

Basecoat WB NISKAB Ultimate Metal Silver

Technical Bulletin

09/11/2019

L8.07.06 UK & Ireland

DESCRIPTION

The repair system for NIS KAB Ultimate Metal Silver consists of three different layers creating a special color effect, based on

1st step: Application of 2K Graphite Filler Light Grey foundation color.

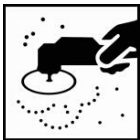
2nd step: Application of Basecoat WB O2 followed by the Basecoat WB effect color.

3rd step: Application of the clearcoat to provide gloss and protection.

PREPARATION

Repair with recommended body fillers and / or undercoats, preferably 2K Graphite Filler Light Grey

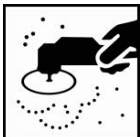
SURFACE PREPARATION



Filler area

Final sanding step P500

Initial sanding steps may be executed with a coarser sanding grit (P360 – P400)



Preparation blending area WB GT O2 toner

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

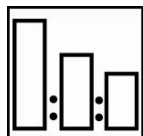
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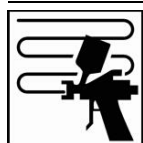
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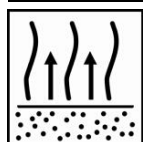
2K GRAPHITE FILLER FOUNDATION COLOR



3	Lesonal 2K Graphite Filler as ADV (+ 30% Flexible Additive)
1	Lesonal Universal Hardener
0.6	Lesonal Multi Thinner Fast / Standard

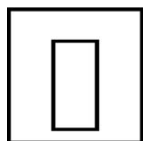


Apply 2K Graphite Filler to the area under repair until opacity is achieved

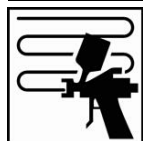


Allow each coat to flash-off naturally until the surface is completely matt.

Do not force-dry by air support.

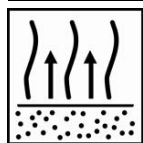


For blending of the foundation color use Fade Out Agent



Dissolve the overspray edge with Fade Out Agent.

Note: Make sure the edge is as smooth as possible!



Allow each coat to flash-off naturally until the surface is completely matt.

Do not force-dry by air support.

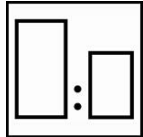
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BASECOAT WB GT EFFECT COLOR



100 Basecoat WB GT 02 (Pre-Foundation Layer)
10-20 Activator WB



Spray gun set-up:

1.3 mm

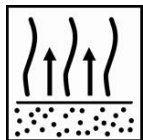
Application pressure:

1.7 bar at the air inlet

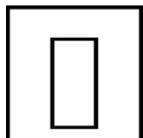
HVLP max 0.6-0.7 bar at the air cap



Apply one coat of Basecoat WB GT 02 to the entire area under repair.



Flash-off by increasing airflow and or heat until completely dry.
If necessary, allow the surface to cool down



RFU Basecoat WB GT NIS KAB Ultimate Metal Silver



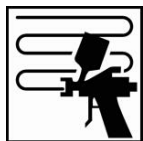
Spray gun set-up:

1.3 mm

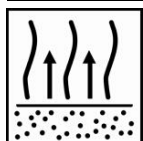
Application pressure:

1.7 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



Apply a 25% layer of Basecoat WB GT NIS KAB slightly extending the filler area and allow to dry.
Next, apply five 75% layers to achieve opacity. Make sure each layer exceeds the previous one. After each layer take sufficient flash off into account.
Finish with a 25% layer.



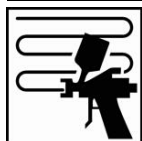
Allow for a minimum of 20-30 minutes final flash-off time at 20°C.

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Apply 2K HS Premium Clear according to TDS



Use suitable respiratory protection

Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Akzo Nobel Coatings LTD

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