

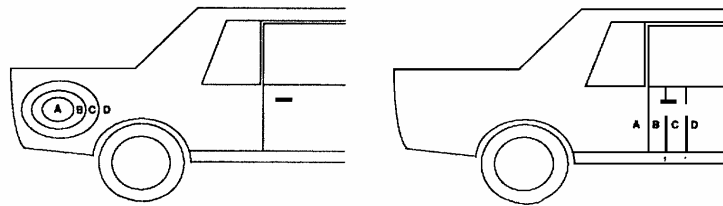


SPOT REPAIRS WITH AUTOCOAT® LV

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 may not be 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 a VOC compliant cleaner/degreaser.

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. Sand areas "A" and "B" with waterproof #P600 followed by #P800 grit paper wet.

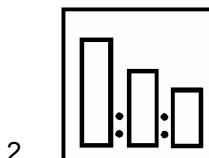


Thoroughly compound areas "C" and "D" (whole panel) with a medium grade compound. Clean and degrease all areas with a VOC compliant cleaner/degreaser.

APPLICATION OF AUTOCOAT LV:



Contains acrylic resins, methyl amyl ketone, xylene and other ingredients.
When mixed, Autocoat LV also contains isocyanates.



100:50:25
Autocoat LV
Autocoat LV Hardener
Standard or Slow
Autocoat LV Reducer



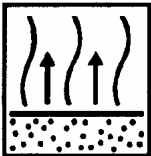
Mixing Ratio:

100 parts by volume Autocoat LV
50 parts by volume Autocoat LV Hardener
Standard or Slow
25 parts by volume Autocoat LV Reducer or
Autocoat LV Accelerator

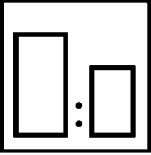
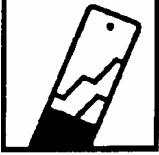

Application Method: Spray single coats in areas "A" and "B" until opacity is achieved. Allow 5–10 minutes flash-off time between coats. Fade out each coat into area "C", with each succeeding coat extending slightly beyond the previous one. After each application, remove dry overspray carefully from areas "C" and "D" with a Sikkens 1•2•3 Tack Cloth.

SPOT REPAIRS WITH AUTOCOAT® LV

APPLICATION OF AUTOCOAT LV (Continued):

3.  Use the Sikkens Measuring Stick #11 (Blue).
4.  2x1
HVLP – Siphon
HVLP 0.071"–0.087" (1.8–2.2 mm)
HVLP – Gravity
0.051"–0.059" (1.3–1.5 mm)
Max 10 psi (0.8 bar)
5.  5–10 minutes at 70°F (20°C)

BLENDING AUTOCOAT LV: (SPECIALTY COATING CATEGORY)

1.  100:50
Autocoat LV, ready to spray
Sikkens Reducer SRA 7.0
(This is now a specialty coating.)
2.  Use the Sikkens Measuring Stick.
3.  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 (0.8 bar)

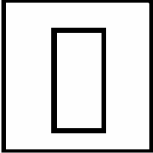


Application Method:

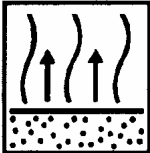
Add to the ready to spray paint, 50 parts by volume Sikkens Reducer SRA 7.0. Extend the application fading out into area "D".



SPOT REPAIRS WITH AUTOCOAT® LV

BLENDING AUTOCOAT LV (SPECIALTY COATING CATEGORY) — CONTINUED:

4.  Sikkens Reducer SRA 7.0
ready to spray
5.  Apply pure Reducer SRA 7.0
6.  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 (0.8 bar)

Use pure Sikkens Reducer SRA 7.0 to
dissolve overspray edge.
Spray 1 thin wet coat.
If necessary, flash for 15 seconds.
Apply final thin wet coat.
7.  15 seconds at 70°F (20°C)
between coats of Reducer SRA 7.0.

AFTER TREATMENT:

For Autocoat LV: after the repair is completely dry, the fade out may be polished with an ultra-fine polishing compound and waxed. (Please see dry-to-polish time of Autocoat LV.)

SPOT REPAIRS WITH AUTOCOAT® LV

ALTERNATE PROCESS #1: (CLEAR COATING WITH AUTOCLEAR II LV SPECIALTY COATING CATEGORY)



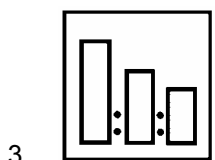
Preparation:

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, Sikkens Blend-Prep and water. Thoroughly clean with water then clean with a compliant Sikkens cleaner. 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), restore gloss and color with a medium grade compound.

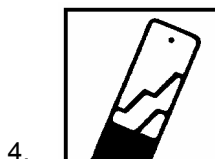


Cleaner/Degreaser

Thoroughly clean all areas with a VOC compliant cleaner/degreaser.



100 Autocoat LV
50 Autocoat LV Hardener Standard
25 Autocoat LV Accelerator

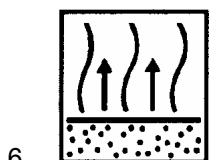


Use the Sikkens Measuring Stick #11 (Blue).

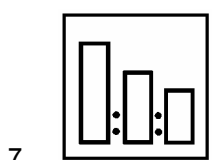


Application method:

Refer to the above data for application and fade out to Autocoat LV color and fade out. **DO NOT APPLY SIKKENS REDUCER SRA 7.0.**



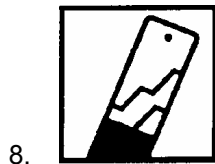
5 minutes at 70°F (20°C)



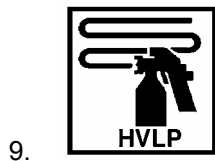
100:50:50
Autoclear II LV
Autoclear II LV Hardener
Autoclear II LV Reducer

SPOT REPAIRS WITH AUTOCOAT[®] LV

ALTERNATE PROCESS #1: (CLEAR COATING WITH AUTOCLEAR II LV SPECIALTY COATING CATEGORY) — CONTINUED:



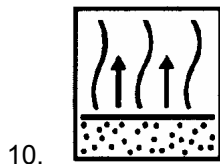
Use the Sikkens Measuring Stick #2 (Blue).



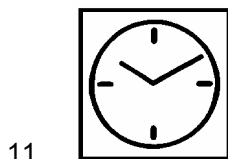
2–3x1
HVL P Siphon
0.071"–0.087" (1.8–2.2 mm)
HVL P Gravity
0.051"–0.059" (1.3–1.5 mm)
Max 10 psi (0.8 bar)

With this over reduced Autoclear II LV, first spray a thin coat only on fade out area "D". Flash for 3–5 minutes. Apply one or two single coats fo the same mixture of Autoclear II LV over the whole panel. If this is not possible, dissolve overspray edge with pure Sikkens Reducer SRA 7.0.

In this case, the preparation for the overspray edge should be done with a medium grade compound.



3–5 minutes at 70°F (20°C)



Allow appropriate dry time.

NOTE:

Where possible, this clearcoat should be sprayed over the whole panel. When fading out, as described, the fade-out area should be prepared with a medium grade compound.



SPOT REPAIRS WITH AUTOCOAT[®] LV

SAFETY ASPECTS:

READY TO

SPRAY VOC:

Autocoat LV (100:50:25):	3.5 lb/gal	420 g/liter
Mixed Autocoat LV (A) with Sikkens Reducer SRA 7.0 (100:50):	4.6 lb/gal	560 g/liter
Autocoat LV (100:50:25) with Autocoat LV Accelerator:	3.2 lb/gal	385 g/liter
Sikkens Reducer SRA 7.0 (100):	7.0 lb/gal	840 g/liter
Autoclear II LV (100:50:50):	2.1 lb/gal	250 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.