

Basecoat 2c

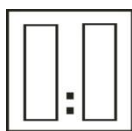
2-Stage Metallic Colors (Aluminum/Pearl/Crystal Pearl)

Product Description

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

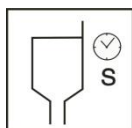
Pre-treatment

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
 AK321 (5°C–15°C)
 AK321 (15°C–25°C)
 AK321 (25°C–35°C)
 AK322 (>35°C) 100-120(vol)
 Mix well and strain before application.



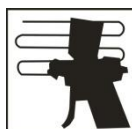
Spray Viscosity

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 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

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.