

Xiralllic/Pearlescent Basecoat 3c

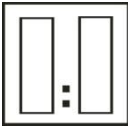
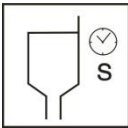
3 – Stage Single Component Pearl/Crystal Pearl Colors

Product Description

Single component metallic colors for repairing automotive 3–stage 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 700S/1020S 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:	15µm	15um-25µm	
		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.			