

# Autobase Plus Three Stage System

FOR PROFESSIONAL USE ONLY

## Definition and description

An Autobase Plus three stage systems consists of three separate applied layers creating a special color effect, based on;

1<sup>st</sup> step: Application of the solid or metallic Autobase Plus foundation color.

- *This foundation coat can also be an prescribed Colorbuild primer*

2<sup>nd</sup> step: Application of the Autobase Plus translucent, solid or pearl effect color (*Final/Mid coat*).

3<sup>rd</sup> step: Application of the clearcoat to provide gloss and protection.

The term spot repair is understood to include all repairs to damaged areas resulting in the repaired area blending invisibly into the still intact existing finish. As a result, the car refinisher is not compelled to spray large panels in the case of minor damage. The spot repair technique also enables minor differences in color and effect between the original car finish and the repair to be made invisible.

## Color check by spray out samples

Correct color match needs to be determined by producing a number of color spray-out samples, the color changes dependent on the number of coats applied of the effect color. Proceed as follow:

- Apply the foundation color until opacity is achieved on 5 different spray-out panels.
- Next apply one single coat of the effect color to all panels.
- Allow sufficient flash-off time and **remove one** panel before continuing this application process, resulting in spray-outs panels ranging with 1-5 coats of the effect coat.
- Allow for a 10-15 minutes flash-off time at 75°F (25°C) prior to clearcoat application.
- *For optimum flash-off, dry the panels for several minutes in a oven or during a drying cycle in the spraybooth.*
- *Apply two single layers of clearcoat to all color spray-out panels, securing brightness and color depth.*

The operator can determine the right color match by using these color samples.

- *Number each panel, indicating the number of effect coats on the panel.*
- *Personal application differences makes it recommendable that each painter creates its own spray-outs.*
- *To obtain an accurate color match, spray the panels as if applying to a vehicle, i.e. place all spray-outs on one larger panel and spray complete panel for each coat. DO NOT SPRAY EACH PANEL SEPARATELY.*

## Prior to painting

### Preparation:

Although the aim is to keep a repair as small as possible, it is almost inevitable with any three stage pearl application to use an additional panel, required for color blend. This is caused mainly due to the multiple layers to apply, ensuring OEM color match

*Prior to preparation the decision has to be made on the number of panels (area required) to prepare.*

### Application foundation coat:

Decide the maximum distance for the foundation coat (consider sufficient additional space for blending the effect color) and apply until achieving full coverage. The third and optional fourth coat will be applied according the described methods, dependent on the type of foundation coat; Colorbuild, solid Autobase Plus color or metallic Autobase Plus color.

*Apply the color blend of the foundation coat in such a way that a smooth transition is created from foundation color to the OEM color before proceeding with the application of the effect color.*

### Application effect color:

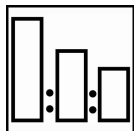
Decide the maximum distance for the effect color to be applied. Use the available area and do not keep the color blend unnecessary small. Then step back each subsequent coat until color is achieved.

When more coats are required for color match then indicated, then alternate the application with each layer of the effect color, thereby not overlapping in the same area..

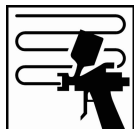
# Autobase Plus Three Stage System

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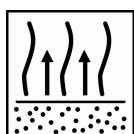
**Colorbuild foundation color**



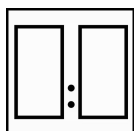
- 100 Colorbuild Plus foundation color
- 50 Colorbuild Plus Hardener
- 50 Colorbuild Plus Reducer Non Sanding



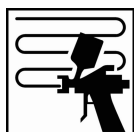
Apply 1 single coat to the primer area or until opacity is achieved.  
*In case a 2<sup>nd</sup> coat is needed, extend this coat beyond the first applied coat.*



Allow each coat to flash-off naturally until the surface is completely matt.  
*Do not force-dry by air support.*

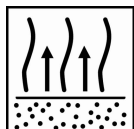


Blending of the foundation color:  
 Mix the RTS Colorbuild color 1:1 with SRA Thinner.



Apply one thin coat, gradually fading out this transparent solid foundation color, extending beyond the repair area facilitating a smoother and more transparent color transition from the repair area to the OEM color.

*In case of insufficient transparency add 100 parts SRA Thinner into the Colorbuild RTS mixture, gradually fading out once more extending beyond the previous applied coat.*



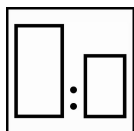
Allow each coat to flash off naturally until the surface is completely matt, do not force-dry by air support.



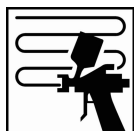
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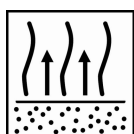
**Autobase Plus solid foundation color**



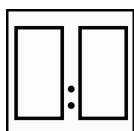
100 Autobase Plus foundation color  
 50 Plus Reducer



Apply 2 single coats to the primer area or until opacity is reached.  
 Extend the second coat over the edge of the previous coat.

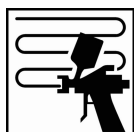


Allow for a minimum flash-off time of 15 minutes at 70°F (20°C).



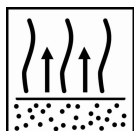
Blending foundation color (two options):

- Mix the RTS Autobase Plus solid foundation color 100:100 with Plus Reducer
- Mix the RTS Autobase Plus solid foundation color 100:100 with the RTS pearl or solid effect color.



Apply one thin coat, gradually fading out this coat, facilitating a more uniform blend of the foundation color, and a smoother transition from the repair area to the OEM color

*In case of insufficient transparency add once more 100 parts RTS pearl or solid effect color into the Autobase Plus solid foundation RTS mixture, gradually fading out once more extending beyond the previous applied coat.*



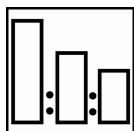
Allow for a minimum flash-off time of 15 minutes at 70°F (20°C).



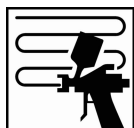
# Autobase Plus Three Stage System

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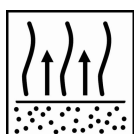
## Autobase Plus metallic foundation color



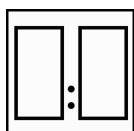
100 Autobase Plus metallic color  
 50-80 Plus Reducer



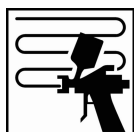
Apply 1 full coat.  
 Next apply an intermediate coat.  
*\*Only when needed, apply a drop coat (metallic orientation coat) by reducing the pressure to 14-22 psi (1-1 ½ bar) at the gun inlet and increase the distance while applying the drop coat with full trigger.*



Allow for a minimum flash-off time of 15 minutes at 70°F (20°C).

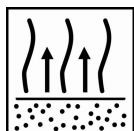


Blending foundation color:  
 Mix the RTS Autobase Plus metallic foundation color 100:100 with the RTS pearl or solid effect color.



Apply one thin coat, gradually fading out this coat, facilitating a more uniform blend of the foundation color, and a smoother transition from the repair area to the OEM color.

*In case of insufficient transparency add once more 100 parts RTS pearl or solid effect color into the Autobase Plus metallic foundation RTS mixture, gradually fading out once more extending beyond the previous applied coat.*

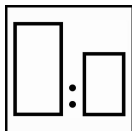


Allow for a minimum flash-off time of 15 minutes at 70°F (20°C).

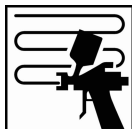
# Autobase Plus Three Stage System

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**Autobase Plus pearl or solid effect color**

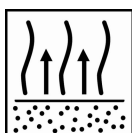


100 Autobase Plus pearl or solid effect color  
 50 Plus Reducer

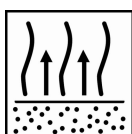


Apply the first coat of the effect color as far as possible from the repair area, within the maximum panel area. Next apply the pre-determined sequential numbers of coats, keeping each layer within the previous applied coat. Start by applying a thin coat, as if fading in, then building up the layer thickness as one comes closer to the repair area. Repeat this with each applied coat of the effect color.

- Apply the number of required coats, dependent on the spray-out sample selection.
- Do not lower the air pressure during application when applying the pearl or solid effect color.
- Alternate the application with each layer of the effect color, do not overlap in the same area.
- Application of the effect color must be executed similar as on the spray-out samples, ensuring similar layer thickness and color effect.
- Apply the indicated number of layers of the effect color until an even color appearance is achieved.



Allow for a minimum flash-off time of 15 minutes at 70°F (20°C) between coats.



Allow for a minimum of 20-30 minutes final flash-off time at 70°F (20°C).

- *Option 1; Allow for a minimum of 10-15 minutes final flash-off time at 100°F (40°C).*
- *Option 2; allow for a flash-off time of approximately 5-10 minutes at 140°F (60°C).*
- *When heat is used for drying, allow object to cool down to application temperature before clearcoat application.*

**Akzo Nobel Car Refinish bv.**  
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