

Process Data Sheet

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INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY



10630V

Mercedes Alubeam 047 Application Process Aquabase Plus

<i>Product</i>	<i>Description</i>
P997-LA05	Liquid Aluminium 2
P998-xxxx	Aquabase Plus Mixing Basics
P998-8991	Aquabase Plus Tone Controller
P980-5000	Aquabase Plus Thinner

Process Description



Mercedes Alubeam (047) is a special effect silver colour which gives a “Liquid Metal” appearance.

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 Finishing the repair with a SG7 Spectral Grey Primer shade is recommended as a groundcoat colour used in Step 2 of the process. A standard Nexa Autocolor 2K clearcoat layer can be applied directly to the SG7 undercoat (after sanding if required).

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 basecoat.
- 2.2 For the Mercedes Alubeam (047), a SG7 groundcoat colour is used with standard 2K clearcoat applied over. When using the Aquabase Plus Mercedes Alubeam (047), full coverage/opacity is achieved to give the best results. The SG7 shade gives the best guide as to when full coverage is achieved.
- 2.3 If only part of a body panel is repaired and primed, the clearcoat should be applied over the entire panel.
- 2.4 The clearcoat is fully dried following the recommendations from the appropriate tds, then sanded with P1200 dry to remove orange peel to result in a completely flat surface.
- 2.5 The area to be painted, then needs to be finished with P1000 Trizact (or equivalent), wet, or finer to minimize any scratches from the removal of the orange peel.
- 2.6 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 P3000 Trizact (or equivalent), wet.

PROCESS

3. AQUABASE PLUS ALUBEAM 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.
- 3.2 Mix Mercedes Alubeam 047 (from colour IT) using Aquabase Plus Liquid Aluminium 2 Tinter P997-LA05 and Aquabase Plus Mixing Basics, P998-xxxx.
- 3.3 Thin 50% with P980-5000 (2 / 1).
- 3.4 Spraygun used Sata 1.0 - 1.1 HVLP (@ 2 bar)
- 3.5 Apply 1st double cross coat @ 2 bar with gun 1 ¼ - 1 ½ turns open and flash off until matt (using air blower).
- 3.6 Apply 2nd double cross coat @ 2 bar with gun 1 ¼ - 1 ½ turns open and flash off until matt (using air blower).
- 3.7 If the metallic control appears even and free from patches at this stage, proceed to step 3.8, otherwise repeat Step 3.6.
- 3.8 1 double / triple mist coat @ 2 bar with gun ¾ turns open and flash off until matt (using air blower).
- 3.9 Care should be taken to apply this final basecoat layer very dry and even without any “wetting up” of the basecoat.
- 3.10 Flash off before clearcoat 20 - 30 minutes and if possible run through Fast Aquadry or similar cycle.
- 3.11 To blend the basecoat, apply the first double cross coat to the primed area, then extend each subsequent coat a little further into the blend area 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 dry and even without any “wetting up” of the basecoat.

PROCESS

4. CLEARCOAT APPLICATION

- 4.1 Clearcoat with a Nexa Autocolor Scratch Resistant 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 Leave to flash off 10 - 15 minutes, then apply 1 full coat (additional ½ coat applied immediately after the full coat may be required on horizontal surfaces).
- 4.4 Bake as indicated in TDS for the clear.
- 4.5 If necessary, to achieve the smoothest final finish sand with P1200 or finer (dry) and then re-apply the Scratch Resistant Clearcoat.
- 4.6 Polish as necessary to achieve finish required.

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

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