

Autoclear UV Blending

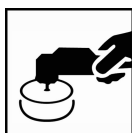
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Description

The term spot repair and blending is understood to include all repairs to damaged areas resulting in an invisible repair or blend into the still intact existing OEM finish. As a result, the car refinisher is not compelled to spray complete panels in the instance of minor damage. The application method and technique described below is appropriate for spots and blends with Sikkens Autoclear UV.

Spot and blend area preparation

1. Thoroughly abrade the surface, removing the existing OEM surface texture. Sand the surface to be coated by using i.e.; 3M 260L sandingpaper P1000 to P1500 preferably in combination with an 3 or 5 mm Soft Interface pad.
2. Thoroughly abrade the surface to be coated by using Sikkens Blend Prep in combination with water. Use a 3M SUFN (Grey) abrasive pad, or in the case of light metallic colours a 3M AXFN (Copper) abrasive pad. Rinse sufficiently with clean water after use.

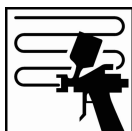


Final blending area preparation; thoroughly polish the blending area with a abrasive polishing compound. Use 3M Fast Cut Plus Compound or comparable, preferably in combination with a polishing machine. *Thoroughly remove all compound residues from the panel.*

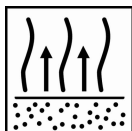


Surface cleaning: remove any surface contamination prior to the application of Autoclear UV using an appropriate surface cleaner. *Pay in particular attention to the blend area, ensure it is thoroughly cleaned and wiped dry with high performance surface cleaning cloths.*

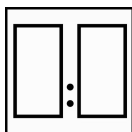
Blending application



Apply the topcoat or clearcoat according TDS recommendation
Extend the 2nd coat beyond the 1st coat



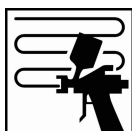
Indicated flash-off time according TDS at 20°C



100 Autoclear UV
 100 Autoclear UV SRA Thinner

Mix the ready to spray topcoat mixture thoroughly with 100 parts Autoclear UV SRA Thinner.

*Extra thinned material creates a lower spray viscosity.
 Apply the following blending steps using a reduced application pressure.*

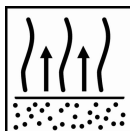


Apply one full flowing coat of the Autoclear UV SRA mixture over the blend area falling just short of the polished area. Fade this mixture in the direction of the previously applied clearcoat layer to reduce overspray on the blend area.

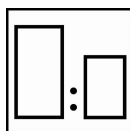
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Blending application (continued)

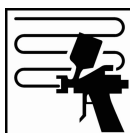


Approximately 15-30 seconds at 20°C



20 Autoclear UV SRA mixture (100:100)
 80 Autoclear UV SRA Thinner

Mixture for optimum clearcoat blending: Keep a little amount of the previous RTS blending mixture in the spray gun and add more Autoclear UV SRA Thinner. Shake thoroughly before use.



1-3 coats.

Apply the final blending coats by fading back into the previously applied clearcoat to reduce overspray and then extending forward into the polished area.

Do not dry the fade-out with air; SRA Thinner requires time to dissolve sufficiently into the existing finish. Allow for approximately 15-30 seconds flash off time between the applied SRA Thinner layers.

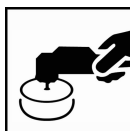
UV curing



Cure the Autoclear UV according TDS recommendations.

- Expose the Autoclear UV blend area for a longer period with UV light for optimum curing.
- The blend area is quicker to polish when longer exposed to UV.
- When possible place the UV lamp on a stand for 2-4 minutes.

Polishing of the blended area



Polish the blended area by hand with a fine polishing compound.

If more effort is required, polish by machine at low rotation speed with minimum surface pressure.

- Start polishing by using a fine polishing compound and soft compounding pad.

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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