity Potlife

As specified in the TDS of the products which Dobte Hardeners are being used.



Spray Guns

As specified in the TDS of the products which Dobte Hardeners are being used.



Application

As specified in the TDS of the products which Dobte Hardeners are being used.



Drying

As specified in the TDS of the products which Dobte Hardeners are being used.

Further Treatment

Refinished panels can be recoated or mounted after drying and -if required- cooling.



Note

1. Wear Mask when using hardeners.
2. Main components of hardener easily reacts with moisture in the air, cover the used out asap after mixing.

Thinners

Dobte Series Thinners

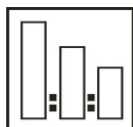
Product Description

Used to reduce application viscosity and to increase the smoothness of the paint film. Thinner with high dissolving ability, compatible with primers, basecoats, topcoats and clears.

AK3211 Thinner 5°C -15°C (**Fast**) **AK3212 Thinner** 1 5°C- 25°C (**Standard**) **AK3213 Thinner** 25°C-35°C (**Slow**) **AK3214 Thinner** >35°C (**Extra Slow**)

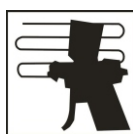
Pre-treatment

As specified in the TDS of the products in which Dobte Thinners are being used.



Mixing Ratio

As specified in the TDS of the products in which Dobte Thinners are being used.



Application

Be cautious of underdissolution of the paint when using poor-dissolving thinner. Avoid poor leveling and poor color effect (e.g. orientation of aluminum/pearl particles, poor solid color brightness).

Binders

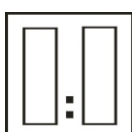
S150 Basecoat Binder

Product Description

Binder for Dobte basecoats. Improves leveling and enhances orientation of aluminum and pearl particles.

Pre-treatment

See process described in **TDS of Basecoat** Solid Basecoat 2c, Metallic Colors 2c, Red Pearl 2c, Xirallic / Pearlescent, Basecoat 3c.



Mixing Ratio

Stir well before use.

		S150	S160
Solid Basecoat	100g	10g	-
Coarse Alu.	100g	15g	0-10g
Fine Alu.	100g	20g	0-10g
3-Stage Pearl	100g	50-70g	-
2-Stage Pearl	100g	10g	-

S160 Flop Control Agent may be added to ensure better results for aluminum and pearl colors as well as for colors with an aluminum mixing base content of at least 75%.

Basecoat

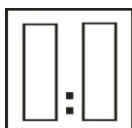
S160 Flop Control Agent Aluminum/Pearl Effect-Adjusting Agent

Product Description

S160 is developed for Dobte aluminum colors to give silver toners a flash-like effect. Used to lighten up the side face and darken the front face of aluminum flakes.

Pre-treatment

See process described in **TDS of Basecoat** Solid Basecoat 2c, Metallic Colors 2c, Red Pearl 2c, Xirallic / Pearlescent, Basecoat 3c.



Mixing Ratio

Stir well before use.

		S150	S160
Coarse Alu.	100g	15g	0-10g
Fine Alu.	100g	20g	0-10g
3-Stage Pearl	100g	50-70g	-
2-Stage Pearl	100g	10g	-

S160 Flop Controller may be added to ensure better results for aluminum colors as well as for colors with an aluminum mixing base content of at least 75%.

Binders

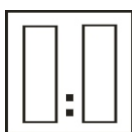
AK100 2K Topcoat Binder for Color Preparation

Product Description

Binder added into 2K solid topcoats to improve the gloss of the paint film.

Pre-treatment

See process described in **TDS of Dobte Solid Topcoats**.



Mixing Ratio

Stir well before use.

Solid Topcoats 100g

AK100 <30g

Note: AK100 should NOT be mixed into 1K basecoats or poor-covering 2K topcoats.

Strain before application

Topcoat

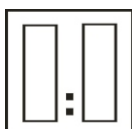
F759 Matting Agent

Product Description

Allows reducing the gloss level of 2K solid colors and clears.

Pre-treatment

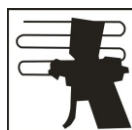
See process described in **TDS of Dobte Solid Topcoats and clear coats**



Mixing Ratio



Spray Guns



Application

Stir well before use.

Option 1:

When F759 is contained in the mixing formula:
Mix the components respecting the amounts specified in the mixing formula.
Prepare the paint for application by adding hardener and thinner as indicated in the TDS of the solid topcoat/ clear coat being adjusted.

Option 2:

When matting an original glossy topcoat/clearcoat:
Add to produce the desired degree of matting.

Semi Gloss: 2K Solids F759	100(vol) 30(vol)	2K Clears F759	100(vol) 30(vol)
Satin Gloss: 2K Solids F759	100(vol) 50(vol)	2K Clears F759	100(vol) 50(vol)
Silky Gloss: 2K Solids F759	100(vol) 100(vol)	2K Clears F759	100(vol) 100(vol)

HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm

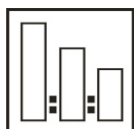
Number of spraycoats: 1 half wet + 1 wet coat
Film thickness: 40-60 µm
Dust-free until mat between spraycoats and before stoving.

Auxiliaries

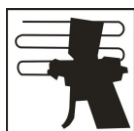
AK201 Anti-Silicon

Product Description

Traces of grease, oils and particularly silicone oils on the surface to be painted, in paint products or in the spraying air can cause surface defects such as "craters" or "fish eyes" in the paint film. In the medium and long term the root cause of craters has to be identified and eliminated. It is mainly applied on clear coats and solid topcoats. AK201 is a short-term remedy to prevent craters in individual repairs.



Mixing Ratio



Application

Mix the Dobte topcoat/clears with hardener and thinner as specified in the TDS. Use the amount of ready-for-use product to determine the amount of AK201 to be added.

Add 1%-2% of total topcoats volume or 2-4 capfuls (10-20g) of per liter of ready-for-use product (toner + hardener + thinner)

Note:

- 1) Use only when necessary.
- 2) Never use more than recommended amounts. Excess addition may cause defect of small bubbles or affect the transparency of paint.
- 3) In serious problems, fisheyes affected paint film must be sanded out and filled.

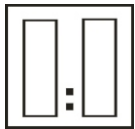
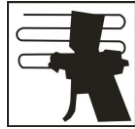
- 1) If defects are detected after one thin spraycoat of Dobte topcoat/clears, use AK201 as specified.
- 2) Wait until the paint coat in which craters or fisheyes were detected is dry.

Auxiliaries

AK350 Thinner SRA

Product Description

Blending thinner designed to smooth transition areas from blend-in zones to old paintwork, by dissolving rough overspray area of new and existing finishes. Suitable for panel/spot repair and for clears and topcoats

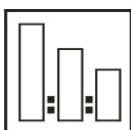
	Mixing Ratio	This product is ready for use.			
	Spray Guns	HVLP gravity-feed spraygun	1.2-1.3mm	1.8-2.0 bar	10-15 cm
		Conventional gravity-feed spraygun	1.3-1.6mm	3.0-4.0 bar	15-20 cm
	Application	1 mist coat right after the finish, second thin coat in 10-20 seconds.			
	Drying	As recommended for the Dobte clear used.			
Further Treatment		If necessary, minor defects can be sanded out with P2000 paper then polish with any standard fine polishing compound once the clear coat has fully cured.			

Auxiliaries

AK301 Retarder Solvent

Product Description

Additive for use in 1K basecoats, 2K topcoats and clears at high temperature ($>30^{\circ}\text{C}$), at high humidity level ($>70\%$) and/or at high air speed level ($>0.5\text{m/s}$) in booths, to prolong volatilization of solvent and to help produce a good leveling and blushing-free refinishing job in above-mentioned circumstance.



Mixing Ratio

Stir well before use

AK301 (30% max) to the first basecoat layer.

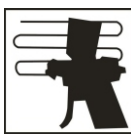
Example for a humidity level is above 70%:

Basecoat	100 (vol)
AK321_ Thinner	70-90 (vol)
AK301	10-30 (vol)

Add AK301 (10% max) to the first topcoat/clearcoat layer.

Example for a humidity level is above 70%:

Topcoats/Clears	100 (vol)
AK260/AK125	50 (vol)
AK321	5-15 (vol)
AK301	5-10 (vol)



Application

Reasonable extension of flash-off time can help reduce the blush of paint.



Drying

Option 1: Prolong the drying time.

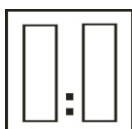
Option 2: Increase the amount of the hardener used in the Dobte 2K topcoat/clear to no more than 10%.

Auxiliaries

AK501 Quick Drier

Product Description

Drying accelerator for use in Dobte topcoats, clears, 2K primers primer surfacer. AK501 will accelerate the chemical reaction between the hardener and the acrylic resin of the products.



Mixing Ratio

Mix Dobte 2K products with hardener and thinner as specified in the TDS. Use the amount of ready-for-use product to determine the amount of AK501 to be added.

Important:

The addition of AK501 will reduce the potlife of the product.
AK501 can NOT be used as hardener.

Use a fast thinner when working in low temperatures (5°C-15°C).

0.5-3 % of total 2K solid or 1-6 capfuls of per liter of ready-for-use product (base + hardener + thinner)

1) Drying in low temperatures

The normal application temperature for paint products is 25°C. If the application temperature is lower, apply the following percentages:

Temperature	10°C-15°C	0°C-10°C	< 0°C
% AK501 (2K Solids)	0.5 -1 %	1-1.5 %	2 %
(2K Clears)	1-1.5 %	1.5-2 %	3 %
(2K Primer)	1-1.5 %	1.5-2 %	3 %

2) Accelerating drying

The stoving time for Dobte topcoats, clears at 60 °C is 60 minutes. When refinishing individual panels, it is possible to reduce the stoving time to 30 minutes at 60°C if the following percentages are respected:

	2K Solids	2K Clears
% AK501	0.5%	1%

Note: If you add too much AK501, you will risk loss of gloss or paint film embrittlement.



Note

1. When using this product, the gloss and weather resistance of clears or topcoats will be affected.
2. DO NOT dry epoxy primer by this product.

Auxiliaries

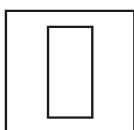
AK401 Degreaser

Product Description

AK401 are particularly well suited for removing grease, oils, wax and silicone prior to the application of Dobte primer and for the pre-treatment of plastic surfaces. No stimulation to skin.

Pre-treatment

Do not use the degreaser on solvent-sensitive or thermoplastic substrates.



Mixing Ratio

This product is ready for use

Soak a clean and dry lint-free cloth with AK401

Degrease small areas of approximately 0.5 m² of the surface to be painted and wipe these areas immediately afterwards with a dry cloth of the same quality.

AK401 should not dry on the surface being treated.



Application

Attention:

Some 1K primers/basecoats may suffer surface etching from the use of AK401. In this case, ensure a good flash-off of the substrate before going on with the repair so that no solvents will be trapped in the new paint system. In extreme cases, remove the 1K primer/basecoat before applying the new paint system, or flat with P800-1000 grade sandpaper for refining/finish.

Auxiliaries

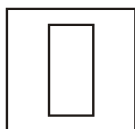
AK701 Body Filler

Product Description

Single-component putty featuring good filling properties, fast-drying and easy to apply. Especially used to cover small scratches, sandholes and pinholes. Suitable for substrates such as dried and sanded existing finishes, putty, 1K and 2K primers.

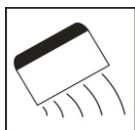
Pre-treatment

Degrease with AK401.
Dry sand with P100-P120 grade paper or wet sand with P150-P180 grade paper.
Re-clean with AK401



Mixing Ratio

This product is ready for use



Application

Apply with plastic/steel blade. DO NOT blade too thick for one time.



Drying

Sanding after 10-20mins at 25°C.

Further Treatment

Apply Dobte 2K primer surfacer, basecoats or topcoats.



Note

1. Mix with Dobte series products to assure spray effect and paint performance.
2. Do Not spray too thick or it will affect adhesion power between layers.
3. Wear protective mask, glove and overall etc.

Auxiliaries

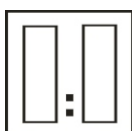
AK1108 Poly Putty

Product Description

Very fine particles, good filling power, fast drying, excellent adhesion power, easy to apply and to sand. Suitable for bare metal, primers and existing finishes.

Pre-treatment

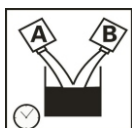
Clean surface with water and soap. Rinse and dry.
Degrease with AK401.
Sand with P150 or P180 to feather edge.
Re-clean with AK401.



Mixing Ratio

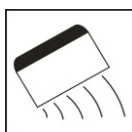
AK1108		100g
Hardener	5°C-15°C	3g
	15°C-25°C	2g
	> 25°C	1.5g

Mix well before application



Potlife

7-8mins at 25°C



Application

Apply with plastic/steel blade. DO NOT blade too thick (MAX 3mm) for one time.



Drying

Flat at 25°C after: 40-60mins
Dry flat at 25°C after: 70-90mins

Further Treatment

Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper. And apply Dobte 2K primer surfacer, basecoats or topcoats.



Note

1. DO NOT apply this product onto unsanded or undegreased substrates.
2. Avoid over amount mix or less amount mix with hardener.
3. Sand right away after coat dries to get easier sanding.
4. DO NOT spray topcoats directly on this product to avoid gloss losing.
5. Baking when using this product below 5°C.

Auxiliaries

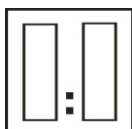
AK1208 Putty

Product Description

Very fine particles, good filling power, fast drying, excellent adhesion power, easy to apply and to sand. Suitable for bare metal, primers and existing finishes.

Pre-treatment

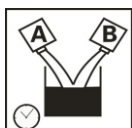
Clean surface with water and soap. Rinse and dry.
Degrease with AK401.
Sand with P150 or P180 to feather edge.
Re-clean with AK401.



Mixing Ratio

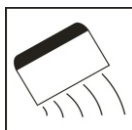
AK1108	100g
Hardener 5°C-15°C	3g
15°C-25°C	2g
> 25°C	1.5g

Mix well before application



Potlife

7-8mins at 25°C



Application

Apply with plastic/steel blade. DO NOT blade too thick(MAX 3mm) for one time.



Drying

Wet flat at 25°C after:40-60mins
Dry flat at 25°C after:70-90mins

Further Treatment

Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper. Apply Dobte 2K primer surfacer. And apply Dobte 2K primer surfacer, basecoats or topcoats.



Note

1. DO NOT apply this product onto unsanded or undegreased substrates.
2. Avoid over amount mix or less amount mix with hardener.
3. Sand right away after coat dries to get easier sanding.
4. DO NOT spray topcoats directly on this product to avoid gloss losing.
5. Baking when using this product below 5°C



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