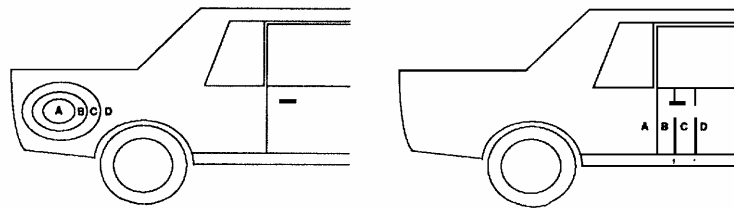


SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

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


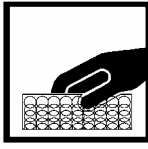
DESCRIPTION: The term spot repair is understood to include all repairs to damaged areas resulting in the repaired area blending invisibly into the still intact existing finish. As a result, the car refinisher is not compelled to spray large panels in the case of minor damage. The spot repair technique 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 M600 Surface Cleaner. In areas where VOC emission regulations apply, use recommended compliant Sikkens Surface Cleaner.


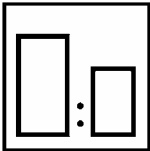
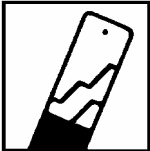

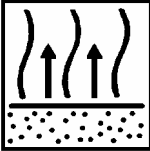
In the above drawings, area “A” is the area under repair. Shape it and build up the area using the appropriate products. After the products have dried, sand the area under repair “A” as well as the adjacent area “B”. When spot repairs are made, wet sanding by hand is preferred.

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, Sikkens Blend-Prep 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 Sikkens Blend-Prep 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 Sikkens Surface Cleaner.



SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

APPLICATION OF AUTOBASE PLUS (THE FOUNDATION COLOR):

1.  Contains acrylic resins and other ingredients.
2.  100:50
Autobase Plus (foundation)
Autobase Plus Reducer
3.  Use the Measuring Stick #1 (Black)
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.  3–5 minutes at 70°F (20°C)

Mixing Ratio:

100 parts by volume Autobase Plus
50 parts by volume Autobase Plus
Reducer Fast or Medium

Application Method:

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

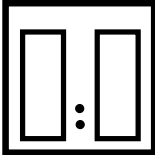

Flash 3–5 minutes and tack between each coat.



SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

BLENDING THE FOUNDATION COLOR:

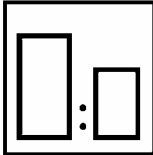

Prior to applying the fade out coats, add to the ready to spray color 100 parts by volume reduced Autobase Plus Pearl Color using the 1 to 1 mixture of Autobase Plus Solid Color with Autobase Plus Pearl Color. This will make the foundation color transparent, facilitating a more uniform blend with the foundation color.

6.  100:100
Autobase Plus
FoundationColor,
ready to spray
Autobase Plus 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 Autobase Plus Pearl Color to the ready to spray Autobase Plus foundation color, ratio 100:100.

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.

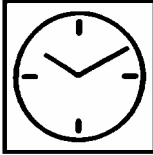

OPTIONAL FADEOUT

- A.  100:50
Autobase Plus Mix
Autobase Plus Blending
Additive
- B.  1x1

For final blending, add to this mix, 50 parts by volume Autobase Plus Blending Additive.

Spray a final fade out coat only in area "C".

APPLICATION CONTINUED:

8.  15–20 minutes at 70°F (20°C)
9.  Apply Autobase Plus Pearl Color.

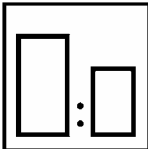
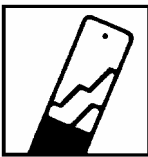

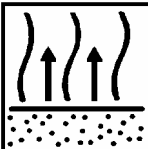


Allow the foundation color to dry for 15–20 minutes before applying the pearl coat color.

Note: It is very important that this foundation color is as invisible as possible before proceeding with the Autobase Plus pearl coat color.



SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

APPLICATION OF AUTOBASE PLUS (PEARL COLOR):

1.  100:50
Autobase Plus Pearl Color
Autobase Plus Reducer
Medium
2.  Use the Sikkens
Measuring Stick #1 (Black).
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.  2–3 minutes at 70°F (20°C)
5.  15–20 minutes at 70°F (20°C)
6.  Apply Autoclear II LV

Mixing Ratio:

100 parts by volume Autobase Plus
Pearl Color
50 parts by volume Autobase Plus
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 Autobase Plus Pearl Color. Fade out as described above. After each application, remove dry overspray with a tack rag.



SPOT REPAIRS WITH AUTOBASE® PLUS — THREE STEP PROCESS

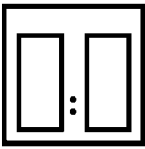
APPLICATION OF AUTOBASE PLUS THREE-STEP

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 100 parts by volume to 50 parts by volume of Autobase Plus 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.  100:100
Autobase Plus Foundation Color, Ready to Spray
Autobase Plus Mid-Coat Color, Ready to Spray


Mixing Ratio:

Reduce the mid-coat color 100 parts color to 50 parts Autobase Plus Reducer. Add this ready-to-spray mid-coat color to the ready-to-spray foundation color at a ratio of one to one.

2.  2x1

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.

3.  15–20 minutes at 70°F (20°C)

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

APPLICATION OF AUTOBASE PLUS (MID COAT):

1.  3–4x1

Mix the mid-coat color 100:50 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.

2.  Apply Autoclear II LV

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



SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

ALTERNATE PROCESS USING AUTOBASE PLUS BLENDING ADDITIVE AS A CLEAR FOUNDATION:

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


Using Autobase Plus 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:

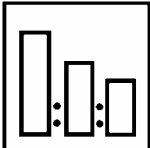
Autobase Plus is sufficiently dry to clearcoat after 15-20 minutes at 70°F (20°C). Tack the entire repair area and clearcoat with Autoclear II LV.

Note: Use clearcoat appropriate to your VOC regulations. Refer to Autoclear II LV technical data sheets.

Example, Autoclear II LV:

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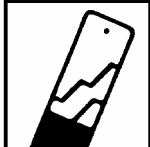
Contains acrylic resins.
When mixed, Autoclear II LV also contains isocyanates.

- 


100:50:30
Autoclear II LV
Autoclear II LV Hardener
Autoclear II LV Reducer

Mixing Ratio:

100 parts by volume Autoclear II LV
50 parts by volume Autoclear II LV Hardener
30 parts by volume Autoclear II LV Reducer

- 

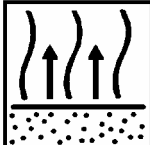
Use the Measuring Stick #1 (Black).

- 


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 Autoclear II LV, 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.

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5 minutes at 70°F (20°C)

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10 hours at 70°F (20°C)
30 minutes at 140°F (60°C)

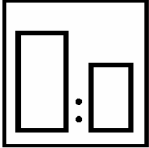


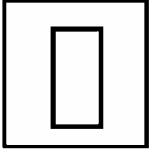

SPOT REPAIRS WITH AUTOBASE[®] PLUS — THREE STEP PROCESS

BLENDING OF CLEARCOAT:

Akzo Nobel Coatings/Sikkens 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. This procedure is not warranted or OE approved.

For Autoclear II LV: Refer to your local VOC regulations for "Specialty Coating" compliance.

- | | | | |
|----|-------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1. |  | <p>100:50
Autoclear II LV, ready to spray
Reducer SRA 7.0</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 Reducer SRA 7.0.</p> |
| 2. |  | <p>Use the Sikkens Measuring Stick # 1 (black).</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>Reducer SRA 7.0
Ready to spray</p> | <p>Use pure Reducer SRA 7.0 to dissolve overspray edge.</p> |
| 5. |  | <p>2x1
HVLP 10 psi (max 0.8 bar)
Conv. 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 AUTOBASE[®] PLUS — 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.
—Autobase Plus Solid, Metallic and Pearl Colors
—Autobase Plus Blending Additive
—Sikkens Reducer SRA 7.0
—Autoclear II LV

SAFETY ASPECTS:

**READY TO
SPRAY VOC:**

Autobase Plus 100:50	6.5 lb/gal	780 g/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.