

Autobase Plus Tri-Stage Candy Colors

FOR PROFESSIONAL USE ONLY

Definition and description

Repair system for the following Tri-stage colors based on Q075 Midcoat Color Enhancer LV:

- FA12:RR
- FA16:R3
- MAZ46V
- LEX3T5
- HON9880
- HON9881
- HON9885
- GMA15:G1E
- GMA17:GPJ

creating a special color effect, based on the following layers:

- Autobase Plus MM Basecoat Groundcoat color
- Autobase Plus Q075 Midcoat Color Enhancer LV
- Clearcoat

NOTE: TDS does not apply for colors which are formulated based on Q065.

Color check by spray out samples

Groundcoat:

Apply ground coat till completely covered and apply mist coat for optimal orientation. All coats should be completely dry before next coat is applied.

Groundcoat is applied as standard Autobase Plus.

Midcoat:

Correct color match needs to be determined by producing a number of color spray-out samples.

The color depends on the number of coats applied of the midcoat.

Distribute spray out panels according to the following matrix and

1. Apply the foundation color in 2, 3, 4 and 5 layers, from top to bottom.
2. Apply 2, 3, 4 and 5 layers of the effect color to the panels, from left to right.

		Midcoat			
		2 coats	3 coats	4 coats	5 coats
Groundcoat	2 coats				
	3 coats				
	4 coats				
	5 coats				

3. Allow for a 10-15 minutes flash-off time at 20°C prior to clearcoat application.
4. Apply two single layers of clearcoat.

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

- Number each panel, indicating the number of foundation and effect coats on the panel.

DO NOT SPRAY EACH PANEL SEPARATELY.



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Suitable substrates

All Existing OEM finishes.
 All current Sikkens preparatory products with the exception of Washprimers.

Surface preparation

Primer (Sanding) area



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02

Basecoat blend area



Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P600 - P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



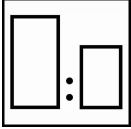
Surface cleaning: remove contamination using an appropriate surface cleaner.



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Groundcoat application



100 parts by volume of Groundcoat
 50 parts by volume of Plus Reducer



Use Sikkens measuring stick

3 Purple



Spray gun set-up:
 1.3 –1.5 mm

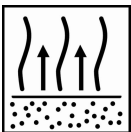
Application pressure:

1.8 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



Apply groundcoat until completely covered, flash-off between each coat and apply a drop coat.



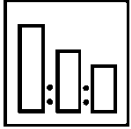
Flash off by increasing airflow until completely dry between each coat.
 Drop coat has to be flashed until completely dry before midcoat application.



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Midcoat application



100 parts by volume of Q075 Midcoat Color Enhancer LV + ABP toner (90:10 (w/w))
 25 parts by volume of Hardener P15 / P25 / P35
 35 parts by volume of Plus Reducer Extra Fast / Fast



Use Sikkens measuring stick

5 Orange



Spray gun set-up:
 1.3 –1.5 mm

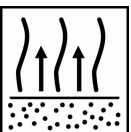
Application pressure:

1.8 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



Apply the number of midcoat layers until desired color is achieved, flash-off between coats for 3-5 minutes.



Allow Midcoat Color Enhancer LV to flash for 20-30 minutes at 20°C before Clearcoat application.

Clearcoat



See Clearcoat T.D.S.



Use suitable respiratory protection

Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

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Notes



- Ensure that each coat is thoroughly flashed-off.
- Application of a Tri-Stage Candy color is the same as a Three Stage Pearl effect color. For further information please refer to Technical Bulletin Autobase Plus Three Stage Pearl application process.

Akzo Nobel Car Refinish bv...

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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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