

# 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 P800–1000 grade paper or dry flat with P600–800 grade paper.

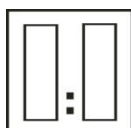
Degrease with AK401

Wash off residues and dry thoroughly.

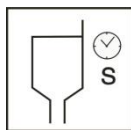
Re-clean with AK401. The use of a tack rag is recommended.

#### 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.



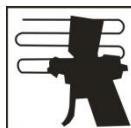
### Mixing Ratio



### Spray Viscosity



### Spray Guns



### Application

### Further Treatment



### Note

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.

16 to 22 seconds DIN 4 cup at 25°C

|                                    |           |             |          |
|------------------------------------|-----------|-------------|----------|
| 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 |

**Apply basecoat over original stoved finishes or over 700S/1020S grey primers.**

Number of spraycoats: 1 thin + 1 wet coat + 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

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

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.