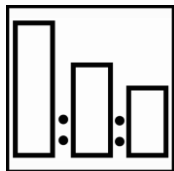


2K weather resistance clear coat A850

FOR PROFESSIONAL USE ONLY

Description

High-build, two-component clear coat designed for universal application and optimal appearance for onwings and onwaves’ coat system which secures excellent flow and gloss.



100 A850
50 Hardener
20-30 Thinner



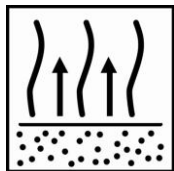
Use Donglai measuring stick



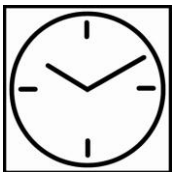
Spray gun set-up: Application pressure:
1.5-1.7 mm (suction type gun) 1.7-2.2 bar at the air inlet
1.3-1.5 mm (gravity type)



2 x 1 coat
Apply 2 single coats (40~80µm)



Between coats Before curing
3-5 minutes at 20 °C 3-5 minutes at 20 °C
Thinner selection according temperature Flash-off time depending on oven type



Air-dry time at 68°F/20°C 3 ~ 4hours
Force dry at 140°F/60°C 45 ~ 60 minutes



Use suitable respiratory protection
Donglai onwings Car Refinishes recommends the use of a fresh air supply respirator.

2K weather resistance Clear coat A850

FOR PROFESSIONAL USE ONLY

Product and additives

Product name

2K Super Clear coat A850

Hardener

A723 Slow dry Hardener; repairs at 25-35 °C
A722 Standard Hardener; repairs at 15 °C-25 °C
A721 Fast dry Hardener; repairs at 5-15 °C

Thinner

A736 Slow dry thinner; repairs at 25-35 °C
A734 Standard thinner; repairs at 15 °C-25 °C
A732 Fast dry thinner; repairs at 5-15 °C

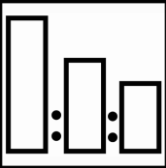
Basic raw materials

2K Super clear coat A855: Acrylic and polyester resins
Hardener: Poly-isocyanate resins

Suitable substrates

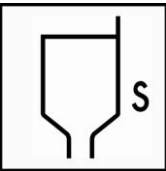
onwings or onwaves basecoat after 15 minutes flash off time at 25 °C

Mixing



100 A850
50 A722
20-30 A734
Use measuring stick

Viscosity



16 - 18 seconds – DIN Cup 4 at 20 °C

Spray gun set-up / application pressure



Spray gun Set-up	Application pressure
Gravity feed gun1.3-1.5 mm	1.7-2.2 bar at the spray gun air inlet
Suction type gun 1.5-1.7 mm	

2K weather resistance Clear coat A850

FOR PROFESSIONAL USE ONLY

Application process



Apply a full coat, allowing for a 5-8 minutes flash-off time at 20 °C.
Next, apply a full coat, allowing for a 5-8minutes flash-off time at 20 °C before baking

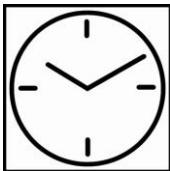
Pot-life

Slow dry Hardener3 4 hour at 20 °C
Standard Hardener 4 hours at 20 °C
Fast dry Hardener 4 hours at 20 °C

Film thickness

By using the recommended application: 40-80 μm.

Drying times



Dust free 8-10min at 20 °C, 45min at 60 °C
Dry to handle 5hrs at 20 °C, 60min at 60 °C

Polishability



Dust and minor imperfections can be polished out after the stated air-dry times have been reached, or after a full bake at 60 °C object temperature, followed by a cool down of the object to ambient temperature.
Carefully sand out dust particles and restore the surface according polishing recommendations. Ready to polish approximately 1 hour after cool down to ambient temperature.

Material usage

By using the recommended application, the theoretical material usage is ±7.2 m ³/liter RTS mixture. The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

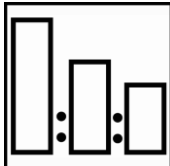


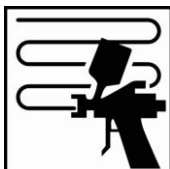
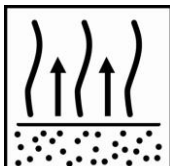


onwings solvents

Product storage

Product shelf-life is 2 years when products are stored unopened at 20 °C. Avoid extreme temperature fluctuation.

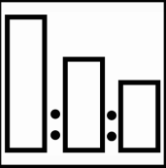
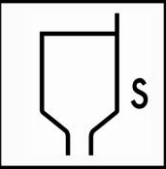


2K super weather resistance Clear coat A855

FOR PROFESSIONAL USE ONLY

Description		
High-build, two-component clear coat designed for universal application and optimal appearance for onwings and onwaves' coat system which secures excellent flow and gloss.		
	100 A855 50 Hardener 20-30 Thinner	
	Use Donglai measuring stick	
	Spray gun set-up: 1.5-1.7mm(suction type gun) 1.3-1.5mm((gravitational type)	Application pressure: 1.7-2.2 bar at the air inlet
	2 x 1 coat Apply 2 single coats (40~80µm)	
	Between coats 3-5 minutes at 20 °C	Before curing 3-5 minutes at 20 °C Thinner selection according temperature Flash-off time depending on oven type
	Air-dry time at 68°F /20°C Force dry at 140°F /60°C	3 ~ 4hours 45 ~ 60 minutes
	Use suitable respiratory protection Donglai onwings Car Refinishes recommends the use of a fresh air supply respirator.	

2K super weather resistance Clear coat A855

FOR PROFESSIONAL USE ONLY

Product and additives	
Product name	
2K Super Clear coat A855	
Hardener	
A723 Slow dry Hardener; repairs at 25-35 °C A722 Standard Hardener; repairs at 15 °C-25 °C A721 Fast dry Hardener; repairs at 5-15 °C	
Thinner	
A736 Slow dry Thinner; repairs at 25-35 °C A734 Standard Thinner; repairs at 15 °C-25 °C A732 Fast dry Thinner; repairs at 5-15 °C	
Basic raw materials	
2K Super clear coat A855: Acrylic and polyester resins Hardener: Poly-isocyanate resins	
Suitable substrates	
Onwings or onwaves basecoat after 15 minutes flash off time at 25 °C	
Mixing	
	100 A855 50 A722 20-30 A734 Use Donglai measuring stick
Viscosity	
	16 - 18 seconds – DIN Cup 4 at 20 °C
Spray gun set-up / application pressure	
	<div>Spray gun set-up</div> <div>Gravity feed gun1.3-1.5 mm</div> <div>suction type gun 1.5-1.7mm</div> <div>Application pressure</div> <div>1.7-2.2 bar at the spray gun air inlet</div>
Application process	
	Apply a full coat, allowing for a 5-8 minutes flash-off time at 20 °C. Next, apply a full coat, allowing for a 5-8minutes flash-off time at 20 °C before baking

2K super weather resistance Clear coat A855

FOR PROFESSIONAL USE ONLY

Pot-life

Slow dry Hardener3 4 hour at 20 ℃
Standard Hardener 4 hours at 20 ℃
Fast dry Hardener 4 hours at 20 ℃

Film thickness

By using the recommended application: 40-80 μm.

Drying times



Dust free 8-10min at 20 ℃, 45min at 60 ℃
Dry to handle 5hrs at 20 ℃, 60min at 60 ℃

Polishability



Dust and minor imperfections can be polished out after the stated air-dry times have been reached, or after a full bake at 60 ℃ object temperature, followed by a cool down of the object to ambient temperature. Carefully sand out dust particles and restore the surface according polishing recommendations. Ready to polish approximately 1 hour after cool down to ambient temperature.

Material usage

By using the recommended application, the theoretical material usage is ±7.2 m²/liter RTS mixture. The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

Onwings solvents

Product storage

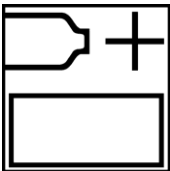
Product shelf-life is 2 years when products are stored unopened at 20 ℃. Avoid extreme temperature fluctuation.

Putty X872

FOR PROFESSIONAL USE ONLY

Description

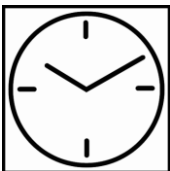
Two-pack polyester filling putty designed to fill dents and surface irregularities in body parts made of steel, zinc-coated steel, aluminum and small scratches in plastic.



100 Putty X872
2 Bodyfiller Hardener



Application time:
3-5 minutes at 70 F 20 °C
3-5 minutes at 70 F 20 °C
3-5 minutes at 70 F 20 °



15-20 minutes at 70 F 20 °C



Final sanding step for Putty P180 - P220



Final sanding step for featheredge P320 - P400



Recoatable with any onwings preparatory product



Use suitable respiratory protection
Onwings recommends the use of a fresh air supply respirator.

Putty X872

FOR PROFESSIONAL USE ONLY

Suitable substrates

Steel, Zinc-coated steel, Stainless steel, Aluminum and plastic surface

Product and additives

X872 Putty
Bodyfiller Hardener

Basic raw materials

X872 Putty: Polyester resins
Bodyfiller Hardener : peroxide

Preparation process



Remove any surface contamination prior to sanding application using appropriate surface cleaner.
Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.

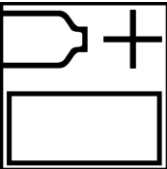


Remove existing coating and sand down to the bare substrate using P180-P220 grit as the final step.



Remove any surface contamination prior to putty / bodyfiller application using appropriate surface cleaner.

Mixing



100 putty
2 bodyfiller hardener
Mix the bodyfiller thoroughly to a homogeneous mass (uniform colour).

Application



Apply the putty to the bare substrate by placing the spreader at a 60 °angle. Avoid thick edges of putty around the perimeter of the repair by tapering away toward the original finish.

Putty X872

FOR PROFESSIONAL USE ONLY

Drying



Ready to sand after 15-20 minutes at20 ℃. If force dried, the bodyfiller can be sanded after 10 minutes at 40 ℃.



Ready to sand after 4 minutes. se IR low power setting at a 50-70 cm distance between panel and IR unit. Temperature should not exceed 90 ℃.

Sanding



P80 - P120 - P220
Use a guide coat between the sanding steps.



P220 - P320 (P400 for a spot repair).
Take care to remove any coarse sanding scratches that may have been created in the feather edge area



Remove any surface contamination prior to filler / surfacer application using appropriate surface cleaner.
Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

Cleaning of equipment

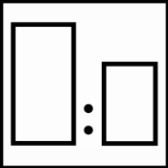



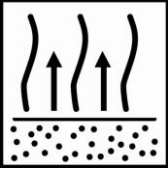


Clean the application equipment immediately after use with onwings solvent。

Product storage

Product shelf-life is 2 years when products are stored unopened at 20 ℃. Avoid extreme temperature fluctuation.

M series Basecoat toners

FOR PROFESSIONAL USE ONLY

Description	
M series solventborne basecoat provides excellent coverage, metallic arrangement and sprayability property. M series basecoat must be used in conjunction with onwings clear coat.	
	100 M series basecoat 60-80 Thinner
	Use Donglai measuring stick
	Spray gun set-up: Application pressure: 1.2-1.5 mm 1.7-2.2 bar at the air inlet
	2 ~ 3 coats Apply 2~3 single coats (15~20 μm)
	Between coats Before clear coat application 3-5 minutes at 20 °C 15-20 minutes at 20 °C Thinner selection according temperature Flash-off time depending on oven type
	Clear coat application See clear coat TDS
	Use suitable respiratory protection onwings recommends the use of a fresh air supply respirator.

M series Basecoat toners

FOR PROFESSIONAL USE ONLY

Suitable substrates

Existing OEM finishes
All other current onwings preparatory products-surfacers

Product and additives

Product name

M Series solventborne basecoat toners

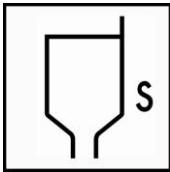
Thinners

A736 Slow dry Thinner; repairs at 25-35 °C
A734 standard Thinner; repairs at 15-25 °C
A732 Fast dry Thinner; repairs at 5-15 °C

Basic raw materials

M Series Basecoat toners: Acrylic resins
Thinner: Physical drying solvents

Viscosity



16 - 18 seconds – DIN Cup 4 at 20 °C

Spray gun set-up / application pressure



Spray gun set-up	Application pressure
1.2-1.5 mm	1.7-2.2 bar at the air inlet



Surface cleaning, remove any surface contamination prior to the application

Mixing



Mixing Machine
Stir M series Toners on mixing machine every 12 hours for 15 minutes



M series Basecoat toners

FOR PROFESSIONAL USE ONLY

Stir before use



Stir product thoroughly before mixing.

Pot-life

6 months at 20 °C

Film thickness

By using the recommended application: 15 - 20 µm.

Cleaning of equipment

onwings Solvents

Product storage

Product shelf-life is 2 years when products are stored unopened at 20 °C. Avoid extreme temperature fluctuation.



A828 solventborne degreaser

FOR PROFESSIONAL USE ONLY

Description

A828 is a solvent based surface cleaner to remove contamination from bare metal, preparatory product prior to any preparation step or paint application.

Before using degreaser

To wash the car or surface of the body panel under treatment and remove all the water-soluble contaminants.

Cleaning skill

Wet a clean cloth with degreaser and clean the surface and then wipe the surface thoroughly dry with high quality absorbent cloths. Always use two cloths, as one cloth will merely shift rather remove dirt and grease. Do not allow the degreaser to evaporate on the surface. Wipe the surface thoroughly dry before the degreaser evaporates.

Attention of degreaser

The degreased surface must not be touched with bare hand avoiding moisture, salts and oils pollute the surface again which may cause blistering problem. If degreased surface had been touch by bared hands, degrease it again.



Use suitable respiratory protection onwings recommends the use of a fresh air supply respirator.

Product storage

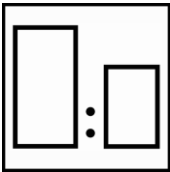
Product shelf-life is 2 years when products are stored unopened at 20 ℃. Avoid extreme temperature fluctuation.

Super Surfacer A8831

FOR PROFESSIONAL USE ONLY

Description

Super Surfacer A8831 is a super performance, acrylic urathane primer delivering excellent build and fast dry with superior sanding property. Surfacer A8831 is approved for onwings or onwaves repair systems.



3 A8831 (surfacer)
1 A722 (Hardener)
1 A734 (Thinner)



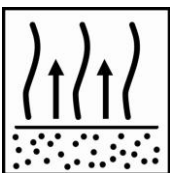
Use onwings measuring stick



Spray gun set-up:	Application pressure:
1.7-2.0mm(suction type gun)	1.7-2.2 bar at the air inlet
1.5-1.7mm((gravitational type)	

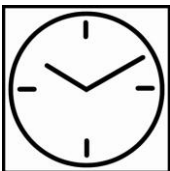


2 ~ 3 coats
Apply 2~3 single coats (40~60µm) allowing for 5-8minutes flash-off



Between coats	Before curing
5-10 minutes at 20 °C	5-10 minutes at 20 °C

Thinner selection according temperature Flash-off time depending on oven type



Air-dry time at 68°F /20°C	1 ~ 2 hours
Force dry at 140°F /60°C	20 ~ 30 minutes



Recoatable with all onwings and onwaves Topcoat



Use suitable respiratory protection
Onwings recommends the use of a fresh air supply respirator.



Super Surfacer A8831

FOR PROFESSIONAL USE ONLY

Suitable substrates

Existing finishes, steel, OEM electro coat, onwings wash primer

Product and additives

Product name

Hardener

A723 Slow dry Hardener; repairs at 25-35 °C
A722 Standard Hardener; repairs at 15 °C-25 °C
A721 Fast dry Hardener; repairs at 5-15 °C

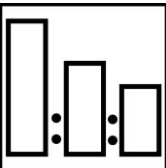
Thinner	Super Surfacer A8831	
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A736 Slow dry Thinner; repairs at 25-35 °C
A734 standard Thinner; repairs at 15-25 °C
A732 Fast dry Thinner; repairs at 5-15 °C

Basic raw materials

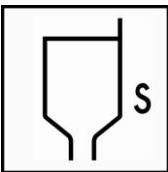
Super Surfacer A8831: Acrylic and polyester resins
Hardener: Poly-isocyanate resins

Mixing



3 A8831
1 A722
1 A734

Viscosity



16 - 18 seconds – DIN Cup 4 at 20 °C

Spray gun set-up / application pressure



Spray gun set-up	Application pressure
Gravity feed gun1.5-1.7 mm	1.7-2.2 bar at the spray gun air inlet
Suction type gun 1.7-2.0 mm	



Super Surfacer A8831

FOR PROFESSIONAL USE ONLY



Surface cleaning, remove any surface contamination prior to the application

Stir before use



Stir product thoroughly before using.

Pot-life

Slow dry Hardener 2 hour at 20 °C
Standard Hardener 2hours at 20 °C
Fast dry Hardener 2 hours at 20 °C

Film thickness

By using the recommended application: 60 - 90 μm.

By using the recommended application, the theoretical material usage is ±5.0 m³/liter RTS mixture. The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Product storage

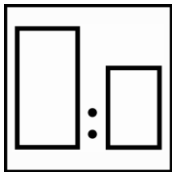
Product shelf-life is 2 years when products are stored unopened at 20 °C. Avoid extreme temperature fluctuation.

Surfacer A8833

FOR PROFESSIONAL USE ONLY

Description

Surfacer A8833 is a high performance, acrylic urathane primer delivering excellent build and fast dry with superior sanding property. Surfacer A8833 is approved for onwings or onwaves repair systems.



3 A8833 (Surfacer)
1 A722 (Hardener)
1 A734 (Thinner)



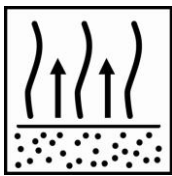
Use onwings measuring stick



Spray gun set-up:	Application pressure:
1.7-2.0 mm(suction type gun)	1.7-2.2 bar at the air inlet
1.5-1.7 mm((gravitational type)	



2 ~ 3 coats
Apply 2~3 single coats (40~60 µm) allowing for 5-8minutes flash-off



Between coats	Before curing
5-10 minutes at 20 °C	5-10 minutes at 20 °C
Thinner selection according temperature Flash-off time depending on oven type	



Air-dry time at 68°F /20°C	1 ~ 2 hours
Force dry at 140°F /60°C	20 ~ 30 minutes



Recoatable with all onwings and onwaves Topcoat



Use suitable respiratory protection
Onwings recommends the use of a fresh air supply respirator.

Surfacer A8833

FOR PROFESSIONAL USE ONLY

Suitable substrates

Existing finishes, steel, OEM electro coat, onwings wash primer

Product and additives

Product name

Hardener

A723 Slow dry Hardener; repairs at 25-35 °C
A722 Standard Hardener; repairs at 15 °C-25 °C
A734 Fast dry Hardener; repairs at 5-15 °C
Surfacer A8833

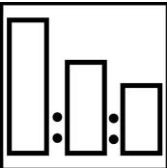
Thinner

A736 Slow dry Thinner; repairs at 25-35 °C
A734 standard Thinner; repairs at 15-25 °C
A732 Fast dry Thinner; repairs at 5-15 °C

Basic raw materials

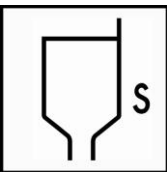
Surfacer A8833: Acrylic and polyester resins
Hardener: Poly-isocyanate resins

Mixing



3 A8833
1 A722
1 A734

Viscosity



16 - 18 seconds – DIN Cup 4 at 20 °C

Spray gun set-up / application pressure



Spray gun set-up	Application pressure
Gravity feed gun1.5-1.7 mm	1.7-2.2 bar at the spray gun air inlet
suction type gun 1.7-2.0 mm	



Surfacer A8833

FOR PROFESSIONAL USE ONLY



Surface cleaning, remove any surface contamination prior to the application

Stir before use



Stir product thoroughly before using.

Pot-life

Slow dry Hardener 2 hour at 20 °C
Standard Hardener 2hours at 20 °C
Fast dry Hardener 2 hours at 20 °C

Film thickness

By using the recommended application: 60 - 90 µm.

Material usage

By using the recommended application, the theoretical material usage is ±5.0 m²/liter RTS mixture. The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

onwings solvents

Product storage

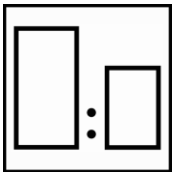
Product shelf-life is 2 years when products are stored unopened at 20 °C. Avoid extreme temperature fluctuation.

Wash Primer A320

FOR PROFESSIONAL USE ONLY

Description

Wash Primer A320 is a chromate-free, two component product for car refinishing. The special composition of its pigment and binding agent enable it to offer top quality corrosion protection and excellent adhesion.



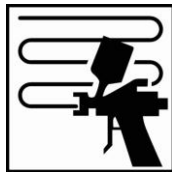
3 A320 (Wash primer)
1 A001 (Activator)



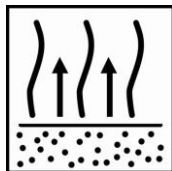
Use Donglai measuring stick



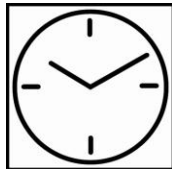
Spray gun set-up:	Application pressure:
1.7-2.0mm(suction type gun)	1.7-2.2 bar at the spray gun air inlet
1.5-1.7mm((gravitational type)	



2 ~ 3 coats
Apply 2~3 single coats (10~15 µm)



Between coats	Before surfacer application
20-30seconds at 20 °C	5-10 minutes at 20 °C



Air-dry time at 68°F /20°C 30~ 60 minutes



Recoatable with all onwings surfacers



Use suitable respiratory protection
Onwings recommends the use of a fresh air supply respirator.

Wash primer A320

FOR PROFESSIONAL USE ONLY

Suitable substrates

Steel, Zinc-coated steel, Stainless steel and Aluminum

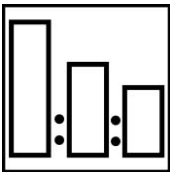
Product and additives

Wash primer A320
A001 Hardener

Basic raw materials

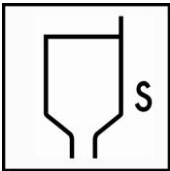
2K Wash primer A320: polyvinyl butyral resins
Activator: phosphoric acid

Mixing



3 A320
1 A001
Use measuring stick

Viscosity



16 - 18 seconds – DIN Cup 4 at 20 °C



Spray gun set-up	Application pressure
Gravity feed gun1.5-1.7 mm	1.7-2.2 bar at the spray gun air inlet
suction type gun 1.7-2.0mm	



Surface cleaning, remove any surface contamination prior to the application



Wash primer A320

FOR PROFESSIONAL USE ONLY

Stir before use



Stir product thoroughly before use

Pot-life

2 hour at 20 °C

Film thickness

By using the recommended application: 10 - 15 µm.

Material usage

By using the recommended application, the theoretical material usage is ±5.0 m²/liter RTS mixture. The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

onwings solvents

Product storage

Product shelf-life is 2 years when products are stored unopened at 20 °C. Avoid extreme temperature fluctuation.