

Basecoat WB MAZ46G Machine Grey

Technical Bulletin

09/11/2019

L8.07.06b UK & Ireland

DESCRIPTION

Machine Grey 46G is one of Mazda's state of the art finishes to compliment Kodo design using its Takuminuri paint technology.

The repair of this color is based on the standard 2 stage TDS application with an additional 2-3 overthinned basecoat layers to achieve its specific fine effect and finish of this color.

Mazda's description of this color:

"This color gives the impression that the vehicle's body has been sculpted from a solid steel ingot"

COLOR CHECK

Correct color match needs to be done by producing a number of color spray-out samples.

Prepare a set of 4 spray out panels applied with a black filler sanded with a minimum of P1000 grit and position them side by side.

1. Apply Basecoat WB GT MAZ46G according to TDS L1.09.02 (including mist coat) to all panels.
Remove and store one panel marked as **number 1**.
2. Add 200% of Activator WB to the Basecoat WB GT MAZ46G color.
Apply this mixture at increased distance as a standard mist coat to the remaining 3 panels.
Remove one panel and mark it as **number 2**
3. Again, apply this mixture at increased distance as a standard mist coat to the remaining 2 panels.
Remove one panel and mark it as **number 3**
4. Apply this mixture at increased distance as a standard mist coat to the remaining panel.
Mark this panel as **number 4**

Note: Ensure to use the same application technique on the vehicle!

After the final mist coat leave the basecoat to flash off completely, or cure for 10 minutes at 60°C and leave to cool down before applying the clearcoat

Complete the sprayout collection as painting the repair / vehicle

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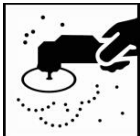
SURFACE PREPARATION



Black Filler area

Final sanding step P500

Initial sanding steps may be executed with a coarser sanding grit (P320 – P400)



Preparation blending area WB GT 02 or 02/04

Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit (P600-P800)



Surface cleaning

Remove any surface contamination using an appropriate surface cleaner

BASECOAT WB GT PRECOAT / WET BED



100

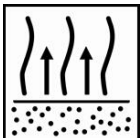
Basecoat WB GT 02 or WB GT 02:04 (mixing ratio 60:40)

10

Activator WB



Apply one flowing coat the entire area under repair.



Flash-off by increasing airflow and or heat until completely dry.

If necessary, allow the surface to cool down

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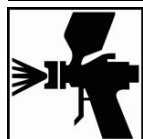
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BASECOAT WB GT MAZ 46G



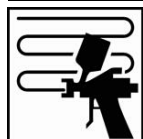
100 Basecoat WB GT MAZ 46G
10 Activator WB



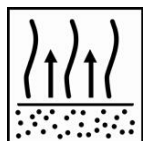
Spray gun set-up:
1.3 mm

Application pressure:

1.7 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



2 x 1 + mist coat



Allow to flash-off until completely matt and dry.




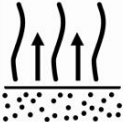


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BASECOAT WB GT MAZ 46G EFFECT COATS

	<p>100 Basecoat WB GT MAZ 46G 200 Activator WB</p>
	<p>Spray gun set-up: 1.3 mm</p> <p>Application pressure: 1.7 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap</p>
	<p>Application effect layers* 1-3 mist coats*</p> <p>*Increase distance, apply coats in even layers *Due to the low viscosity, shake spray gun prior to application of the next coat</p>
	<p>Between coats: Until completely matt and dry</p> <p>Before clearcoat: Bake for 10 minutes at 60°C.</p>
	<p>Clearcoat application See clearcoat T.D.S.</p> <p>With the application of the clearcoat, apply a thin closed 1st layer</p>
	<p>Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.</p>

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