



# Technical Bulletin

Paint code 589 and 590 Mercedes Basecoat Repair System

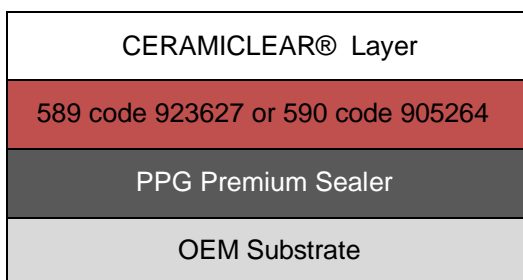
TCB-104

## PRODUCT DESCRIPTION:

This process has been developed to enhance the long term durability refinish repair of Mercedes paint codes 589 and 590 to meet the stringent OEM requirements for these colors. This repair process requires the use of a hardener in solvent basecoat, or adjuster and modifier in waterborne basecoat. Repair with careful preparation of the OEM finish with PPG Premium Primers, Primer Surfacer, Primer Sealers, and D8126 or DC4125 *CeramiClear*. The use of these products deliver excellent gloss and durability.

For all refinish repairs, follow the instructions according to the appropriate PPG Product Sheets.

This refinish repair consists of a basecoat clearcoat process. See illustration below.



## PREPARATION OF SUBSTRATE:

- For all repairs, wash surfaces to be refinished with soap and water and dry. Then clean with the appropriate PPG surface cleaner. Ensure that the substrate is thoroughly clean and dried before the application of any refinish materials.
- Repairs must be performed by selecting a correct system for the refinishing of basecoat /clearcoat, aluminum, steel, and plastic substrates.
- Abrade surfaces with the recommended grade paper according to the PPG product sheet for the system selected. Carefully abrade the repair area to the original primer to ensure that the original base color and clearcoat is removed. Abrade the surrounding area to stable paint layers, then finish abrading the clearcoat on the entire panel. Try to avoid abrading to bare metal or bare plastic. Thoroughly clean the surface before proceeding.
  - If abraded to bare metal, use an OEM approved PPG etch primer\* or epoxy primer system on the bare metal area, followed by an OEM approved PPG surfacer or sealer.
  - If abraded to bare plastic, use an OEM approved PPG Plastic Primer on the exposed plastic area followed by an OEM approved PPG surfacer or sealer.
  - For stable OEM paint or undercoat area on metal or plastic parts, it is sufficient to use only an OEM approved PPG surfacer or sealer.

- For all repairs, the PPG surfacer or sealer must be applied over the whole panel.
- Refer to the specific OEM approved product list for the recommended products and refer to all PPG product sheets for their specific use and instructions.

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\*Note : Do not apply basecoat systems directly over **2K** Etch Primers

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## BASECOAT PREPARATION:

- Solvent basecoat must be activated and reduced. Go to the **additives** section listed in the product sheet for the basecoat activator amount required.
- Waterborne basecoat must use adjuster, modifier, and thinner. Go to the **mix ratio** section listed in the product sheet, **solid color** for the adjuster, modifier, and thinner amount required.

**Note: For solvent basecoat choose reducer according to the application environment**

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## CLEARCOAT PREPARATION:

- Ceramiclear® must be activated according to the appropriate product sheets.

**Note: For best result, *CeramiClear* should be used for full panel repairs.**



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