

# FRD 9732 Electric Orange

FOR PROFESSIONAL USE ONLY

## Definition and description

The repair system for FRD 9732 Electric Orange consists of three applied layers creating a special colour effect, based on;

1<sup>st</sup> step: Application of the Colorbuild Plus foundation colour.  
2<sup>nd</sup> step: Application of the Autowave transparent effect colour.  
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 colour and effect between the original car finish and the repair to be made invisible.

## Colour check by spray out samples

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

- Apply the foundation colour until opacity is achieved on a number of different spray-out panels (6 panels).
- Next apply one single coat of the effect colour to all panels.
- Allow sufficient flash-off time and **remove one** panel before continuing this application process, resulting in spray-outs panels ranging with 1-6 coats of the effect coat.
- Allow for a 10-15 minutes flash-off time at 25°C prior to clearcoat application.
- *For optimum flash-off, dry the panels for several minutes in an oven or during a drying cycle in the spraybooth.*
- *Apply two single layers of clearcoat to all colour spray-out panels, securing brightness and colour depth.*

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

- *Number each panel, indicating the number of effect coats on the panel.*
- *Personal application differences make it recommendable that each painter creates its own spray-outs.*
- *To obtain an accurate colour 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 colour blend. This is caused mainly due to the multiple layers to apply, ensuring OEM colour 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 colour) and apply until achieving full coverage. The third and optional fourth coat will be applied according to the described method.

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

### Application effect colour:

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

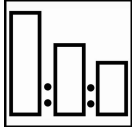
Apply the indicated number of layers of the effect colour until an even colour appearance is achieved.

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

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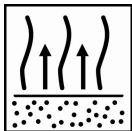
**Colorbuild Plus plus foundation colour**



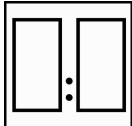
- 100 Colorbuild Plus foundation color
- 50 Colorbuild Plus Hardener
- 30 Colorbuild Plus Reducer Non Sanding / Plus Reducers



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.*

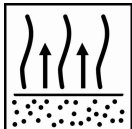


Blending of the foundation colour:  
 Mix the RTS Colorbuild Plus colour 1:1 with Colorbuild Plus Reducer Non Sanding (Plus Reducers or SRA Thinner).



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

*In case of insufficient transparency add again 100 parts Colorbuild Plus Reducer Non Sanding (Plus Reducers or SRA Thinner) into the Colorbuild Plus RTS mixture, gradually fading out once more extending beyond the previous applied coat.*

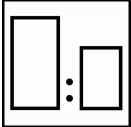


Allow each coat to flash-off naturally until the surface is completely matt, do not force-dry by air support.

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**Autowave pearl or solid effect colour**



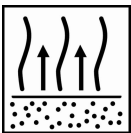
100 Autowave pearl or solid effect colour

10-20 Activator WB

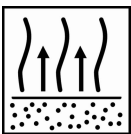


Apply the first coat of the effect colour as far as possible from the repair area, within the maximum panel area. Next apply the pre-determined sequential numbers of coats, keeping each layer within the previous applied coat. Start by applying a thin coat, as if fading in, and then building up the layer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

- Apply 3-6 coats, dependent on the spray-out sample selection.
- Do not lower the air pressure during application when applying the pearl or solid effect colour.
- Alternate the application with each layer of the effect colour; do not overlap in the same area.
- Application of the effect colour must be executed similar as on the spray-out samples, ensuring similar layer thickness and colour effect.
- Apply the indicated number of layers of the effect colour until an even colour appearance is achieved.



Flash-off between coats by increasing airflow and or heat until the basecoat dries completely to a matt finish. *If necessary allow the surface to cool.*



Allow for a minimum of 20-30 minutes final flash-off time at 25°C.

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

*Humidity and airflow will influence the Autowave flash-off and drying times. These times can be reduced to a minimum by using air accelerator systems thus increasing the airflow over the object.*

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