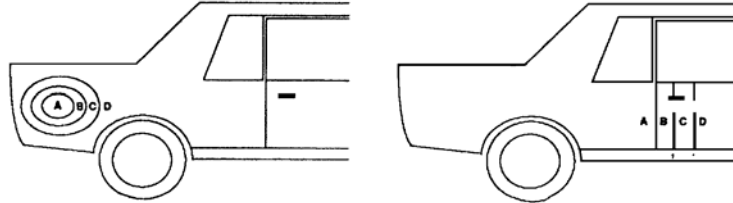


SPOT REPAIRS WITH BASECOAT SB — THREE STEP PROCESS

DEFINITION: A three step pearl color consists of 3 layers.
1st step – the foundation color (solid color).
2nd step – the Lesonal SB mica color (a very transparent pearl effect).
3rd step – the clearcoat (to provide gloss and protection).

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 repair 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 products have dried, sand the area under repair "A" as well as the adjacent area "B". When spot repairs are made, wet sanding by hand is preferred.



1.

Sand areas "A" and "B" with waterproof #P600 to #P800 grit paper wet. Thoroughly scuff 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.




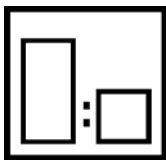
2.

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

SPOT REPAIRS WITH BASECOAT SB — THREE STEP PROCESS


APPLICATION OF BASECOAT SB (THE FOUNDATION COLOR):


1.  Contains acrylic resins and other ingredients.

2.  2:1
Lesonal Basecoat SB
Lesonal Reducer

Mixing Ratio:


2 parts by volume Basecoat SB
1 parts by volume Lesonal Reducer
Fast or Medium

3.  Use the Lesonal Measuring Stick #4.

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)

Application Method:

Spray single coats of Basecoat SB in area "A", extending slightly beyond previous coats until opacity is achieved.

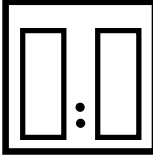

5.  2–5 minutes at 70°F (20°C)

Flash 2–5 minutes and tack between each coat.

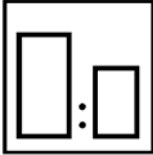

SPOT REPAIRS WITH BASECOAT SB — THREE STEP PROCESS

BLENDING THE FOUNDATION COLOR:



Prior to applying the fade out coats, mix the ready to spray Basecoat SB foundation color 1:1 with ready to spray Basecoat SB Pearl Color. This will make the foundation color transparent, facilitating a more uniform blend with the foundation color.

6.  1:1
Basecoat SB Foundation
Color, ready to spray
Basecoat SB Pearl Color
ready to spray
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)
- Add the reduced Basecoat SB Pearl Color to the ready to spray Basecoat SB foundation color, ratio 1:1.
- With this transparent foundation color, spray 1 to 2 thin coats. Extending beyond the repair area, gradually fading out into area "C". Allow for flash-off between coats.

OPTIONAL FADEOUT

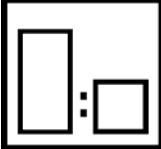


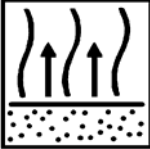


- A.  3:1
Basecoat SB Mix Color
Basecoat SB Blending
Additive
- B.  1x1
HVLP Siphon
0.071"–0.087" (1.8–2.2 mm)
HVLP Gravity
0.051"–0.059" (1.3–1.5 mm)
Max 10 psi (max 0.8 bar)
- For final blending, add to this mix, 33 parts by volume Basecoat SB Blending Additive. Use Lesonal mixing stick #9.
- Spray a final fade out coat only in area "C".

APPLICATION CONTINUED:

8.  15–20 minutes at 70°F (20°C)
9.  Apply Basecoat SB Pearl Color.
- Allow the foundation color to dry for 15–20 minutes before applying the pearl coat color.
- Note: It is very important that this foundation color is as invisible as possible before proceeding with the Basecoat SB pearl coat color.

SPOT REPAIRS WITH BASECOAT SB — THREE STEP PROCESS

APPLICATION OF BASECOAT SB (PEARL COLOR):

1.  2:1
Lesonal Basecoat SB
Lesonal Reducer Medium
2.  Use the Lesonal
Measuring Stick #4.
3.  3–4x1
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)
4.  2–5 minutes at 70°F (20°C)
5.  15–20 minutes at 70°F (20°C)
6.  Apply clearcoat

Mixing Ratio:

2 parts by volume Basecoat SB
Pearl Color
1 parts by volume Basecoat SB
Reducer, Medium

Application Method:

Spray 3–4 even, thin coats of pearl. Alternate the spraying area with each coat. Start application well within foundation color, then wider, then within foundation color, wider, etc. The last coats should extend well from the foundation color, fading into area "D".

NOTE: Do not spray a drop coat.

NOTE:

Do not add extra reducer to the Basecoat SB Pearl Color. Fade out as described above. After each application, remove dry overspray with a tack rag.

SPOT REPAIRS WITH BASECOAT SB — THREE STEP PROCESS

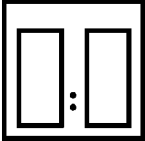
APPLICATION OF BASECOAT SB THREE-STEP

METALLIC COLORS: As the application of 3-step metallic colors is very similar to that of a 3-step pearl color spot repair, we will not repeat every aspect of the process but will highlight the major differences of the process.


Mix the metallic foundation color 2 parts by volume to 1 part by volume of Lesonal Reducer.

BLENDING THE FOUNDATION COLOR:

Apply single coats in area A until opacity is achieved. Extend each coat slightly beyond the previous one. (Do not make any attempt at fade-out yet.)

1.  1:1
Basecoat SB Foundation Color, Ready to Spray
Basecoat SB Mid-Coat Color, Ready to Spray

2.  2x1

3.  15–20 minutes at 70°F (20°C)

Mixing Ratio:

Reduce the mid-coat color 2 parts color to 1 part Lesonal Reducer. Add this ready-to-spray mid-coat color to the ready-to-spray foundation color at a ratio of one to one.

Application Method:

With this “tinted” transparent foundation color, spray 2 medium coats. Extend beyond the first coats of foundation color, gradually fading out into area C.

Allow this tinted foundation color to dry to 15-20 minutes before applying the (red) mid-coat color.

APPLICATION OF BASECOAT SB (MID COAT):

1.  3–4x1

2.  Apply clearcoat

Mix the mid-coat color 2:1 and apply 3–4 medium wet coats, allowing a flash-off time of 5–10 minutes between coats. Do not overlap in the same areas.

Allow the Basecoat SB mid-coat color to flash/dry for 15-20 minutes before applying clearcoat.

SPOT REPAIRS WITH BASECOAT SB — THREE STEP PROCESS

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

It is also possible, prior to repairing Basecoat SB (three-stage process), to spray 1 single coat of Lesonal Basecoat SB Blending Additive. Flash off for 3–5 minutes, and then follow directions on “Spot Repairs with Basecoat SB–Three Stage Process”.


Using Lesonal Basecoat SB Blending Additive as a clear foundation coat for fade-out areas will result in an easier blend as far as color, flip tone and effect are concerned.

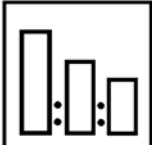
APPLICATION OF CLEARCOAT:

Basecoat SB is sufficiently dry to clearcoat after 15-20 minutes at 70°F (20°C). Tack the entire repair area and clearcoat with Lesonal Universal Clear or Lesonal LV Clear.

Note: Use clearcoat appropriate to your VOC regulations. Refer to Lesonal Universal Clear or Lesonal LV Clear technical data sheets.


Example, Lesonal Universal Clear:


1.  Contains acrylic resins. When mixed, Lesonal Universal Clear also contains isocyanates.

2.  3:1:1
Lesonal Universal Clear
Lesonal Clear Hardener
Lesonal Clear Fast Activator

Mixing Ratio:

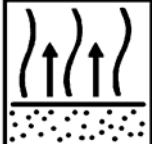
3 parts by volume Lesonal Universal Clear
1 part by volume Lesonal Clear Hardener
1 part by volume Lesonal Clear Fast Activator


3.  Use the Measuring Stick #9.

4.  2–3x1
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 2 to 3 single coats of Lesonal Universal Clear, the last coat over entire panel. Allow 5 minutes flash time after each coat. Limit the application of coats right next to an adjacent panel.

5.  5 minutes at 70°F (20°C)

6.  5 hours at 70°F (20°C)
20 minutes at 140°F (60°C)




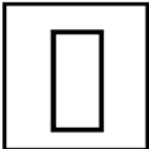

SPOT REPAIRS WITH BASECOAT SB — THREE STEP PROCESS

BLENDING OF CLEARCOAT:

Akzo Nobel Coatings/Lesonal strongly recommends the application of clear coat over the whole panel that is thoroughly prepared. Clearcoating of entire panel is required for lifetime warranty.

There are, however, instances where this is not practical. Such as repairs on older vehicles where economics would dictate that a warranty is not required. In these instances, it may be acceptable to blend the clearcoat into a small area such as a rocker panel or sail panel, vertical areas only.

For Lesonal Universal Clear: Procedures listed below should also be used for Lesonal LV Clear. Refer to your local VOC regulations for "Specialty Coating" compliance.

- | | | | |
|----|---|--|--|
| 1. |  | <p>2:1
Lesonal Universal Clear,
ready to spray
Lesonal Blending Solvent or
Reducer Medium</p> | <p>Application Method:
When blending of the clear is inevitable. After the last coat of clear is sprayed, add 50 parts by volume of Lesonal Blending Solvent or Reducer Medium.</p> |
| 2. |  | <p>Use the Lesonal Measuring Stick # 4.</p> | |
| 3. |  | <p>1x1
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>Hard line the last coat of clear into the prepared area (sail panel), keeping a sharp blend line.</p> |
| 4. |  | <p>Lesonal Blending Solvent or Reducer Medium</p> | <p>Use pure Lesonal Blending Solvent or Reducer Medium to dissolve overspray edge.</p> |
| 5. |  | <p>2x1
HVLP 10 psi (max 0.8 bar)
Conventional 20–30 psi
(1.3–2.0 bar)</p> | <p>Spray 1 thin coat.
Flash for 15 seconds.
Apply a final thin coat.</p> |



SPOT REPAIRS WITH BASECOAT SB — THREE STEP PROCESS

**AFTER
TREATMENT:**

After the repair area 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:

Please refer to the following Technical Data Sheets for more information.
—Basecoat SB Solid, Metallic and Pearl Colors
—Basecoat SB Blending Additive
—Lesonal Universal Clear
—Lesonal LV Clear

SAFETY ASPECTS:

**READY TO
SPRAY VOC:**

Basecoat SB 2:1	6.6 lb/gal	792g/liter
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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.