

Autobase Plus Lexus 3T5 Radiant Red

FOR PROFESSIONAL USE ONLY

Definition and description

The repair system for Lexus 3T5 Radiant Red consists of different layers creating a special color effect, based on

- Basecoat Foundation color
- Basecoat Effect color
- Clearcoat

Color check by spray out samples

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 both foundation and effect color.

Distribute spray out panels according to the following matrix and

1. Apply the foundation color in 2, 3, 4 layers, from top to bottom.
2. Mix the effect color according to the formula in Mixit (Mix A)
3. Apply 2, 3, 4 and 5 layers of the Mix A to the panels, from left to right.

		Mix A			
		2 coats	3 coats	4 coats	5 coats
Foundation color	2 coats				
	3 coats				
	4 coats				

4. Allow for a 10-15 minutes flash-off time at 20°C prior to clearcoat application.
5. 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.

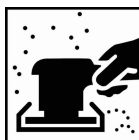
DO NOT SPRAY EACH PANEL SEPARATELY.

Preparation

Repair with recommended bodyfillers and / or undercoats.

Surface preparation

Filler 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 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.

Autobase Plus Lexus 3T5 Radiant Red

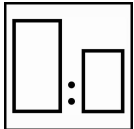
FOR PROFESSIONAL USE ONLY

Repair process



(Fade out of foundation coat)

Apply Autobase Plus Blending Agent to the panel until the area designated for fade out.
 Allow to dry.

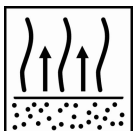


Step 1

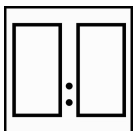
100 parts by volume foundation coat
 50 parts by volume Plus Reducer



Apply foundation color as determined with the color check spray out panels

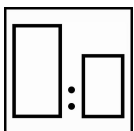


Allow each coat to flash-off naturally until the surface is completely matt.
Do not force-dry by air support.



Step 2

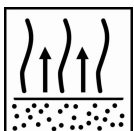
Mix foundation color and effect color (1:1)(Mix B).



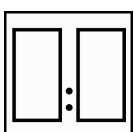
100 parts by volume Mix B
 50 parts by volume Plus Reducer



Mix B applied until achieved opacity



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



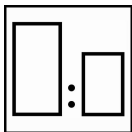
Step 3

Mix Mix B and effect color (1:1) (Mix C).

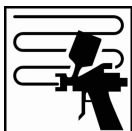


Autobase Plus Lexus 3T5 Radiant Red

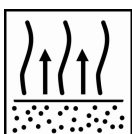
FOR PROFESSIONAL USE ONLY



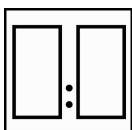
100 parts by volume Mix C
 50 parts by volume Plus Reducer



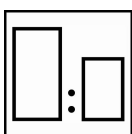
Apply 1 coat or 2 coats over the edge of Mix B.



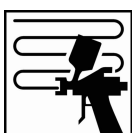
Allow each coat to flash-off naturally until the surface is completely matt.
Do not force-dry by air support.



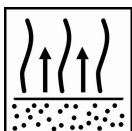
Step 4
 Mix Mix C and effect color (1:1) (Mix D).



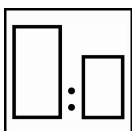
100 parts by volume Mix D
 50 parts by volume Plus Reducer



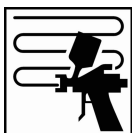
Apply 1 coat or 2 coats over the edge of Mix C.



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



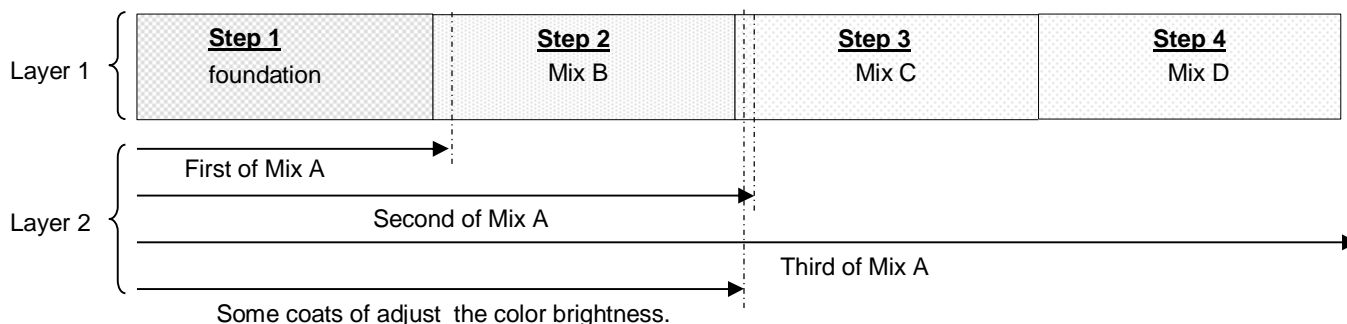
100 parts by volume Mix A
 50 parts by volume Plus Reducer



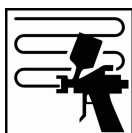
Apply first the Mix A to the foundation color area.
 Apply second the Mix A to the Mix B area.
 Apply third the Mix A to the Mix D area. (Inside-out)
 If needed, apply final coat on Mix B area to adjust the color brightness.

Autobase Plus Lexus 3T5 Radiant Red

FOR PROFESSIONAL USE ONLY



Clearcoat



Apply Autoclear Plus HS according to TDS 5.2.64.

Akzo Nobel
Car
Refinish
 bv..

Address: Rijksweg 31, PO Box 3, 2170 BA Sassenheim.
 Tel: +31(0)71308-6944

FOR PROFESSIONAL USE ONLY

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.

Brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

Head Office

Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com

