

# Topcoat

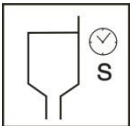
## 1- Stage Solid Colors

### 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.

|                                                                                     |                           |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
|-------------------------------------------------------------------------------------|---------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|--|--|----------------------------|-------------------------|--------------------|-----------------|------------------------------------|---------------------------|--------------------------|----------|-----------------|------------------------|-----------------------|-------------|--|--|--|
|    | <b>Mixing Ratio</b>       | <p>Stir well before use. Twice per day for 15 mins on the mixing machine.</p> <table><tr><td><b>2 K Solid Colors</b></td><td>100 (vol)</td><td colspan="3">depending on color</td></tr><tr><td><b>AK260_ Hardener</b></td><td>50 (vol)</td><td colspan="3"></td></tr><tr><td><b>AK321_ Thinner</b></td><td>10-20 (vol)</td><td colspan="3"></td></tr></table> <p>Mix well and strain before application.</p> <p>Note: AK2601/AK3211 is for temperatures between 5°C–15°C<br/>AK2602/AK3212 is for temperatures between 15°C–25°C<br/>AK2603/AK3213 is for temperatures above 25°C<br/>AK3214Thinner is for temperatures above 35°C or when refinishing large surfaces.</p> |          |  |  | <b>2 K Solid Colors</b>    | 100 (vol)               | depending on color |                 |                                    | <b>AK260_ Hardener</b>    | 50 (vol)                 |          |                 |                        | <b>AK321_ Thinner</b> | 10-20 (vol) |  |  |  |
| <b>2 K Solid Colors</b>                                                             | 100 (vol)                 | depending on color                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
| <b>AK260_ Hardener</b>                                                              | 50 (vol)                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
| <b>AK321_ Thinner</b>                                                               | 10-20 (vol)               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
|   | <b>Spray Viscosity</b>    | 18 to 26 seconds DIN 4 cup at 25°C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
|                                                                                     | <b>Potlife</b>            | 4 hours at 25°C; 3 hours at 35°C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
|  | <b>Spray Guns</b>         | <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 |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
|  | <b>Application</b>        | <p><b>Apply topcoat over original stoved finishes or over 700S/1020S grey primers.</b></p> <table><tr><td>Number of spraycoats:</td><td colspan="3">1 half wet + 1 wet coat</td></tr><tr><td>Flash-off:</td><td colspan="3">10-20mins (Before Baking)</td></tr><tr><td>Film thickness:</td><td colspan="3">40–60 µm</td></tr></table>                                                                                                                                                                                                                                                                                                                                      |          |  |  | Number of spraycoats:      | 1 half wet + 1 wet coat |                    |                 | Flash-off:                         | 10-20mins (Before Baking) |                          |          | Film thickness: | 40–60 µm               |                       |             |  |  |  |
| Number of spraycoats:                                                               | 1 half wet + 1 wet coat   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
| Flash-off:                                                                          | 10-20mins (Before Baking) |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
| Film thickness:                                                                     | 40–60 µm                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
|  | <b>Drying</b>             | <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                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
|                                                                                     |                           | <p>IR drying after flash-off time:<br/>Step 1–short wave: 5 mins at a 80 cm distance<br/>Step 2–medium wave: 20 mins at a 80 cm distance</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
| <b>Further Treatment</b>                                                            |                           |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |
|  | <b>Note</b>               | <p>Polish after specified drying times and cooling.</p> <ol style="list-style-type: none"><li>1. Mix with Dobte series products to assure spray effect and paint performance.</li><li>2. Use different type of hardener &amp; thinners as per different temperature.</li><li>3. Wear protective mask, glove and overall etc.</li></ol>                                                                                                                                                                                                                                                                                                                                     |          |  |  |                            |                         |                    |                 |                                    |                           |                          |          |                 |                        |                       |             |  |  |  |