

Autobase Plus MAZDA 46G Machine Grey

FOR PROFESSIONAL USE ONLY

Definition and description



Machine Grey 46G is one of Mazda's state of the art finishes to compliment Kodo design using its Takuminuri paint technology. The repair of this color is based on the standard 2 stage TDS application with extra focus on preparation of the substrate.

The description of this color by Mazda is:

"This color gives the impression that the vehicle's body has been sculpted from a solid steel ingot"

The following steps are mandatory to meet the appearance of the original car color:

Preparation of the substrate before Basecoat color application

The preparation of this particular color with it's fine metallic is of utmost importance. To avoid disoriented fine metallic, sanding the blending areas with fine grit P1500 or P2000 is mandatory.

Application over sanded (Dark Grey / black) filler:

Remove any texture by sanding the filler with P500 followed by P1000 as a minimum, degrease and proceed with the application of the 46G color.

Preparation of the blending area on the original clearcoat:

Remove any texture by sanding the original clearcoat with P1500 grit as a minimum. Apply a single flowing coat of Q070 toner as a pre-coat and leave to flash off completely.

Surface preparation

Filler area



Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit (P500 – P800)
- Remove (orange peel) structure of the filler

Preparation blending area for application of Autobase plus tone Q070 (mandatory)



Final sanding step P1500

- Initial sanding steps may be executed with a coarser sanding grit (P1000-P1200)
- Remove (orange peel) texture of the OEM clearcoat

Surface cleaning

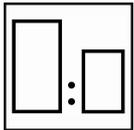


Remove any surface contamination using an appropriate surface cleaner.

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Autobase Plus Pre coat / wet bed, mixing and application

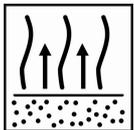


100 Autobase Plus toner Q070

50 Autobase Plus Reducer



Apply one flowing coat of Autobase Plus toner Q070 to the entire area under repair.



Flash-off by until completely dry.

Autobase Plus MAZ46G mixing and application



100 Autobase Plus MAZ 46G

5 P Hardener

+

50 Autobase Plus Reducer



Use Sikkens measuring stick

1 Black



Spray gun set-up:
 1.3-1.4 mm

Application pressure:

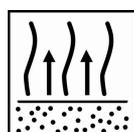
1.7 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



Application metallic color:

2 x 1 coat followed by a mist-coat



Between coats:

Until completely matt and dry

Prior to clearcoat application:

Until completely matt and dry

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Clearcoat application
 See clearcoat T.D.S.
 With the application of the clearcoat, apply a thin closed 1st layer



Use suitable respiratory protection
 Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Useful tips:

Preparation:

The recommended preparation of the substrate with this 46G color is mandatory. The substrate has to be flat and smooth, any structure and/or too coarse scratches in the OEM clearcoat will be visible after clearcoat application, especially with blending on the OEM finish.

Therefore: to avoid disorientation of the fine metallic, the use of a fine sanding grit as described is of utmost importance for the preparation of the substrate.

Preparation filler substrate: abrade with a minimum grit of P1000 and ensure to remove all texture.

It is mandatory to apply a wet bed (pre-coat) over the prepared blending area of the OEM clearcoat, abrade blending area with P1500 minimum and ensure that all texture of the OEM clear-coat is removed, after removing dust and degreasing the substrate, apply one smooth closed flowing layer Autobase Plus toner Q070 as described.

Application in general:

- Mix Autobase Plus 46G with 5% of hardener and stir before adding reducer.
- After application of every single basecoat layer completely flash off the basecoat before prior to the next layer
- Apply the effect layers in cross coat application on larger areas
- Apply the first clearcoat layer not too heavy and allow to flash off as stated in TDS clearcoat used.

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