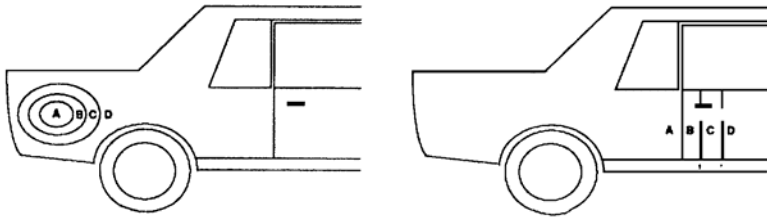


SPOT REPAIRS WITH BASECOAT SB

DESCRIPTION:

The term spot repair is understood to include all repairs to damaged areas resulting in the repaired area blending invisibly into the still intact existing finish. As a result, the car refinisher is not compelled to spray large panels in the case of minor damage. The spot repair technique also enables minor differences in color and effect between the original car finish and the refinish to be made invisible.

PREPARATION:



Clean all areas: first degrease with Lesonal Wax and Grease Remover or VOC compliant surface cleaner.

In the above drawings, area "A" is the area under repair. Shape it and build up the area using the appropriate products. After the appropriate products have dried, sand the area under repair "A" as well as the adjacent area "B".



Sand areas "A" and "B" with waterproof #P600 to #P800 grit paper. Thoroughly scour areas "C" and "D" (whole panel) with a grey scuff pad, Lesonal Plastoblend and water, or alternately prepare areas "C" and "D" with a good quality DA sander using a 3M interface pad and #P1000 grit sanding disk.



If blending of the clearcoat is inevitable (sail panels), apply Lesonal Plastoblend on a sponge, and scour until gloss is removed. Thoroughly clean with water or alternately, lightly scuff with the 3M Clear Blend Prep scuff pad #07745 (gold) and degrease with a compliant Lesonal surface cleaner.

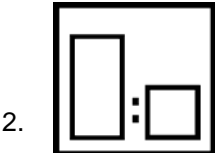
APPLICATION BASECOAT SB:



Contains acrylic resins and other ingredients.




Use the Lesonal Measuring Stick #4.

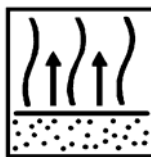


2:1
 Lesonal SB Basecoat
 Lesonal Reducer

SPOT REPAIRS WITH BASECOAT SB

For Basecoat SB solid colors:

4.  3X1
HVLP Siphon
0.071"–0.087" (1.8–2.2 mm)
HVLP Gravity
0.051"–0.059" (1.3–1.5 mm)
Max 10 psi (max 0.8 bar)

5.  2–5 minutes at 70°F (20°C)

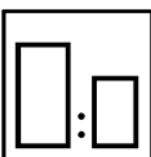
Application Method:

Spray single coats of Basecoat SB in areas A & B until opacity is achieved.

Allow 2–5 minutes flash off time between coats. Tack off between coats. Fade out each coat into area C, with succeeding coats extending slightly beyond the previous one.

BLENDING BASECOAT SB SOLID AND METALLIC COLORS:

Prior to applying the fade out coats, add to 3 parts ready to spray (RTS) Basecoat SB, 1 part of Basecoat SB Blending Additive (3-1) or add 10% Lesonal Reducer Medium by volume (use the centimeter side of measuring stick). This will make the color transparent, facilitating a more uniform blend with the original color.

6.  3:1
Basecoat SB color;
(Ready to spray)
Basecoat SB Blending Additive
(Measuring stick #9)

Mix as follows:


3 parts by volume Basecoat SB Ready to Spray
1 part by volume Basecoat SB Blending Additive

OR


1:10%
Basecoat SB color;
(Ready to spray)
Lesonal Reducer Medium
(any stick centimeter side)

Mix as follows:

1 part by volume Basecoat SB Ready to Spray
10% by volume Lesonal Reducer Medium

7.  1–2x1
HVLP Siphon
0.071"–0.087" (1.8–2.2 mm)
HVLP Gravity
0.051"–0.059" (1.3–1.5 mm)
Max 10 psi (max 0.8 bar)


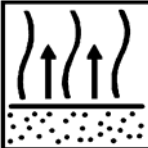



With this transparent color, spray 1 to 2 thin coats. Extending beyond the repair area, gradually fading out into area "C".

8.  15–20 minutes at 70°F (20°C)

Allow 15–20 minutes at 70°F (20°C) before final tack and applying the clearcoat.

SPOT REPAIRS WITH BASECOAT SB

For Basecoat SB Metallic Colors:

- | | | | |
|----|---|--|--|
| 4. |  | 3x1 HVLP Siphon 0.071"–0.087" (1.8–2.2 mm) HVLP Gravity 0.051"–0.059" (1.3–1.5 mm) Max 10 psi (max 0.8 bar) | Application Method: Spray 1 medium coat of Basecoat SB metallic in areas A and B. After 2–5 minutes flash off, spray the same area under repair until opacity is achieved (2–3 medium coats). Flash between coats. |
| 5. |  | 2–5 minutes at 70°F (20°C) | |
| 6. |  | 1–2x1 HVLP Equipment 8 psi High Pressure Equipment 30 psi | Due to the hiding power of Basecoat SB, establish color control and metallic orientation during your first and second coat to avoid additional coats and material waste. Lowering the air pressure is not necessary with HVLP; however, it may be done for color control. Fade out using metallic orientation coats into areas C and D extending well into these areas. |
| 7. |  | 15–20 minutes at 70°F (20°C) | |
| 8. |  | Apply clearcoat. | NOTE: The best color control is usually achieved by adjusting the air pressure and gun distance. Remove dry overspray from areas C and D with a tack rag between each coat. Allow 15–20 minutes at 70°F (20°C) before final tack and applying the clearcoat. |

NOTE: Fade out by extending application into areas C and D. After each application, remove dry overspray with a tack cloth.

NOTE: Basecoat SB is sufficiently dry to clearcoat after 15–20 minutes at 70°F (20°C). Tack the entire repair area.

ALTERNATE PROCESS USING BASECOAT SB BLENDING ADDITIVE AS A CLEAR FOUNDATION:





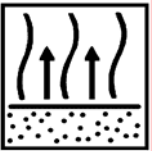

It is also possible, prior to applying Basecoat SB basecoat and fading out, to spray 1 single coat of Basecoat SB Blending Additive. Flash off 3–5 minutes, and then follow directions on application of basecoat.

Using Basecoat SB Blending Additive as a clear foundation and spraying metallic orientation coats of the Basecoat SB metallic into this clearcoat will result in an easier blend as far as color, flip tone and effect are concerned

SPOT REPAIRS WITH BASECOAT SB

APPLICATION OF CLEARCOAT:

For this example, we have chosen Lesonal Universal Clear.

1.  Contains acrylic resins and other ingredients. When mixed, also contains isocyanates.
2.  3:1:1
 Lesonal Universal Clear
 Lesonal Clear Hardener
 Lesonal Clear Fast Activator
3.  Use the Lesonal Measuring Stick #9.
4.  2x1
 HVLP Siphon
 0.071"–0.087" (1.8–2.2 mm)
 HVLP Gravity
 0.051"–0.059" (1.3–1.5 mm)
 Max 10 psi (max 0.8 bar)
5.  5 minutes at 70°F (20°C)
6.  5 hours at 70°F (20°C)
 20 minutes at 140°F (60°C)

Application Method:
 Spray 2 single coats of Lesonal Universal Clear, the last coat over entire panel.
 Allow 3 minutes flash time after each coat.




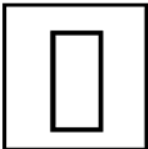


Limit the application of coats right next to an adjacent panel, provided there are 2 coats of Lesonal Universal Clear over the Basecoat SB spot repair.

SPOT REPAIRS WITH BASECOAT SB

BLENDING OF CLEARCOAT:

Akzo Nobel Coatings/Lesonal strongly recommends the application of clear coat over the whole panel that is thoroughly prepared. There are, however, instances where this is not practical. Such as repairs on older vehicles where economics would dictate that a lifetime guarantee is not required. In these instances, it may be acceptable to blend the clear coat into a small area such as a rocker panel or sail panel, vertical areas only.

For Lesonal Universal Clear: If other clearcoats are used, these procedures should also be used.

- | | | | |
|----|---|--|---|
| 1. |  | <p>2:1 Lesonal Universal Clear, ready to spray Lesonal Blending Solvent or Medium Reducer</p> | <p>Application Method, when blending of the clear is inevitable. After the last coat of clear is sprayed, add to the ready to spray clear 50 parts by volume Lesonal Blending Solvent or Medium Reducer.</p> |
| 2. |  | <p>Use the Sikkens Measuring Stick #4.</p> | |
| 3. |  | <p>1 x 1 HVLP Siphon 0.071"–0.087" (1.8–2.2 mm) HVLP Gravity 0.051"–0.059" (1.3–1.5 mm) Max 10 psi (max 0.8 bar)</p> | <p>Fade out the last coat into the prepared area (sail panel) keeping a sharp blend line.</p> |
| 4. |  | <p>Lesonal Blending Solvent or Lesonal Medium Reducer</p> | <p>Use pure Lesonal Blending Solvent or Medium Reducer to dissolve overspray edge.</p> |
| 5. |  | <p>2 x 1 HVLP Max 10 psi (max 0.8 bar) Conventional 20–30 psi (1.3–2.0 bar)</p> | <p>Spray 1 medium coat. Flash for 15 seconds Apply a final thin coat.</p> |
| 6. |  | <p>15 seconds at 70°F (20°C)</p> | |



SPOT REPAIRS WITH BASECOAT SB

**AFTER
TREATMENT:**

After the repair is completely dry, the fade out area (if any) may be polished with an ultra-fine polishing compound and waxed. (Please see *Dry-To-Polish* time of the products used.)

NOTE:

Refer to the following Technical Data Sheets for more information:

- Basecoat SB Solid and Metallic Colors
- Basecoat SB Blending Additive
- Lesonal Universal Clear

Other Lesonal clearcoats may be used. Refer to the appropriate TDS.

SAFETY DATA:

**READY TO
SPRAY VOC:**

Lesonal SB 2:1

6.6 lb/gal

794 g/liter

NOTICE:

Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.