

Autobase Plus MAZDA 46V Soul Red Crystal MM

FOR PROFESSIONAL USE ONLY

Definition and description

This color can be repaired by use of the color formulas of the Mazda 46V Groundcoat and Midcoat.



This step by step application instruction provides a simple method for obtaining an invisible repair.

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 of the midcoat applied. Distribute spray out panels according to the following matrix and apply the groundcoat in 3-4 coats till completely covered and apply a drop coat for optimal orientation. All coats should be completely dry before next coat is applied. Apply the midcoat in 2 to 5 closed coats. Each applied coat of the midcoat should be completely dry before the next coat is applied.

Create a set of sprayout panels as below:

3-4 coats Groundcoat Until hiding + Drop-coat				
	2 coats Midcoat	3 coats Midcoat	4 coats Midcoat	5 coats Midcoat

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.

NOTE: DON'T SPRAY PANELS SEPARATELY.

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Surface preparation



Colorbuild Plus (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

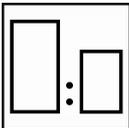
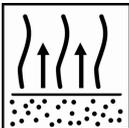
- *Initial sanding steps may be executed with a coarser sanding grit P600 - P800*
- *Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.*
- *For detailed surface preparation see TDS S8.06.02*



-Surface cleaning: remove contamination using an appropriate surface cleaner.

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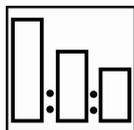
Groundcoat information	
	<p>100 parts by volume of Autobase Plus MM Groundcoat Mazda 46V 50 parts by volume of Plus Reducer</p>
	<p>Use Sikkens measuring stick 1 Black</p>
	<p>Spray gun set-up: 1.2 – 1.4mm</p> <p>Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap</p>
	<p>Apply 3-4 coats of the ground coat until completely covered, flash-off between each coat and apply a dropcoat.</p> <p>NOTE: For an optimal blend-edge a mini/compact gun with 1.2mm nozzle can be used</p>
	<p>Flash off by increasing airflow until completely dry between each coat. Dropcoat has to be flashed until completely dry before mid coat application.</p>



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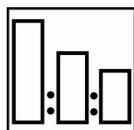
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Midcoat information



100 parts of Midcoat Color Enhancer LV (Q075) + Autobase Plus toner (90:10 (w/w))
 25 parts of Hardener P15 / P25 / P35
 35 parts of Plus Reducer

OR



100 parts of Autobase Plus RM Midcoat Mazda 46V
 25 parts of Hardener P15 / P25 / P35
 35 parts of Plus Reducer



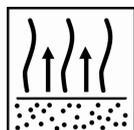
Spray gun set-up:
 1.3-1.4 mm

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



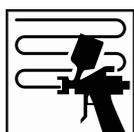
Apply 2-5 coats of the mid coat until desired color is achieved
 Flash-off between coats.

Note: Apply overlapping coats towards and over the Groud-coat, start 1st coat as wide as possible with the second and following coats within the previous coats until desired color is achieved.



Flash off until completely dry between each coat and allow to flash off for 20-30 minutes 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.

Notes



- Ensure that each coat is thoroughly flashed-off.
- Application Mazda 46V is the same as a Three Stage Pearl effect colour. For further information please refer to to Technical Bulletin Autobase Plus Three Stage Pearl application process.

Autobase Plus

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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.

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