

# WB Tri Stage Exclusive Colors

Technical Bulletin

09/11/2019

L8.01.05 UK &amp; Ireland

## DESCRIPTION

Repair system for the following Tri-stage colors which are based on the new MM3060 toner :

- FA12:RR
- FA12:R3
- MAZ46V
- LEX3T5
- HON9880
- HON9881
- HON9885
- GMA15:G1E
- GMA15:GPJ

The above colours consist of different layers creating a special effect:

Basecoat WB GT Basecoat Groundcoat color

Basecoat WB GT MM3060 Midcoat color

Clearcoat

**NOTE: TDS does not apply for colors which are formulated based on MM02.**

## COLOR CHECK

**Groundcoat** Apply groundcoat till completely covered and apply mist coat for optimal orientation. All coats should be completely dry before next coat is applied.  
Groundcoat is applied as standard Basecoat WB GT.

**Midcoat** Correct color match needs to be determined by producing a number of color spray-out samples. The color depends on the number of coats applied of the midcoat.  
Distribute spray out panels according to the following matrix.

**Note:**

This matrix is an indication of the number of midcoats:

Always complete sufficient sprayout samples to determine the colour accuracy.

The application will vary depending on temperature, humidity and applicator and therefore could have an influence on the number of midcoat layers.

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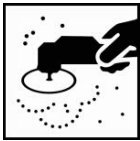
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Midcoat	Advised Grey Shade	1 coat	2 coats	3 coats	4 coats	5 coats
FA12:RR			✓			
FA12:R3	G	✓				
MAZ46V						✓
LEX3T5	W/G		✓			
HON9880	G/B		✓			
HON9881					✓	
HON9885			✓			
GMA15:G1E	G	✓				
GMA17:GPJ	G	✓				

## PREPARATION

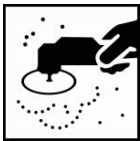
### Primer area



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS L8.06.02

### Basecoat blend area



Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P600 - P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02
- **Do NOT use Basecoat WB GT MM02/MM04 as pre-coat;** it will change the depth of the OE color.
- Clear midcoat can be used as a pre coat; it has to be dried completely before application of groundcoat color.

### Surface cleaning



Remove contamination using an appropriate surface cleaner.

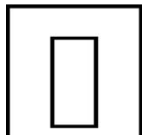
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## GROUNDCOAT APPLICATION

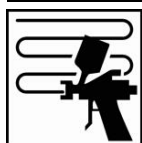


Ready For Use (RFU)



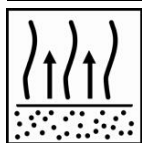
Spray gun set-up :  
1.3 –1.4 mm

Application pressure:  
1.8 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



Apply Groundcoat until completely covered

Flashing-off in between each coat



Flash off by increasing airflow until completely dry between each coat.

Drop coat has to be flashed off until completely dry before Midcoat application.

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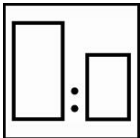
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## MIDCOAT APPLICATION



**Important!**

Please use mixed paint within the same day

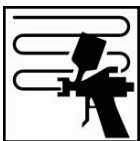


100 Parts of midcoat  
10-20 Parts of Activator WB

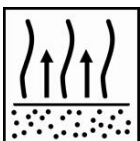


Spray gun set-up :  
1.3 –1.4 mm

Application pressure:  
1.8 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



Apply the number of midcoat layers until the desired color is achieved.  
Flash off until completely matt after each coat  
Use the matrix as an indication for the number of layers required.



Flash off by increasing airflow until completely dry between each coat.  
Drop coat must be flashed off until completely dry before clearcoat application.

## CLEARCOAT



See clearcoat TDS



Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

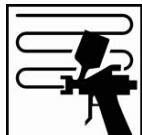
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## NOTES

**Ensure that each coat is thoroughly flashed-off.**

Application of a Tri-Stage Exclusive color is the same as a Three Stage Pearl effect color.

For further information please refer to Technical Bulletin Basecoat WB Three Stage Pearl application process.

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