

Autowave 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 formulation 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 25°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

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

Basecoat area



Final sanding step P1000

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

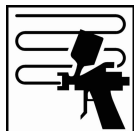


Surface cleaning: remove contamination using an appropriate surface cleaner.

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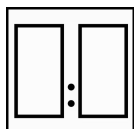
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Repair process

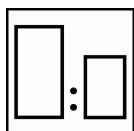


Apply Autowave MM666 / MM600 (60:40) to the door panel until the area designated for fade out. Allow to dry.

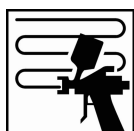
Apply foundation color as determined with the color check spray out panels



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

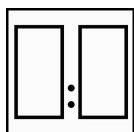


100 parts by volume Mix B
 20 parts by volume Activator WB

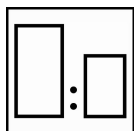


Mix B applied until achieved opacity

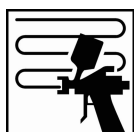
Note: Make sure to keep the succeeding coats within the first coat (outside-in).



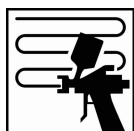
Mix Mix B and Mix A (1:1) (Mix C).



100 parts by volume Mix C
 20 parts by volume Activator WB

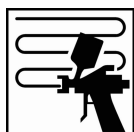


Apply 1 coat over the edge of Mix B.



Apply the Mix A to the repair area, starting at the 'mix C area' into the repair area. Apply the second Mix A, only starting 10 cm more to the left. If needed, apply third coat and fourth coat on Mix B area to adjust the color brightness.

Clearcoat



Apply Autoclear LV Superior according to TDS S1.05.01.

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