

The Onwings logo is a stylized banner with a black left half and a red right half, containing the word "Onwings" in white sans-serif font with a registered trademark symbol.

**Onwings®**

# TECHNICAL DATA SHEET 2024



DONGLAI COATING TECHNOLOGY  
[www.onwings.com](http://www.onwings.com)

## Donglai Coatings Technology

Established in 1999, we specialize in high-performance coatings fields such as automotive coatings, industrial coatings, and 3C consumer electronic coatings.

Stock Code:688129

ONWINGS is the premium solvent paint system of Donglai company.

### **A productive paint line**

Efficient products and Advanced color tools

Color match by AI tech Spectrometer  
2 hours lightning speed quick repair system  
Super cure clear, 20mins no baking

### **A reliable paint line**

First class materials and quality control  
Choice of 4000+ dealerships  
OEMs certificated, Life time Warranty

### **A profitable paint line**

Saving waste during color matching  
Saving spray layers by high coverage base coat  
Saving 40% application time by SRS system

Smarter Choice, Higher Benefits

# ONWINGS

Shade Code	Scaleable	Shade Features
M161 Chestnut	0-100%	High chroma, bright, yellowish, to make red pearl series colors.
M162 Magenta	0-100%	Dark purplish red shade. High chroma.
M103 Permanent Red	0-100%	Purplish pink shade, high chroma.
M114 Transparent Bright Red	0-100%	Similar to M194, yellow red with transparent.
M194 Bright Red	50-100%	It makes metallic paint side light and reddish yellow. Not transparent.
M195 Brownish Red	0-100%	Dark gray shade makes metallic paint side light and reddish yellow. Not transparent.
M107 Transparent Gold	0-90%	It's recommended for mixing golden color, reddish yellow.
M108 Transparent Brown	0-100%	It's recommended for mixing golden color, strong reddish.
M109 Transparent Red	0-100%	Relatively transparent, normal opacity.
M223 Orange	0-100%	It makes metallic paint side tone light and reddish yellow. Not transparent
M301 Canary yellow	0-90%	It makes metallic paint face tone yellow shade, green flop. High chroma.
M320 Med. Yellow	0-90%	Adding makes metallic paint side tone more light and reddish yellow. Not transparent.
M322 Yellow	0-90%	Adding makes metallic paint side tone more light and reddish. Not transparent.
M393 Khaki	0-100%	Dark darker yellow tinter makes metallic paint side tone light, stone yellow. Not transparent.
M326 Lemon Yellow	0-90%	It makes metallic paint side tone lighter, yellowish green.
M307 Pure Yellow	0-100%	High chroma is recommended for mixing golden color with yellowish green tone.
M365 Transparent Yellow	0-90%	It's recommended for mixing golden color, face and side tone yellowish green.
M401 Bronze Green	0-80%	High chroma is recommended for mixing golden color, obvious yellowish green shade.
M402 Emerald Green	0-100%	Yellowish green shade, high chroma.
M403 Permanent Green	0-100%	Bluish green shade.
M501 Bright Blue	0-100%	Face tone green, and side tone red, high chroma.
M562 Permanent Blue	0-100%	Face tone is bluer than bright blue, side tone red.
M564 Transparent Blue	0-30%	Face tone blue, side tone green, high chroma.
M565 M566 reddish Blue	0-100%	Both face and side tone purplish blue.
M661 Purple	0-100%	Reddish purple, side tone dark.
M090 Pure White	0-100%	It makes metallic paint face tone haze and side tone light. Recommended for metallic side tone adjustment.
M061 Super White	0-100%	Recommended for basecoat of pearl colors, high concentration, high opacity.
M013 Transparent White	0-50%	To make metallic paint side tone light and blueish, and yellowish at 45°.
M002 Metallic Controller	0-20%	Aluminum controlling resin. Makes positive bevel tone dark while side tone light, more shining.
M003 Transparent Additive	0-50%	Clear and transparent resin. Overuse will affect opacity.
M881 Special Black	0-100%	Recommended for whole car refinishing, blueish, high concentration.
M805 Pure Black	0-100%	The deepest black toner, high chroma, blueish, high concentration, can be for whole car refinishing.
M806 Hi-concentration Black	0-30%	For fine toning of metallic colors. its side tone becomes light with blueish tone when it is mixed with aluminum,

**Attention:**

1. Do not mix with S series.
2. High hiding power, wonderful color with third dimension when use with 2K clear coat.

Shade Code	Scaleable	Shade Features
M908 Very Fine Aluminum	0-100%	Most fine aluminum, face and bevel dark, side tone light.
M913 Fine Aluminum	0-100%	Fine aluminum, face and bevel a little dark, side tone grey.
M914 Bright Aluminum	0-100%	Fine aluminum, face bright, with dark side tone.
M915 Fine Bright Aluminum	0-100%	Shinning with strong metallic texture. Face and bevel are bright and white with dark side tone.
M923 Medium Aluminum	0-100%	Face a little darker than M924, side a little lighter than M924. Medium grain diameter.
M924 White Medium Aluminum	0-100%	Face and bevel are bright and side dark.
M931 Med. Bright Aluminum	0-100%	Both face and side tone are bright and sparkling.
M932 Med Coarse Bright Aluminum	0-100%	Slightly coarser and more sparkling than M931. Brighter white than M931 at face and bevel. Darker than it at side.
M940 Coarse Aluminum	0-100%	Coarse and sparkling.
M950 Coarse Bright Aluminum	0-100%	The coarsest and most sparkling aluminum, normal hiding power.
M981 Red Aluminum	0-100%	Red colouring aluminum powder, high colour, side dark.
M984 Green Aluminum	0-100%	Green colouring aluminum powder, high colour, side dark.
M985 Blue Aluminum	0-100%	Blue colouring aluminum powder, M564 tone, face blue, side green, and dark high colour.
M988 Yellow Silver	0-100%	Special color aluminum, golden yellow granules, side tone dark yellow.

**Attention:**

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2. High hiding power, wonderful color with third dimension when use with 2K clear coat.

Shade Code	Scaleable	Shade Features
P001 White Pearl	0-100%	Middle-diameter, face quite white, side tone beige. Colorful and shinning in the sun.
P002 White Pearl(fine)	0-100%	Fine, face and bevel tone a little dark. Colorful and shinning in the sun.
P003 White Pearl(coarse)	0-100%	Coarse, face quite white, side tone beige. Colorful and shinning in the sun.
P005 Super Fine white Pearl	0-100%	White pearl, finer than WP002.
P006 Glass White Pearl	0-100%	High transparency, high flash in sunlight, Interference effect white pearl, bright white.
P007 Aluminum Pearl	0-100%	Blue and white shinning white pearl, side dark.
P010 Red Pearl(coarse)	0-100%	Noninterference, good opacity, yellowish red, coarse.
P011 Red Pearl(fine)	0-100%	Noninterference, good opacity, yellowish red, fine.
P012 Pure Red Pearl	0-100%	Interference, quality, 90°angle of face misty white, 45°angle of side red, at 15°angle of bevel beige and greenish.
P013 Brown Pearl	0-100%	Noninterference, coarse, reddish yellow, high chroma.
P014 Med. Red Pearl	0-100%	Noninterference, High vibrancy, coverage, pure red pearl color.
P020 Yellow Pearl(fine)	0-100%	Noninterference, fine, face and bevel greenish yellow and dark, side light grey.
P021 Yellow Pearl(coarse)	0-100%	Noninterference, coarse, positive bevel golden and side light grey.
P023 Pure Yellow Pearl	0-100%	Interference, misty white at 90°angle of face, yellow at 45°angle of side, purplish at 15° angle of bevel.
P025 Interfering Yellow Pearl	0-100%	Interference, yellow pearl, similar to P023, coarser than P023
P030 Pure Green Pearl	0-100%	Interference, misty white at 90°angle of face, green at 45°angle of side, at 15° angle of bevel beige and reddish.
P031 Stellar Green Pearl	0-100%	Noninterference, face emerald green, bright red pearl at side.
P040 Pure Blue Pearl	0-100%	Interference, misty white at 90°angle of face, blue at 45°angle of side, beige and orange at 15° angle of bevel.
P041 Blueish Purple Pearl	0-100%	Interference, misty white at 90°angle of face, purplish blue at 45°angle of side, beige and orange at 15° angle of bevel.
P026 Pure Purple Pearl	0-100%	Interference, misty white at 90°angle of face, purple at 45°angle of side, beige and yellowish at 15° angle of bevel.
P008 White Crystal Pearl	0-100%	Special. It has strong metal texture in the sun. Clear as a whole, more sparkling.
P018 Red Crystal Pearl	0-100%	Special, reddishing yellow. It has strong metal texture in the sun. Clear as a whole, more sparkling.
P028 Yellow Crystal Pearl	0-100%	Special, face misty white, yellowish bevel, side purplish cream. Clear as a whole, more sparkling.
P029 Crystal Brass Pearl	0-100%	Special, face reddish yellow, side dark. Clear as a whole, more sparkling.
P038 Green Crystal Pearl	0-100%	Special, face misty white, bevel greenish, side reddish cream color. Clear as a whole, more sparkling.
P048 Blue Crystal Pearl	0-100%	Special, face misty white, bevel blueish, side orangeish cream. Clear as a whole, more sparkling.
P902 Crystal Fine White Pearl	0-100%	Finer and whiter than P008, special pearl, strong metallic texture in sunlight, clear as a whole and more sparkling particles
PB31 Illusion Green Red Pearl	0-10%	Chameleon pearl powder, contrary to PB13, face red and bevel green.
PB13 Red-green Illusion Pearl	0-10%	To make chameleon color series.

**Attention:**

1. Do not mix with S series.
2. High hiding power, wonderful color with third dimension when use with 2K clear coat.

Shade Code	Scaleable	Shade Features
S011 Super White	0-100%	Recommended as main color in white series, high hiding power.
S161 Magenta	0-100%	Recommended as matching deep red, yellowish, high chroma.
S102 Violet red	0-100%	Deep purple and shade, high chroma.
S103 Permanent Red	0-100%	Pink purple red, normal opacity.
S104 Scarlet	0-100%	The highest chroma among red series with a little yellowish, normal opacity.
S105 Brownish Red	0-100%	Yellowish, recommended for matching gray red color.
S223 Orange	0-100%	Strong yellowish in orange colors, recommended for matching red series colors.
S322 Yellow	0-100%	Reddish yellow.
S320 Med. Yellow	0-100%	A little reddish yellow, normal chroma.
S303 Khaki	0-100%	Low chroma, high hiding power.
S326 Lemon Yellow	0-100%	Greenish yellow shade, normal opacity.
S368 Intense Yellow	0-80%	Greenish yellow, high chroma, low opacity.
S402 Transparent Green	0-100%	Yellowish green shade, high chroma.
S403 Permanent Green	0-100%	Bluish green shade, high chroma.
S501 Brilliant Blue	0-100%	Greenish blue shade, high chroma.
S502 Permanent Blue	0-100%	Standard blue, darker and more reddish than brilliant blue.
S505 Reddish Blue	0-100%	Slight purple blue.
S601 Purple	0-100%	Reddish purple, high concentration.
S801 Special Black	0-100%	For black top coat only. Bluish, high concentration.
S802 Black	0-30%	For mixing light colors, low concentration.
S805 Pure Black	0-100%	The deepest black, bluish, high concentration, suitable for whole car application.
S376 Transparent Additive	0-50%	Colorless transparent resin. Overuse will reduce opacity.
S777 Delustering Agent	0-100%	To reduce the lustrousness.

**Attention:**

1. Do not mix with M series and P series.
2. No needed of 2K clear coat when mixing with 2K 2:1 hardener.



## M/P series 1K Base coat toners

Premium Solvent 1K basecoat, good coverage, Leveling and weather resistant.

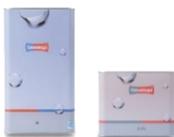
Appearance	Liquid with various colors, No impurities and turbidity	Substrate	Primer sand by p400~p600, wet on wet primer until matte, Prepared original old paint film
Density	/	Next Process	Onwings 2K Clear Coat
VOC	≤770g/L	Shelf Life Unopened	24 months
Mixing Ratio Weight	1:0.6~0.8	Mixing Ratio Volume	1:0.6~0.8
Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Reducer	A810	A811	A812
Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet: 1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet: 1.5-2.0bar		
Pot Life after mixed	6 hours	Filter	120-150Mesh
Storage after mixed	1 week	Application Viscosity	16-18"/DIN 4mm/20°C
1K solid colors	2-3 Layers(10~30µm)	Matellic and Pearls	2-3 Layers(10~30µm)
1st Layer:	Mid-wet Coat	1st Layer:	Mid-wet Coat
2nd Layer:	Wet Coat	2~3 Layer:	Wet Coat
3rd Layer:	Wet Coat	Effect coat:	Mist Coat
Drying Method	Flash off between coats	Flash off before clear Coat	Gloss after drying, 60°
Air Dry at 20°C/70°F (Panel temperature)	5~10 mins	Until Matte (10~15 mins)	/
	Temperature and humidity will affect drying speed.	If <10°C/50°F, warm up spray booth to 20°C/70°F	
Cleaning of Substrate	Sand the repaired area correctly and then clean it. If the substrate is wet-on-wet primer, no sanding is required.		
Trouble Shooting	If there are any small damage or defect found after base coat dry, such as perspiration spots, dust impregnation, fish eye/Craters, second repair is needed.  Wait 20~30 mins before sand base coat. Lightly sand the damaged area with #P600 grid disk, clean sanding dust before re-spray. If damaged area is too big, suggest to redo this job.		
Safety notes: read carefully before use	<p>1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.</p> <p>2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.</p> <p>3. The toners must be thoroughly stirred before mixing. Matellics will have different color shades due to different film thickness and different spraying methods.</p> <p>4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.</p> <p>Paint mixing, spraying, and waste disposal must comply with local laws and regulations</p> <p><b>Only for professional use.</b></p>		



## S series 2K toners

S series is a premium 2K top coat system, with high gloss, coverage and weather resistant. Use together with 2K hardener A801/802/803 for good performance.

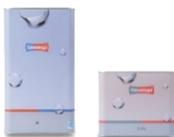
Appearance	Liquid with various colors, No impurities and turbidity	Substrate	Primer sand by p400~p600, wet on wet primer until matte, Prepared original old paint film
Density	/	Next Process	Polishing if needed
VOC	≤580g/L	Shelf Life Unopened	24 months
 Mixing Ratio Weight	2:1:0.2~0.6	Mixing Ratio Volume	2:1:0.2~0.6
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A801	A802	A803
Reducer	A810	A811	A812
 Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet: 1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet: 1.5-2.0bar		
 Pot Life after mixed	2 Hours(20°C)	Filter	120-150Mesh
Storage after mixed	2 Hours(20°C)	Application Viscosity	16-18"/DIN 4mm/20°C
 Application Tips	2-3 Layers	Flash off between coats	5-8 mins
 1st Layer:	Med. Wet Coat	Flash off before baking	8-10 mins
2nd Layer:	Wet Coat	Film Thickness	40~80µm
3rd Layer:	Wet Coat	Recoat Open Window	Within 24 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Polish	Gloss after drying, 60°
Force dry at 60°C/140°F (Panel temperature)	8~10 mins	30 mins After cooling down	>90°
Air Dry at 23°C/75°F (Panel temperature)	15-20 mins	3-4Hours	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Polishing	<b>Judging conditions:</b> Finger touch method, pressing panel by finger without finger marks. <b>Defect treatment:</b> Use scraper, 1000/1500# sand paper to remove dirty spots or sagging. <b>Polishing note:</b> pay attention to Panel temperature, pressure, force, speed of polishing. <b>Suggested polishing time:</b> within 1-6 hours after panels dried.		
   Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A850 Weather-resistant clear 2:1

2K Clear Coat for Refinish use. Good gloss and weather resistant.

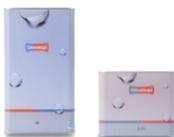
Appearance	Transparent Liquid No impurities, turbidity	Substrate	Onwings/Onwaves base coat 2K top coat after sand by #1000 sand paper.
Density	0.98~1.02	Next Process	Polishing if needed
VOC	≤480g/L	Shelf Life Unopened	24 months
 Mixing Ratio Weight	2:1:0.1~0.4	 Mixing Ratio Volume	2:1:0.1~0.4
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A801	A802	A803
Reducer	A810	A811	A812
 Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar (suggested)		
 Pot Life after mixed	2Hours	Filter	180-200Mesh
 Storage after mixed	2Hours	Application Viscosity	16-18" /DIN 4mm/20°C
 Application Tips	2-3 Layers	Flash off between coats	5-8 mins
 1st Layer:	Med. Wet Coat	Flash off before baking	8-10 mins
2nd Layer:	Wet Coat	Film Thickness	40~80um
3rd Layer:	Wet Coat	Recoat Open Window	Within 24 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Polish	Gloss after drying, 60°
Force dry at 60°C/140°F (Panel temperature)	5-10 mins	35 mins	≥90 °
Air Dry at 23°C/75°F (Panel temperature)	15-20 mins	4-6Hours	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
 Tips for Polishing	<b>Judging conditions:</b> Finger touch method, pressing panel by finger without finger marks. <b>Defect treatment:</b> Use scraper, 1000/1500# sand paper to remove dirty spots or sagging. <b>Polishing note:</b> pay attention to Panel temperature, pressure, force, speed of polishing. <b>Suggested polishing time:</b> within 1-6 hours after panels dried.		
 Safety notes: read carefully before use	<ol style="list-style-type: none"> <li>Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.</li> <li>liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.</li> <li>Drying instructions: When the film thickness is too high, the drying time will be extended.</li> <li>This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.</li> </ol> Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A852 MS Clear 2:1

Classic MS 2K Clear Coat for Refinish use. With balanced performance.

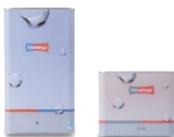
Appearance	Transparent Liquid No impurities, turbidity	Substrate	Onwings/Onwaves Base Coat 2K Top Coat after sand by #1000 sand paper.
Density	0.98~1.02	Next Process	Polishing if needed
VOC	≤480g/L	Shelf Life Unopened	24 months
 Mixing Ratio Weight	2:1:0.3~0.5	 Mixing Ratio Volume	2:1:0.3~0.5
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A801	A802	A803
Reducer	A810	A811	A812
 Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar (suggested)		
 Pot Life after mixed	2Hours	Filter	180-200Mesh
 Storage after mixed	2Hours	Application Viscosity	16-18" /DIN 4mm/20°C
 Application Tips	2-3 Layers	Flash off between coats	5-8 mins
 1st Layer:	Med. Wet Coat	Flash off before baking	8-10 mins
2nd Layer:	Wet Coat	Film Thickness	40~80um
3rd Layer:	Wet Coat	Recoat Open Window	Within 24 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Polish	Gloss after drying, 60°
Force dry at 60°C/140°F (Panel temperature)	5-10 mins	40 mins	≥90 °
Air Dry at 23°C/75°F (Panel temperature)	15-20 mins	3-4Hours	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
 Tips for Polishing	<b>Judging conditions:</b> Finger touch method, pressing panel by finger without finger marks. <b>Defect treatment:</b> Use scraper, 1000/1500# sand paper to remove dirty spots or sagging. <b>Polishing note:</b> pay attention to Panel temperature, pressure, force, speed of polishing. <b>Suggested polishing time:</b> within 1-6 hours after panels dried.		
 Safety notes: read carefully before use	<ol style="list-style-type: none"> <li>Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.</li> <li>liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.</li> <li>Drying instructions: When the film thickness is too high, the drying time will be extended.</li> <li>This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.</li> </ol> Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A853 Anti-solvent popping MS clear 2:1

2K Clear Coat for Refinish use. Good performance in poor spraying environment

Appearance	Transparent Liquid No impurities, turbidity	Substrate	Onwings/Onwaves Base Coat 2K Top Coat after sand by #1000 sand paper.
Density	0.98~1.02	Next Process	Polishing if needed
VOC	≤480g/L	Shelf Life Unopened	24 months
 Mixing Ratio Weight	2:1:0.3~0.5	 Mixing Ratio Volume	2:1:0.3~0.5
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A801	A802	A803
Reducer	A810	A811	A812
 Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar (suggested)		
 Pot Life after mixed	2Hours	Filter	180-200Mesh
 Storage after mixed	2Hours	Application Viscosity	16-18" /DIN 4mm/20°C
 Application Tips	2-3 Layers	Flash off between coats	5-8 mins
 1st Layer:	Med. Wet Coat	Flash off before baking	8-10 mins
2nd Layer:	Wet Coat	Film Thickness	40~80um
3rd Layer:	Wet Coat	Recoat Open Window	Within 24 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Polish	Gloss after drying, 60°
Force dry at 60°C/140°F (Panel temperature)	5-10 mins	40 mins	≥90 °
Air Dry at 23°C/75°F (Panel temperature)	15-20 mins	3-4Hours	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
 Tips for Polishing	<b>Judging conditions:</b> Finger touch method, pressing panel by finger without finger marks. <b>Defect treatment:</b> Use scraper, 1000/1500# sand paper to remove dirty spots or sagging. <b>Polishing note:</b> pay attention to Panel temperature, pressure, force, speed of polishing. <b>Suggested polishing time:</b> within 1-6 hours after panels dried.		
 Safety notes: read carefully before use	<ol style="list-style-type: none"> <li>Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.</li> <li>liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.</li> <li>Drying instructions: When the film thickness is too high, the drying time will be extended.</li> <li>This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.</li> </ol> Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A855 Hi-weather-resistance clear 2:1

Good gloss and hardness and extra weather resistant

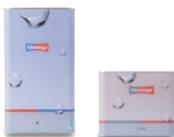
Appearance	Transparent Liquid No impurities, turbidity	Substrate	Onwings/Onwaves Base Coat 2K Top Coat after sand by #1000 sand paper.
Density	0.98~1.02	Next Process	Polishing if needed
VOC	≤480g/L	Shelf Life Unopened	24 months
 Mixing Ratio Weight	2:1:0.2~0.4	 Mixing Ratio Volume	2:1:0.2~0.4
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A801	A802	A803
Reducer	A810	A811	A812
 Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar (suggested)		
 Pot Life after mixed	2Hours	Filter	180-200Mesh
 Storage after mixed	2Hours	Application Viscosity	16-18" /DIN 4mm/20°C
 Application Tips	2-3 Layers	Flash off between coats	5-8 mins
 1st Layer:	Med. Wet Coat	Flash off before baking	8-10 mins
2nd Layer:	Wet Coat	Film Thickness	40~80um
3rd Layer:	Wet Coat	Recoat Open Window	Within 24 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Polish	Gloss after drying, 60°
Force dry at 60°C/140°F (Panel temperature)	5-10 mins	35 mins	≥90 °
Air Dry at 23°C/75°F (Panel temperature)	15-20 mins	3-4Hours	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
 Tips for Polishing	<b>Judging conditions:</b> Finger touch method, pressing panel by finger without finger marks. <b>Defect treatment:</b> Use scraper, 1000/1500# sand paper to remove dirty spots or sagging. <b>Polishing note:</b> pay attention to Panel temperature, pressure, force, speed of polishing. <b>Suggested polishing time:</b> within 1-6 hours after panels dried.		
 Safety notes: read carefully before use	<ol style="list-style-type: none"> <li>Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.</li> <li>liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.</li> <li>Drying instructions: When the film thickness is too high, the drying time will be extended.</li> <li>This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.</li> </ol> Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A857 Low VOC HS Clear 2:1

European standard Low VOC clear coat.  
Flagship clear coat. Premium gloss and hardness, Fast curing.

Appearance	Transparent Liquid No impurities, turbidity	Substrate	Onwings/Onwaves BaseCoat 2K Top Coat after sand by #1000 sand paper.
Density	0.98~1.02	Next Process	Polishing if needed
VOC	≤420g/L	Shelf Life Unopened	24 months
Mixing Ratio Weight	2:1:0.4~0.6	Mixing Ratio Volume	2:1:0.4~0.6
Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A804		
Reducer	A810	A811	A812
Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar (suggested)		
Pot Life after mixed	2Hours	Filter	180-200Mesh
Storage after mixed	2Hours	Application Viscosity	16-18" /DIN 4mm/20°C
Application Tips	1-2 Layers	Flash off between coats	5-8 mins
1st Layer:	Med. Wet Coat	Flash off before baking	8-10 mins
2nd Layer:	Wet Coat	Film Thickness	40~80um
3rd Layer:		Recoat Open Window	Within 8 hours, Sanding is not needed
Curing Method	Dust Free	Ready for Polish	Gloss after drying, 60°
Force dry at 60°C/140°F (Panel temperature)	5 mins	20-25 mins	≥90°
Air Dry at 23°C/75°F (Panel temperature)	10-15 mins	1.5-2Hours	
Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Polishing	<b>Judging conditions:</b> Finger touch method, pressing panel by finger without finger marks. <b>Defect treatment:</b> Use scraper, 1000/1500# sand paper to remove dirty spots or sagging. <b>Polishing note:</b> pay attention to Panel temperature, pressure, force, speed of polishing. <b>Suggested polishing time:</b> within 1-6 hours after panels dried.		
Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## 138 2K Production Clear Coat

2K Clear Coat for univeral jobs. Good gloss and weather resistant.

Appearance	Transparent Liquid No impurities, turbidity	Substrate	Onwings/Onwaves BaseCoat 2K Top oat after sand by #1000 sand paper.
Density	0.98~1.02	Next Process	Polishing if needed
VOC	≤480g/L	Shelf Life Unopened	24 months
	4-6Hours	4-6Hours	4-6Hours
	Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C,60°F~80°F
	Hardener	139F	139
	Reducer	A810	A812
	Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar (suggested)	
	Pot Life after mixed	2Hours	Filter
	Storage after mixed	2Hours	Application Viscosity
			180-200Mesh
	Application Tips	2-3 Layers	Flash off between coats
	1st Layer:	Med. Wet Coat	Flash off before baking
	2nd Layer:	Wet Coat	Film Thickness
	3rd Layer:	Wet Coat	Recoat Open Window
			Within 24 hours, Sanding is not needed
	Curing Method	Dust Free	Ready for Polish
	Force dry at 60°C/140°F (Panel temperature)	5-10 mins	45 mins
	Air Dry at 23°C/75°F (Panel temperature)	15-20 mins	4-6Hours
			≥90 °
	Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.	
	Tips for Polishing	<b>Judging conditions:</b> Finger touch method, pressing panel by finger without finger marks. <b>Defect treatment:</b> Use scraper, 1000/1500# sand paper to remove dirty spots or sagging. <b>Polishing note:</b> pay attention to Panel temperature, pressure, force, speed of polishing. <b>Suggested polishing time:</b> within 1-6 hours after panels dried.	
	Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.	
		2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.	
		3. Drying instructions: When the film thickness is too high, the drying time will be extended.	
		4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.	
		Paint mixing, spraying, and waste disposal must comply with local laws and regulations	
		<b>Only for professional use.</b>	



## A867 Matt Clear Coat

2K Matt Clear Coat. For repair different matt level car surface.

Appearance	Translucent Liquid No impurities, turbidity	Substrate	Onwings/Onwaves BaseCoat 2K Top Coat after sand by #1000 sand paper.					
Density	0.98~1.02	Next Process	/					
VOC	≤630g/L	Shelf Life Unopened	24 months					
Mixing Ratio Weight	3:1:0.6~0.8	Mixing Ratio Volume	3:1:0.6~0.8					
Glossiness(°) 60° angle gloss±5°	15°	25°	35°	45°	60°	75°	90°	
A850/A852/A853	Mixing Ratio	/	10	30	50	70	90	100
A867		100	90	70	50	30	10	/
Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C,60°F~80°F	25°C~35°C, 80°F~95°F					
Hardener	A801	A802	A803					
Reducer	A810	A811	A812					
Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar							
Pot Life after mixed	2 Hours	Filter	180-200 Mesh					
Storage after mixed	2 Hours	Application Viscosity	16-18"/DIN 4mm/20°C					
Application Tips	1+2 Layers	Flash off between coats	Until matte					
1st Layer:	Mid. Wet Coat (High gloss clear coat)	Flash off before baking	Until matte(15-20mins)					
2nd Layer:	Mid.Wet Coat (Matte clear)	Film Thickness	40-80µm					
3rd Layer:	Wet Coat (Matte clear)	Recoat Open Window	Within 24 hours, Sanding is not needed					
Curing Method	Dust Free	Ready for Finishing	Gloss after drying, 60°					
Force dry at 60°C/140°F (Panel temperature)	5-10 mins	35 mins	/					
Air Dry at 23°C/75°F (Panel temperature)	15-20 mins	3-4Hours						
Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.							
Tips for Polishing	/							
Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.							
	2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.							
	3. Drying instructions: When the film thickness is too high, the drying time will be extended.							
	4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.							
	Paint mixing, spraying, and waste disposal must comply with local laws and regulations							
Only for professional use.								



## A770 Super Curing Clear Coat 4:1

4:1 fast curing clear coat. High Solid, Good gloss and hardness.

Appearance	Transparent Liquid No impurities, turbidity	Substrate	Onwings BaseCoat 2K Top oat after sand by #1000 sand paper.
Density	0.98	Next Process	Polishing if needed
VOC	≤480g/L	Shelf Life Unopened	24 months
Mixing Ratio Weight	4:1:0~0.4	Mixing Ratio Volume	4:1:0~0.4
Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A707	A707	A707S
Reducer	A810	A811	A812
Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar (suggested)		
Pot Life after mixed	30 mins	Filter	180-200Mesh
Storage after mixed	30 mins	Application Viscosity	16-18" /DIN 4mm/20°C
Application Tips	1-2 Layers	Flash off between coats	2-3 mins
1st Layer:	Med. Wet Coat	Flash off before baking	3-5 mins
2nd Layer:	Wet Coat	Film Thickness	30~60um
		Recoat Open Window	Within 8 hours, Sanding is not needed
Curing Method	Dust Free	Ready for Polish	Gloss after drying, 60°
Air Dry at 23°C/75°F (Panel temperature)	2-4 mins	25-35 mins	≥90°
Air Dry at 15°C/60°F (Panel temperature)	5-8 mins	45-60 mins	
Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Polishing	<b>Judging conditions:</b> Finger touch method, pressing panel by finger without finger marks. <b>Defect treatment:</b> Use scraper, 1000/1500# sand paper to remove dirty spots or sagging. <b>Polishing note:</b> pay attention to Panel temperature, pressure, force, speed of polishing. <b>Suggested polishing time:</b> within 1-6 hours after panels dried.		
Safety notes: read carefully before use	<ol style="list-style-type: none"> <li>Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.</li> <li>liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.</li> <li>Drying instructions: When the film thickness is too high, the drying time will be extended.</li> <li>This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.</li> </ol> Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A762 2.1 Low VOC 4:1 Clear coat

Specially designed for North America 2.1 VOC regulation

Appearance	Transparent Liquid No impurities, turbidity	Substrate	Onwings/Onwaves BaseCoat 2K Top Coat after sand by #1000 sand paper.
Density	0.98~1.02	Next Process	Polishing if needed
VOC	≤248g/L (USA Standard exemption)	Shelf Life Unopened	24 months
Mixing Ratio Weight	4:1:0.2~0.6	Mixing Ratio Volume	4:1:0.2~0.6
Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A701		
Reducer	A810	A811	A812
Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar (suggested)		
Pot Life after mixed	4Hours	Filter	180-200Mesh
Storage after mixed	4Hours	Application Viscosity	16-18" /DIN 4mm/20°C
Application Tips	2-3 Layers	Flash off between coats	5-8 mins
1st Layer:	Med. Wet Coat	Flash off before baking	8-10 mins
2nd Layer:	Wet Coat	Film Thickness	40~80um
3rd Layer:	Wet Coat	Recoat Open Window	Within 24 hours, Sanding is not needed
Curing Method	Dust Free	Ready for Polish	Gloss after drying, 60°
Force dry at 60°C/140°F (Panel temperature)	10-15 mins	50 mins	≥90°
Air Dry at 23°C/75°F (Panel temperature)	20-25 mins	5 Hours	
Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Polishing	<b>Judging conditions:</b> Finger touch method, pressing panel by finger without finger marks. <b>Defect treatment:</b> Use scraper, 1000/1500# sand paper to remove dirty spots or sagging. <b>Polishing note:</b> pay attention to Panel temperature, pressure, force, speed of polishing. <b>Suggested polishing time:</b> within 1-6 hours after panels dried.		
Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A763 Low VOC MS Clear coat 2:1

Specially designed for North America 2.1 VOC regulation

Appearance	Transparent Liquid No impurities, turbidity	Substrate	Onwings/Onwaves BaseCoat 2K Top Coat after sand by #1000 sand paper.
Density	0.98~1.02	Next Process	Polishing if needed
VOC	≤248g/L (USA Standard exemption)	Shelf Life Unopened	24 months
 Mixing Ratio Weight	2:1:0.2~0.4	Mixing Ratio Volume	2:1:0.2~0.4
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A703		
Reducer	A810	A811	A812
 Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar (suggested)		
 Pot Life after mixed	4Hours	Filter	180-200Mesh
Storage after mixed	4Hours	Application Viscosity	16-18" /DIN 4mm/20°C
 Application Tips	2-3 Layers	Flash off between coats	5-8 mins
 1st Layer:	Med. Wet Coat	Flash off before baking	8-10 mins
2nd Layer:	Wet Coat	Film Thickness	40~80um
3rd Layer:	Wet Coat	Recoat Open Window	Within 24 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Polish	Gloss after drying, 60°
Force dry at 60°C/140°F (Panel temperature)	10-15 mins	50 mins	≥90°
Air Dry at 23°C/75°F (Panel temperature)	20-25 mins	5 Hours	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Polishing	<b>Judging conditions:</b> Finger touch method, pressing panel by finger without finger marks. <b>Defect treatment:</b> Use scraper, 1000/1500# sand paper to remove dirty spots or sagging. <b>Polishing note:</b> pay attention to Panel temperature, pressure, force, speed of polishing. <b>Suggested polishing time:</b> within 1-6 hours after panels dried.		
 Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A846 Wet on Wet Primer

2K wet on wet primer, non sanding, excellent adhesion and stone-chipping resistance.

Appearance	White grey color viscous liquid No impurities, turbidity	Substrate	E-coat, Epoxy Primer, Wash Primer, Plastic Primer or Body Filler
Density	1.5	Next Process	Base Coat or 2K Top Coat
VOC	≤560g/L	Shelf Life Unopened	12 months
Mixing	Mixing Ratio Weight	Mixing Ratio Volume	Application Viscosity
Wet on Wet application	4:1:2	3:1:2	16-18" /DIN 4mm/20°C
Sand application	4:1:1	3:1:1	18-20" /DIN 4mm/20°C
Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A801	A802	A803
Reducer	A810	A811	A812
Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar		
Pot Life/storage after mixed	40 mins	Filter	120-150Mesh
1-1.5 Layers(Wet on Wet)	1st layer: Mist Coat	Film thickness (Wet on Wet)	15~20um
	2nd layer: Med. Wet Coat	Flash off (Wet on Wet)	no flash off between coats, wait until matte before BC
Curing Method	Wet on Wet application		
Force dry at 60°C/140°F (Panel temperature)	/		
Air Dry at 23°C/75°F (Panel temperature)	Until Matte(around 10 mins)		
Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for wet on wet application	Wet on wet application needs a flat and smooth substrate. Usually for for new bumper or new car doors with E-coat, or scratch repair. Thicker layer is not suggested, if wet on wet primer is thicker than suggested, may cause pin holes or adhesion issues. for darker base coat, add no more than 10% M805 toner in to wet on wet primer before mix with hardener and reducer, to get mid-dark grey color primer.		
Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.		
	2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.		
	3. Drying instructions: When the film thickness is too high, the drying time will be extended.		
	4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.		
	Paint mixing, spraying, and waste disposal must comply with local laws and regulations		
<b>Only for professional use.</b>			



## A8830/8831/8832 Tintable Primer Surfacer

Mix white and black to get different greyscale, ideal choice for saving base coat

Appearance	A8830 White, A8831 Grey, A8832 Black No impurities, turbidity	Substrate	Bare Metal, E-coat, Epoxy Primer, Wash Primer, Plastic Primer or Body Filler
Density	A8830 1.76, A8831 1.75, A8832 1.56	Next Process	Base Coat or 2K Top Coat
VOC	≤560g/L	Shelf Life Unopened	12 months

Mixing	Mixing Ratio Weight	Mixing Ratio Volume	Application Viscosity
Sand application	5:1:0~1	3:1:0~1	18-21" /DIN 4mm/20°C
Wet on Wet application	5:1:1~2	3:1:1~2	16-18" /DIN 4mm/20°C

Mixing Ratio Weight	Color	A8830	A8832
Greyscale 1	White	100	0
Greyscale 2	Light grey	85	15
Greyscale 3	Medium grey	55	45
Greyscale 4	Dark grey	20	80
Greyscale 5	Black	0	100

Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A801/A8809	A802/A8809	A803/A8809
Reducer	A810	A811	A812

Spray Gun Set Up	Suction gun: 1.5-1.7mm, Air inlet:1.5-2.0bar Gravity gun: 1.5-1.7mm, Air inlet:1.5-2.0bar		
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Pot Life after mixed	1Hours	Filter	80-100Mesh
Storage after mixed	1Hours	Application Viscosity	18-21" /DIN 4mm/20°C

Application Tips (Sanding)	2-3 Layers	Flash off between coats	3-5 mins
1st Layer:	Mist Coat	Flash off before baking	5-8 mins
2nd Layer:	Mid. Wet Coat	Film Thickness	60~90um
3rd Layer:	Wet Coat	Recoat Open Window	Within 48 hours, Sanding is not needed
Application (Wet on Wet)	1st layer: Mist Coat	Flash off (Wet on Wet)	no flash off between coats, wait until matte before BC
	2nd layer: Med. Wet Coat	Film thickness (Wet on Wet)	15~20um

Curing Method	Dust Free	Ready for Sanding	Wet on Wet
Force dry at 60°C/140°F (Panel temperature)	3-5 mins	10 mins w/ A8809, 20 mins w/ A801/802/803	/
Air Dry at 23°C/75°F (Panel temperature)	6 mins	4~6 hours	Until Matte(around 10 mins)

Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Sanding	<b>Grinding description:</b> grinding starting with P320, then move to P400/P500 for solvent base coat. P500/P600 for waterborne base coat. For wet sanding, use P800 or above. Suggest to use Carbon powder indicator to check the smoothness after sanding. clean well with blower, touch cloth and degreaser before next step.		

Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.		
	2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.		
	3. Drying instructions: When the film thickness is too high, the drying time will be extended.		
	4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.		
	Paint mixing, spraying, and waste disposal must comply with local laws and regulations		
<b>Only for professional use.</b>			



## A8833 Primer surfacer

2K Primer with good sanding and adhesion performance.

Appearance	Grey color, viscous liquid No impurities, turbidity	Substrate	Bare Metal, E-coat, Epoxy Primer, Wash Primer, Plastic Primer or Body Filler
Density	1.6	Next Process	Base Coat or 2K Top Coat
VOC	≤560g/L	Shelf Life Unopened	12 months
 Mixing Ratio Weight	5:1:1	 Mixing Ratio Volume	3:1:1
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A801	A802	A803
Reducer	A810	A811	A812
 Spray Gun Set Up	Suction gun: 1.5-1.7mm, Air inlet: 1.5-2.0bar Gravity gun: 1.5-1.7mm, Air inlet: 1.5-2.0bar		
 Pot Life after mixed	1Hours	Filter	80-100Mesh
 Storage after mixed	1Hours	Application Viscosity	18-21" /DIN 4mm/20°C
 Application Tips	2-3 Layers	Flash off between coats	3-5 mins
 1st Layer:	Mist Coat	Flash off before baking	5-8 mins
2nd Layer:	Mid. Wet Coat	Film Thickness	60~90um
3rd Layer:	Wet Coat	Recoat Open Window	Within 48 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Sanding	
Force dry at 60°C/140°F (Panel temperature)	5-8 mins	20 mins Sand after cooling down	
Air Dry at 23°C/75°F (Panel temperature)	5-8 mins	60~90 mins	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Sanding	<b>Sandpaper:</b> P320/400/500/600 <b>Grinding description:</b> grinding starting with P320, then move to P400/P500 for solvent base coat. P500/P600 for waterborne base coat. clean well before next step. For wet sanding, use P800 or above. Suggest to use Carbon powder indicator to check the smoothness after sanding.		
 Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A831 4:1 primer surfacer

Universal 2K primer, good for most repair works.

Appearance	Grey color, viscous liquid No impurities, turbidity	Substrate	Epoxy Primer, Wash Primer, Plastic Primer or Body Filler
Density	1.43	Next Process	Base Coat or 2K Top Coat
VOC	≤560g/L	Shelf Life Unopened	12 months
 Mixing Ratio Weight	4:1:1	 Mixing Ratio Volume	3:1:1
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A801	A802	A803
Reducer	A810	A811	A812
 Spray Gun Set Up	Suction gun: 1.5-1.7mm, Air inlet: 1.5-2.0bar Gravity gun: 1.5-1.7mm, Air inlet: 1.5-2.0bar		
 Pot Life after mixed	1Hours	Filter	80-100Mesh
 Storage after mixed	1Hours	Application Viscosity	18-21" /DIN 4mm/20°C
 Application Tips	2-3 Layers	Flash off between coats	3-5 mins
 1st Layer:	Mist Coat	Flash off before baking	5-8 mins
 2nd Layer:	Mid. Wet Coat	Film Thickness	60~90um
 3rd Layer:	Wet Coat	Recoat Open Window	Within 48 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Sanding	
Force dry at 60°C/140°F (Panel temperature)	5-8 mins	40 mins Sand after cooling down	
Air Dry at 23°C/75°F (Panel temperature)	10-15 mins	after 3~4 hours	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
 Tips for Sanding	<b>Sandpaper:</b> P320/400/500/600 <b>Grinding description:</b> grinding starting with P320, then move to P400/P500 for solvent base coat. P500/P600 for waterborne base coat. clean well before next step. For wet sanding, use P800 or above. Suggest to use Carbon powder indicator to check the smoothness after sanding.		
 Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A838 2.1 VOC HS Primer

High Solid Primer, Specially designed for North America 2.1 VOC regulation, with good filling and adhesion performance.

Appearance	Grey color, viscous liquid No impurities, turbidity	Substrate	Bare Metal, E-coat, Epoxy Primer, Wash Primer, Plastic Primer or Body Filler
Density	1.75	Next Process	Base Coat or 2K Top Coat
VOC	≤248g/L (USA Standard exemption)	Shelf Life Unopened	12 months
 Mixing Ratio Weight	8:1:0.4~0.5	Mixing Ratio Volume	4:1:0.4~0.5
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A703	A703	A703
Reducer	A739	A739	A739
 Spray Gun Set Up	Suction gun: 1.5-1.9mm, Air inlet:3.5-4.0bar Gravity gun: 1.5-1.9mm, Air inlet:3.5-4.0bar		
 Pot Life after mixed	4 hours	Filter	80-100Mesh
Storage after mixed	4 hours	Application Viscosity	20-30" /DIN 4mm/20°C
 Application Tips	2-3 Layers	Flash off between coats	3-5 mins
 1st Layer:	Mist Coat	Flash off before baking	10-15 mins
2nd Layer:	Mid. Wet Coat	Film Thickness	60~180um
3rd Layer:	Wet Coat	Recoat Open Window	Within 48 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Sanding	
Force dry at 60°C/140°F (Panel temperature)	10-15 mins	60-80 mins Sand after cooling down	
Air Dry at 23°C/75°F (Panel temperature)	15-25 mins	4~5 hours	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Sanding	<b>Sandpaper:</b> P320/400/500/600 <b>Grinding description:</b> grinding starting with P320, then move to P400/P500 for solvent base coat. P500/P600 for waterborne base coat. clean well before next step. For wet sanding, use P800 or above. Suggest to use Carbon powder indicator to check the smoothness after sanding.		
 Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A839 HS High Build Primer

High Build Primer, film build 120~180mu by 2-3 layers. For big area of deep damage.

Appearance	Grey color, viscous liquid No impurities, turbidity	Substrate	Bare Metal, E-coat, Epoxy Primer, Wash Primer, Plastic Primer or Body Filler
Density	1.82	Next Process	Base Coat or 2K Top Coat
VOC	≤560g/L	Shelf Life Unopened	12 months
Mixing Ratio Weight	8:1:0.25~0.5	Mixing Ratio Volume	5:1:0.25~0.5
Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A801	A802	A803
Reducer	A810	A811	A812
Spray Gun Set Up	Suction gun: 1.5-1.9mm, Air inlet:3.5-4.0bar Gravity gun: 1.5-1.9mm, Air inlet:3.5-4.0bar		
Pot Life after mixed	4 hours	Filter	80-100Mesh
Storage after mixed	4 hours	Application Viscosity	20-24" /DIN 4mm/20°C
Application Tips	2-3 Layers	Flash off between coats	3-5 mins
1st Layer:	Mist Coat	Flash off before baking	10-15 mins
2nd Layer:	Mid. Wet Coat	Film Thickness	120~180um
3rd Layer:	Wet Coat	Recoat Open Window	Within 48 hours, Sanding is not needed
Curing Method	Dust Free	Ready for Sanding	
Force dry at 60°C/140°F (Panel temperature)	10-15 mins	60-80 mins Sand after cooling down	
Air Dry at 23°C/75°F (Panel temperature)	15-25 mins	4~5 hours	
Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Sanding	<b>Sandpaper:</b> P320/400/500/600 <b>Grinding description:</b> grinding starting with P320, then move to P400/P500 for solvent base coat. P500/P600 for waterborne base coat. clean well before next step. For wet sanding, use P800 or above. Suggest to use Carbon powder indicator to check the smoothness after sanding.		
Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A870 Super Curing primer

Expressive curing speed, good for cold application environment

Appearance	Grey color, viscous liquid No impurities, turbidity	Substrate	E-coat, Epoxy Primer, Wash Primer, Plastic Primer or Body Filler
Density	1.75	Next Process	Base Coat or 2K Top Coat
VOC	≤560g/L	Shelf Life Unopened	12 months
 Mixing Ratio Weight	5:1:1~2	 Mixing Ratio Volume	3:1:1~2
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A807		
Reducer	A810	A811	A812
 Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet: 1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet: 1.5-2.0bar		
 Pot Life after mixed	40 mins	Filter	80-100Mesh
 Storage after mixed	40 mins	Application Viscosity	16-18" /DIN 4mm/20°C
 Application Tips	1-2 Layers	Flash off between coats	2-3mins
 1st Layer:	Mist Coat	Flash off before baking	3-5 mins
2nd Layer:	Med. Wet Coat	Film Thickness	20~30um
		Recoat Open Window	Within 24 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Sanding	
Force dry at 60°C/140°F (Panel temperature)	2 mins	10-15 mins	
Air Dry at 23°C/75°F (Panel temperature)	5 mins	25-35 mins	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Sanding	<b>Sandpaper:</b> P320/400/500/600 <b>Grinding description:</b> grinding starting with P320, then move to P400/P500 for solvent base coat. P500/P600 for waterborne base coat. clean well before next step. For wet sanding, use P800 or above. Suggest to use Carbon powder indicator to check the smoothness after sanding.		
 Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A830 1K NC Surfer

1K Primer, traditional technology

Appearance	Grey color, viscous liquid No impurities, turbidity	Substrate	E-coat, Epoxy Primer, Wash Primer, Plastic Primer or Body Filler
Density	1.44	Next Process	Base Coat or 2K Top Coat
VOC	≤560g/L	Shelf Life Unopened	12 months
 Mixing Ratio Weight	1:0.6~0.8	 Mixing Ratio Volume	1:0.4~0.55
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener			
Reducer	A810	A811	A812
 Spray Gun Set Up	Suction gun: 1.5-1.7mm, Air inlet: 1.5-2.0bar Gravity gun: 1.5-1.7mm, Air inlet: 1.5-2.0bar		
 Pot Life after mixed	4 hours	Filter	80-100Mesh
 Storage after mixed	4 hours	Application Viscosity	16-18" /DIN 4mm/20°C
 Application Tips	2-3 Layers	Flash off between coats	3-5 mins
 1st Layer:	Mist Coat	Flash off before baking	5-8 mins
2nd Layer:	Mid. Wet Coat	Film Thickness	45-60um
3rd Layer:	Wet Coat	Recoat Open Window	Within 48 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Sanding	
Force dry at 60°C/140°F (Panel temperature)	5-8 mins	30 mins	
Air Dry at 23°C/75°F (Panel temperature)	10-15 mins	4 hours	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Sanding	<b>Sandpaper:</b> P320/400/500/600 <b>Grinding description:</b> grinding starting with P320, then move to P400/P500 for solvent base coat. P500/P600 for waterborne base coat. clean well before next step. For wet sanding, use P800 or above. Suggest to use Carbon powder indicator to check the smoothness after sanding.		
 Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A832 Plastic Primer

1K Plastic Primer, for automotive external plastic parts. Improving adhesion.

Appearance	Grey color, viscous liquid No impurities, turbidity	Substrate	Plastic PP or TPO
Density	0.98	Next Process	2K Primer
VOC	≤580g/L	Shelf Life Unopened	12 months
 Mixing Ratio Weight	Direct use after stir well	Mixing Ratio Volume	Direct use after stir well
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener			
Reducer			
 Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar		
 Pot Life	4 hours Shake well after 1 hour	Filter	120-150Mesh
Storage	4 hours Shake well after 1 hour		
 Application Tips	1-2 Layers	Flash off between coats	3-5 mins
 1st Layer:	Mist Coat	Flash off before baking	/
2nd Layer:	Med. Wet Coat	Film Thickness	5~15um
		Recoat Open Window	Within 24 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Sanding	
Force dry at 60°C/140°F (Panel temperature)	/	/	
Air Dry at 23°C/75°F (Panel temperature)	Wait 10-15 minutes to next process		
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Application Note:	Plastic Primer is mainly for improve adhesion between plastic and other paint layers. With very limited filling power, after spray, 10-15mins flash off, then next process, do not need sanding.		
 Safety notes: read carefully before use	<p>1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.</p> <p>2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.</p> <p>3. Drying instructions: When the film thickness is too high, the drying time will be extended.</p> <p>4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.</p> <p>Paint mixing, spraying, and waste disposal must comply with local laws and regulations</p> <p><b>Only for professional use.</b></p>		



## A834/A835/A836 Plastic Primer

1K Plastic Primer, for automotive external plastic parts. Have different greyscale for different color of base coat.

Appearance	A834 Grey A835 White A836 Transparent	Substrate	Plastic PP or TPO
Density	A834 0.98~1.02 A835 1.02, A836 0.89	Next Process	2K Primer
VOC	≤580g/L	Shelf Life Unopened	12 months
 Mixing Ratio Weight	Direct use after stir well	Mixing Ratio Volume	Direct use after stir well
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener			
Reducer			
 Spray Gun Set Up	Suction gun: 1.3-1.5mm, Air inlet:1.5-2.0bar Gravity gun: 1.3-1.5mm, Air inlet:1.5-2.0bar		
 Pot Life	4 hours Shake well after 1 hour	Filter	120-150Mesh
Storage	4 hours Shake well after 1 hour		
 Application Tips	1-2 Layers	Flash off between coats	3-5 mins
 1st Layer:	Mist Coat	Flash off before baking	/
2nd Layer:	Med. Wet Coat	Film Thickness	5~15um
		Recoat Open Window	Within 24 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for Sanding	
Force dry at 60°C/140°F (Panel temperature)	/	/	
Air Dry at 23°C/75°F (Panel temperature)	Wait 10-15 minutes to next process		
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Application note	Plastic Primer is mainly for improve adhesion between plastic and other paint layers. With very limited filling power, after spray,10-15mins flash off, then next process, do not need sanding.		
 Safety notes: read carefully before use	<p>1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.</p> <p>2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.</p> <p>3. Drying instructions: When the film thickness is too high, the drying time will be extended.</p> <p>4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.</p> <p>Paint mixing, spraying, and waste disposal must comply with local laws and regulations</p> <p><b>Only for professional use.</b></p>		



## A844 5:1 Epoxy Primer

2K Epoxy primer, apply on bare metal, for anti corrosion purpose.

Appearance	Grey color, viscous liquid No impurities, turbidity	Substrate	Bare metal
Density	1.4	Next Process	Body Filler or Intermediate Primer
VOC	≤580g/L	Shelf Life Unopened	12 months
Mixing Ratio Weight	5:1:1~1.5	Mixing Ratio Volume	4:1:1~1.5
Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	A891	A891	A891
Reducer	A810/A892	A811/A892	A812/A892
Spray Gun Set Up	Suction gun: 1.3-1.6mm, Air inlet: 1.5-2.0bar Gravity gun: 1.3-1.6mm, Air inlet: 1.5-2.0bar		
Pot Life after mixed	2Hours	Filter	120-150Mesh
Storage after mixed	2Hours	Application Viscosity	18-21" /DIN 4mm/20°C
Application Tips	1-2 Layers	Flash off between coats	2-3 mins
1st Layer:	Mist Coat	Flash off before baking	3-5 mins
2nd Layer:	Med. Wet Coat	Film Thickness	30~60um
		Recoat Open Window	Within 72 hours, Sanding is not needed
Curing Method	Dust Free	Ready for Sanding	
Force dry at 60°C/140°F (Panel temperature)	5-8 mins	30 mins Sand after cooling down	
Air Dry at 23°C/75°F (Panel temperature)	20-30 mins	4 hours	
Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Sanding	<b>Sandpaper:</b> P80/120/180/240/320 <b>Grinding description:</b> grinding starting with P80 or P120, then move to P180/P240 for 2K sand primer. P320 for wet on wet primer. clean well before next step. Suggest to use Carbon powder indicator to check the smoothness after sanding.		
Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## A8402 Wash Primer

1K Wash Primer, apply on bare matel, for anti corrosion purpose.

Appearance	Grey color, viscous liquid No impurities, turbidity	Substrate	Bare matel
Density	1~1.1	Next Process	Body Filler or Intermediate Primer
VOC	≤580g/L	Shelf Life Unopened	12 months
 Mixing Ratio Weight	1:2±15%	Mixing Ratio Volume	1:1~1.2
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener			
Reducer	A8117	A8117	A8117
 Spray Gun Set Up	Suction gun: 1.1-1.3mm, Air inlet:1.5-2.0bar Gravity gun: 1.1-1.3mm, Air inlet:1.5-2.0bar (suggested)		
 Pot Life after mixed	3~4Hours	Filter	120-150Mesh
Storage after mixed	3~4Hours	Application Viscosity	13~15" /DIN 4mm/20°C
 Application Tips	1-2 Layers	Flash off between coats	/
 1st Layer:	Mist Coat	Flash off before baking	/
 2nd Layer:	Med. Wet Coat	Film Thickness	5~10um
		Recoat Open Window	Within 24 hours, Sanding is not needed
 Curing Method	Dust Free	Ready for next step	
Force dry at 60°C/140°F (Panel temperature)	/	3~5 mins	
Air Dry at 23°C/75°F (Panel temperature)	/	5~10 mins	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Application note	Wash Primer is mainly for anti-corrosion purpose. With very limited filling power, after spray,5-10mins flash off, then next process, do not need sanding.		
 Safety notes: read carefully before use	<p>1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.</p> <p>2. liquid coatings may react with water vapor in the air and become unusable. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.</p> <p>3. Drying instructions: When the film thickness is too high, the drying time will be extended.</p> <p>4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.</p> <p>Paint mixing, spraying, and waste disposal must comply with local laws and regulations</p> <p><b>Only for professional use.</b></p>		



## A820 - Plastic Cleanser

	Product type	Designed for surface cleaning and anti static treatment of plastic parts.
	Purpose	Remove the grease, release agent, lubricant and other contamination on plastic, avoiding static electricity, strengthen the adhesion.
	Mixing ratio	No need to mix, ready for use
	Cleaning guide	Spray plastic Cleanser to plastic part, and gently wipe with cleaning cloth.
	Instructions	1. Be sure panel is completely dry before next step. 2. Parts with heavy static or soiled may need to be treated twice.
	Safety	Strongly recommended to use appropriate personal protection during application to avoid respiratory, skin and eye irritation.
	Package size	1L



## A825 - Plastic Softener

	Product type	2K additive, designed for improving flexibility of paint film.
	Purpose	To avoid issues of paint film cracking, loss of adhesion on Plastic parts after Significant temperature changes.
	Mixing ratio Before mix with hardener/reducer	2K Primer: A825=2:1 2K color, 2K Clear coat: A825=1:20~50% by weight
	Application	After added plastic softener, just spray in same way of original Primer, 2K color or clear coat.
	Application Notes	1. Flash off and drying time will be 20% longer after added A825. 2. Bake less than 60°C to avoid blister risk.
	Safety	Strongly recommended to use appropriate personal protection during application to avoid respiratory, skin and eye irritation.
	Package size	1L



## A828/A828S - Degreaser

	Product type	Multi Purpose Degreasing cleanser for refinish work.
	Purpose	To remove the grease, release agent, lubricant and other contamination on substrate. A828S is slower than A828.
	Mixing ratio	No need to mix, ready for use.
	Cleaning guide	Spray degreaser to substrate, and gently wipe with cleaning cloth.
	Instructions	1. Be sure panel is completely dry before next step. 2. Parts with heavy static or soiled may need to be treated twice.
	Safety	Strongly recommended to use appropriate personal protection during application to avoid respiratory, skin and eye irritation.
	Package size	1L/ 5L



## A829 - Fish-Eye Eliminator

	Product type	Additive for the last step of finishing.
	Purpose	Prevention for film defects, for example: fish-eye, pit and contraction cavity and so on because of poor spraying environment.
	Mixing ratio	Ready mixed 2K topcoat : Fish Eye Eliminator = 1:0.008~0.04 by weight.
	Application	After added Eliminator, the first layer of clear coat must be mist coat, and other layers same with standard clear coat or 2K color application.
	Application Notes	Stir well the mixture of 2K Top coat and Eliminator before spray.
	Safety	Strongly recommended to use appropriate personal protection during application to avoid respiratory, skin and eye irritation.
	Package size	1L



## A350 - Fade-Out Reducer

	Product type	Strong solvent to integrate new & old paint films at edge of repair work.
	Purpose	To disable the rough edge of repair work, integrate new & old paint films together and recuring.
	Mixing ratio	Ready mixed clearcoat : Fade-Out Reducer = 2:1 by weight or volume
	Application	On the edge of repair work, spray 1 layer of mixture of clear coat and fade-out reducer, then 100% fade out reducer to spray 2 mist coat.
	Application Notes	Fade out reducer can not be used as a normal reducer.
	Safety	Strongly recommended to use appropriate personal protection during application to avoid respiratory, skin and eye irritation.
	Package size	1L



## A822 - Fast Dry Agent

	Product type	Additive for the last step of finishing, like 2K clear coat and 2K color.
	Purpose	Improve the speed of drying.
	Mixing ratio	2K top coat : Fast dry Agent = 1:0.01~0.1 by weight before mixing with hardener and Reducer.
	Application	After added fast dry agent, spray in the same way of standard 2K top coat application.
	Application Notes	Stir well the mixture of 2K top coat and Fast dry Agent before spray. Add too much fast dry agent, may cause gloss lossing.
	Safety	Strongly recommended to use appropriate personal protection during application to avoid respiratory, skin and eye irritation.
	Package size	1L



## S777 - Gloss Reducer

	Product type	Additive for the last step of finishing, like 2K clear coat and 2K color.
	Purpose	Reduce the gloss level and match the gloss level of target panel.
	Mixing ratio before mix hardener/reducer	2K Clear coat/2K color : Gloss reducer 1: 0- 65% by weight
	Application	After added gloss reducer, spray in the same way of standard 2K top coat application.
	Application Notes	<p>1, Stir well the mixture of 2K top coat and gloss reducer before spray. After mixed, and stock for more than 15mins before spray, need to shake or stir again to ensure performance.</p> <p>2, Will reduce coverage after added to 2K color.</p> <p>3, Leave enough flash off time between layers and before baking to avoid uneven gloss or highlight spot issues.</p> <p>4, the gloss level reduced will be effect by difference of original gloss of 2K top coat, thickness of spray layers and drying speed. slower hardener, slower reducer, longer flash off time and lower baking temperature will get better gloss reducing performance.</p>
	Safety	Strongly recommended to use appropriate personal protection during application to avoid respiratory, skin and eye irritation.
	Package size	1L / 3.5L



## Body Filler AK27/AK28

Unsaturated polyester body filler. Universal use.

Appearance	Light yellow viscous paste	Substrate	E-coat, Epoxy Primer, Wash Primer
Density	1.96	Next Process	Intermediate Primer
VOC	<550g/L	Shelf Life Unopened	12 months
 Mixing Ratio Weight	Puty:Hardener 1:1%~3%	Mixing Ratio Volume	/
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	2%~3%	2%	1~2%
Notes about mixing hardeners.	1, Add > 3% or <1% hardener, will reduce the adhesion and bad curing condition. 2, To apply thick layer of body filler on panels, need to reduce the hardener amount.		
 Pot Life after mixed	3~5 mins	Heat Resistant	<100°C After cured
Storage after mixed	3~5 mins		
1st Layer:	Blade coating a thin layer to the damaged area	Flash off between coats	/
2nd Layer:	Apply to the edges of the damaged area	Flash off before baking	/
3rd Layer:	Repeat the blade in center of damage area	Film Thickness	as per needed
4th Layer:	Then thin layer to cover the whole damage area	Recoat Open Window	/
 Curing Method	Dust Free	Ready for Sanding	
Force dry at 60°C/140°F (Panel temperature)	2~3 mins	10 mins	
Air Dry at 23°C/75°F (Panel temperature)	5-10 mins	15~30 mins	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Sanding	<b>Sandpaper:</b> P80/120/180/240/320 <b>Grinding description:</b> grinding starting with P80 or P120, then move to P180/P240 for 2K sanding primer. additional P320 for wet on wet primer. clean well before next step. Suggest to use Carbon powder indicator to check the smoothness after sanding.		
 Safety notes: read carefully before use	1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly. 2. Body filler is easy to get dry. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner. 3. Drying instructions: When the film thickness is too high, the drying time will be extended. 4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician. Paint mixing, spraying, and waste disposal must comply with local laws and regulations <b>Only for professional use.</b>		



## Fine Body Filler AK58

Unsaturated polyester body filler. Finer finishing.

Appearance	Light yellow viscous paste	Substrate	E-coat, Epoxy Primer, Wash Primer
Density	1.96	Next Process	Intermediate Primer
VOC	<550g/L	Shelf Life Unopened	12 months
 Mixing Ratio Weight	1:0.01~0.03	Mixing Ratio Volume	/
 Application Temperature	5°C~15°C, 40°F~60°F	15°C~25°C, 60°F~80°F	25°C~35°C, 80°F~95°F
Hardener	2%~3%	2%	1~2%
Notes about mixing hardeners.	1, Add > 3% or <1% hardener, will reduce the adhesion and bad curing condition. 2, To apply thick layer of body filler on panels, need to reduce the hardener amount.		
 Pot Life after mixed	3~5 mins	Heat Resistant	<100°C After cured
Storage after mixed	3~5 mins		
1st Layer:	Blade coating a thin layer to the damaged area	Flash off between coats	/
2nd Layer:	Apply to the edges of the damaged area	Flash off before baking	/
3rd Layer:	Repeat the blade in center of damage area	Film Thickness	as per needed
4th Layer:	Then thin layer to cover the whole damage area	Recoat Open Window	/
 Curing Method	Dust Free	Ready for Sanding	
Force dry at 60°C/140°F (Panel temperature)	2~3 mins	10 mins	
Air Dry at 23°C/75°F (Panel temperature)	5-10 mins	15~30 mins	
 Cleaning of Substrate	If substrate polluted by dust/grease, use A828 Degreaser to gently wipe with cleaning cloth.		
Tips for Sanding	<b>Sandpaper:</b> P80/120/180/240/320 <b>Grinding description:</b> grinding starting with P80 or P120, then move to P180/P240 for 2K sanding primer. additional P320 for wet on wet primer. clean well before next step. Suggest to use Carbon powder indicator to check the smoothness after sanding.		
 Safety notes: read carefully before use	<p>1. Please wear personal protections during use and avoid direct contact with the skin and inhalation of paint, curing agents, and diluents. If accidentally inhaled into the body, please seek medical attention promptly.</p> <p>2. Body filler is easy to get dry. After opening the lid and using, it is necessary to seal it in a timely manner and store it in a cool place. Please clean the painting tools before and after use in a timely manner.</p> <p>3. Drying instructions: When the film thickness is too high, the drying time will be extended.</p> <p>4. This information is developed based on laboratory environment and testing data, and is for reference only; If you have any questions, please contact our technician.</p> <p>Paint mixing, spraying, and waste disposal must comply with local laws and regulations</p> <p><b>Only for professional use.</b></p>		



[Facebook.com/Donglaicoating](https://www.facebook.com/Donglaicoating)



[intesales@onwings.com](mailto:intesales@onwings.com)