

# Autowave 2.0 FA12:RR Ruby Red

FOR PROFESSIONAL USE ONLY

## Definition and description

Repair system for Ford FA12:RR Ruby Red consists of different layers creating a special color effect, based on the following layers:

- Colorbuild Plus 013 Grey
- Basecoat Ground coat color
- Basecoat Mid coat 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 the mid coat. Distribute spray out panels according to the following matrix and apply ground coat in 2-3 coats till completely covered and apply mist coat directly into wet final coat from bottom to top. With the exception of the mist coat all coats should be completely dry before next coat is applied. Apply mid coat in 2, 3 and 4 closed coats from left to right. All applied coats of the mid coat should be completely dry before next coat is applied.



Allow for a 15-20 minutes flash-off time at 25°C prior to clearcoat application and apply clearcoat according T.D.S.

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 Colorbuild Plus 013.

## Surface preparation



### Colorbuild Plus CBP013 (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

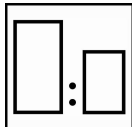


Surface cleaning: remove contamination using an appropriate surface cleaner.

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## Ground coat application



100 parts by volume of Autowave 2.0 FA12:RR ground coat  
 10-20 parts by volume Activator WB



Use Sikkens measuring stick

**14** Blue

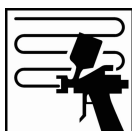


Spray gun set-up:  
 1.3-1.4 mm

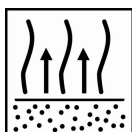
Application pressure:

1.8 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



Apply 2-3 coats of the ground coat until completely covered, flash-off between each coat. A mist coat is applied directly into the wet final coat.

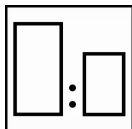


Flash off by increasing airflow until completely dry between each coat with the exception of the mist coat. Mist coat is applied directly into the wet final coat. Final coat and mist coat has to be flashed until completely dry before mid coat application.

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## Mid coat application



100 parts by volume of FA12:RR mid coat  
 20-30 parts by volume Activator WB

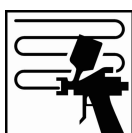


Use Sikkens measuring stick  
 14 Blue

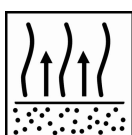


Spray gun set-up:  
 1.3-1.4mm

Application pressure:  
 1.8 bar at the air inlet  
 HVLP max 0.6-0.7 bar at the air cap

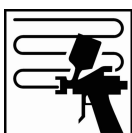


Apply 2-4 coats of the mid coat until desired color is achieved, flash-off between coats.



Flash off by increasing airflow until completely dry between each coat and 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 between coats with the exception of the mist into the final wet layer of the ground coat.
- Spot Repair application with Colorbuild Plus CBP013 Non Sanding – reduce RTS mixture 1:8 with Plus Reducer to reduce the overspray edge, apply one single layer over and beyond the Colorbuild Plus Non Sanding area.
- Before application of the ground coat and mid coat, it is important to pay particular attention to the spray gun fan pattern set-up. It is not advised to spray either coat with the fan pattern setting fully open as it possible to get an uneven spray pattern, ensure an even wet pattern from top to bottom of the fan pattern
- Application FA12:RR Ruby Red is applied in the same way as a Three Stage Pearl effect colour. For further information please refer to to Technical Bulletin Autowave 2.0 Three Stage Pearl application process.

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