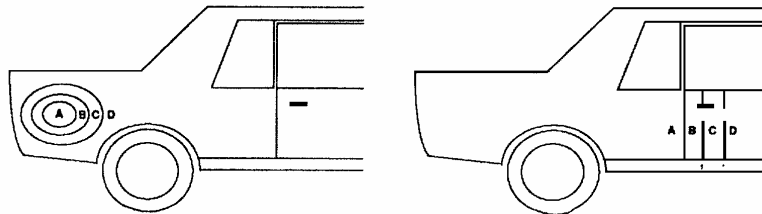


SPOT REPAIRS WITH AUTOBASE[®] PLUS

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:



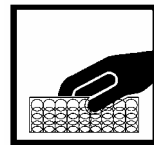
Clean all areas: first degrease with M600 Surface Cleaner. In areas where VOC emission regulations apply, use recommended compliant Sikkens Surface Cleaner.

In the above drawings, area "A" is the area under repair. Shape it and build up the area using the appropriate products. After the appropriate 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.

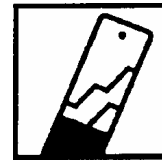
If blending of the clearcoat is inevitable (sail panels), apply Sikkens Blend-Prep on a damp sponge, and scuff until gloss is removed or alternately prepare (sail panels) by lightly scuffing with a 3M Clear Blend Prep Pad #07745 (gold). Thoroughly clean areas with a compliant Sikkens Surface Cleaner.

APPLICATION OF AUTOBASE PLUS (BASECOAT):



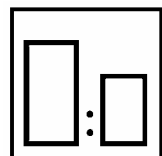
1.

Contains acrylic resins and other ingredients.



3.

Use the Sikkens Measuring Stick #1 (Black).




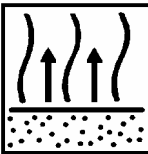
2.

100:50
Autobase Plus
Autobase Plus Reducer
Fast or Medium

SPOT REPAIRS WITH AUTOBASE® PLUS

For Autobase Plus solid colors:

4.  2X1
HVLV Siphon
0.071"–0.087" (1.8–2.2 mm)
HVLV 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)

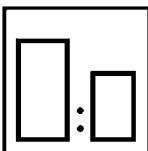
Application Method:

Spray single coats of Autobase Plus in areas A & B until opacity is achieved. Extend each coat slightly beyond the previous one. Flash between coats.

It is acceptable to accelerate flash by blowing air (at a 45° angle) on the spot repair with the spray gun. Tack off between coats.


SOLID COLOR FADEOUT:

Prior to applying the fade out coats, add to the ready to spray color, 50 parts by volume Reducer SRA 7.0. This will make the color transparent, facilitating a more uniform blend with the original color.


6.  100:50
Autobase Plus Color,
Ready to Spray
Reducer SRA 7.0

Mix as follows:

100 parts by volume Autobase Plus
Ready to Spray
50 parts by volume Reducer SRA 7.0

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

With this transparent color, spray 1 thin coat, extending beyond the repair area. Fading out into area "C".

8.  15–20 minutes at 70°F (20°C)


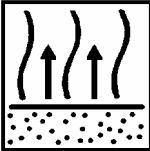



Allow 15–20 minutes at 70°F (20°C) before final tack and applying the clearcoat.

9.  Apply Autoclear II LV



SPOT REPAIRS WITH AUTOBASE® PLUS

METALLIC COLOR FADE OUT:

- | | | | |
|----|---|--|---|
| 4. |  | 2x1
HVL P Siphon
0.071"–0.087" (1.8–2.2 mm)
HVL P Gravity
0.051"–0.059" (1.3–1.5 mm)
Max 10 psi (max 0.8 bar) | Application Method: Spray 1 medium coat of Autobase Plus Metallic in areas A and B. After 3–5 minutes flash off, spray the same area under repair until opacity is achieved. Flash between coats. |
| 5. |  | 3–5 minutes at 70°F (20°C) | |
| 6. |  | 1–2x1 | Lower air pressure, extend distance and fade out into areas "C" and "D", extending well into these areas. Lowering the air pressure is not necessary with HVL P. However, it may be done for color control. |
| 7. |  | 15–20 minutes at 70°F (20°C) | NOTE: The best color control is usually achieved by adjusting the air pressure and gun distance. Tack off between coats. |
| 8. |  | Apply Autoclear II LV | Allow 15–20 minutes at 70°F (20°C) before final tack and applying the clearcoat. |

NOTE: Do not add extra Reducer. Fade out by extending application into areas C and D. After each application, remove dry overspray with a Sikkens 1•2•3 Tack Cloth.

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

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

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




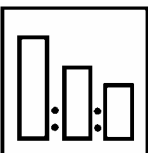
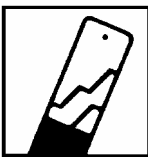

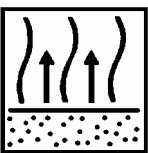
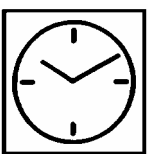
SPOT REPAIRS WITH AUTOBASE[®] PLUS

APPLICATION OF CLEARCOAT:

Autobase Plus is sufficiently dry to clear coat 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

1.  Contains acrylic resins and other ingredients. When mixed, also contains isocyanates.
2.  100:50:30
Autoclear II LV
Autoclear II LV Hardener
Autoclear II LV Reducer
3.  Use the Sikkens Measuring Stick #1 (Black).
4.  2x1
HVLV Siphon
0.071"–0.087" (1.8–2.2 mm)
HVLV 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.  10 hours at 70°F (20°C)
30 minutes at 140°F (60°C)

Application Method:

Spray 2 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.

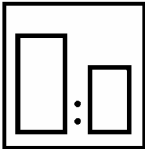
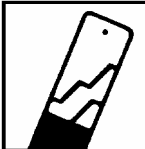

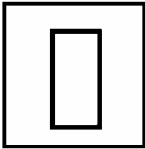

SPOT REPAIRS WITH AUTOBASE® PLUS

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 clear coat into small areas 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. |  | 100:50
Autoclear II LV, ready to spray
Reducer SRA 7.0 | Application Method , when blending of the clear is inevitable. After the last coat of clear is sprayed, add 50 parts by volume Reducer SRA 7.0. |
| 2. |  | Use the Sikkens Measuring Stick # 1 (black). | |
| 3. |  | 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) | Hard line the last coat into the prepared area (sail panel), keeping a sharp blend line. |
| 4. |  | Reducer SRA 7.0
Ready to Spray | Use pure Reducer SRA 7.0 to dissolve overspray edge. |
| 5. |  | 2 x 1
HVLP
Max 10 psi (max 0.8 bar)
Conventional 20–30 psi
(1.3–2.0 bar) | Spray 1 thin coat.
Flash for 15 seconds
Apply a final thin coat. |



SPOT REPAIRS WITH AUTOBASE[®] PLUS

**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:

- Autobase Plus Solid, Metallic and Pearl Colors
- Autobase Plus Blending Additive
- Reducer SRA 7.0
- Autoclear II LV

SAFETY DATA:

**READY TO
SPRAY VOC:**

Autobase Plus 100:50

6.5 lb/gal 780 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.