

Process Data Sheet

March 2017

INTERNATIONAL MASTER
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I0635V

TCB103 - Aquabase Plus Mazda 46G Machine Grey Process P997-LA05 EMEA

<i>Product</i>	<i>Description</i>
Mazda 46G Machine Gray	Aquabase Plus Mixed Color
P990-8948	Aquabase Plus Deep Black Tinter
P990-8999	Aquabase Plus Clear Adjuster
P997-LA05	Aquabase Plus Liquid Aluminium 2

Process Description

Mazda 46G Machine Gray is a special effect colour and requires a specific application process as outlined below.



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PROCESS

1. REPAIR AND PREPARATION OF SUBSTRATE

- 1.1 The damaged body work of the vehicle should be repaired using a Nexa Autocolor repair and undercoating system for the substrate of the body panels being repaired (Aluminium, Steel, Plastic etc.)
- 1.2 Sealing the repair with a SG07 Spectral Grey WOW Primer shade as a first step is recommended followed by P990-8948 Deep Black tinter as a groundcoat colour over repaired areas used in Step 2 of the process.

2. GROUNDCOAT AND PREPARATION OF SUBSTRATE

- 2.1 When preparing the substrate as recommended below, suitable colour panels should be prepared alongside for use when checking the colour/effect of the basecoats OEM color variation can differ.
- 2.2 For the Mazda 46G Machine Gray Aquabase Plus colour process, P990-8948 tinter thinned 20% is applied prior to the topcoat colour.
When using the 46G Aquabase Plus mixed colour thinned 20%, full coverage must be achieved.
This also needs to be applied to the SG07 colour panels when being prepared for the colour check process.
- 2.3 If only part of a body panel is repaired and primed, SG07 WOW primer should be applied over the sanded/primed repair areas first. This should be followed by using Spot Blender or Aerosol Spot Blender, applied and blended on SG07 edges.
This should be followed by P990-8948 Deep Black tinter applied over complete SG07 WOW areas.
- 2.4 Where blending of the basecoat will occur as part of the repair, the area of the panel from the basecoat blend to the edge of the panel should be finished with P1000 Abralon damp using a 150MM orbital sander.
1 wet coat of P990-8999 Clear Adjuster should be applied to the blend area as per normal blending process.

PROCESS

3. AQUABASE PLUS 46G MACHINE GRAY APPLICATION

- 3.1 Due to possible variation of the colour of a particular vehicle, it is essential that a colour check panel is prepared using the colour panels prepared as in Section 2 and using the basecoat application process recommended in this section (3).
- 3.2 Apply 1 wet coat of P990-8999 thinned 20% over to the prepared Blend area for smooth lay down.
- 3.3 Mix P990-8948 Deep Black at 20% thinner.
 - Ensure P990-8948 is applied 1 wet double coat to seal repair and enhance laydown of 46G colour
- 3.4 Thin mixed 46G Aquabase Plus colour at 20% with P980-5000 thinner
 - Ensure 46G mixed colour is thoroughly stirred prior to thinning and after
- 3.5 Apply 46G as by normal TDS recommendation. 2 single coat ensure best patchiness control. Flash off until matt.
- 3.6 Apply Control coat (double coat can be done in case of patchiness) from a distance of about 20-30cm from panel and evenly applied @ 1.3-1.5 bar with material 1 ¼ turns open from closed position and the fan fully open or “Half Trigger” with no turns.
Care should be taken to apply this final basecoat layer very lightly and evenly Flash off until matt
- 3.7 Minor defects maybe denibbed with 3000 abralon **in between** coats and Tack ragged
- 3.8 Flash off for 15 - 20 minutes until completely matt before applying Clearcoat.
- 3.9 To blend the basecoat, apply the first double coat to the primed area, then extend each subsequent coat a little further into the blend area each time using normal blending techniques to achieve an even blend into the original colour.
As with full panel application care should be taken apply this final basecoat blended edge very lightly and evenly without over wetting of the basecoat.

PROCESS

4. CLEARCOAT APPLICATION

- 4.1 Clearcoat with an approved NEXA Autocolor Clearcoat.
- 4.2 The first coat of clearcoat must be applied as a light mist coat.
Avoid wetting this first coat too much, over application can move the basecoat leading to patchiness.
- 4.3 Apply second coat of clear as recommended for the appropriate NEXA Autocolor Clearcoat.
- 4.4 Bake as indicated in TDS for the clear.
- 4.5 Polish as necessary to achieve finish required.

NOTES

- 1- P800 followed by P1000 abralon damp with 150mm orbital sander to prepare blend areas.
Do not hand sand afterwards.
- 2- Apply SG07 WOW Primer on all new panels and blend over any correctly prepared and sanded areas including sanded primer areas.
Where WOW edges may exist around primer patches apply Aerosol Blending thinner over the top to smooth the edges.
- 3- Use P990-8999 thinned 20% blending into adjacent panels. This will assist with the polished metal look required.
- 4- Use P990-8948 Deep Black thinned 20% over repaired areas. This will assist with the polished metal look and assist with the OEM process plus help control mottle
- 5- Thin 46G 20% with P980-5000 thinner.
- 6- Use a recommended spraygun setup for waterbaoned basecoat the best mottle control and colour accuracy.
- 7- Basecoat may be de-nibbed with Abralon 3000 dry once it is flashed off.
- 8- Humidity may play part in the wetting of the basecoat however, this may slightly stay wetter longer



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